### MODEL 600 - FIELD SERVICE MANUAL

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The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



This SERVICE MANUAL supplement includes a brief design function, recommended method of disassembly, and assembly of each part. Any necessary adjustment or care in assembly is included. A final section on malfunctions and a complete index of gun parts completes the supplement. Close-up line drawings as well as a complete sectional view serve to illustrate text.

The Instruction Folder/Parts List, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

<u>Precaution:</u> Make sure no live cartridges remain in gun before cleaning, servicing, or shipping.

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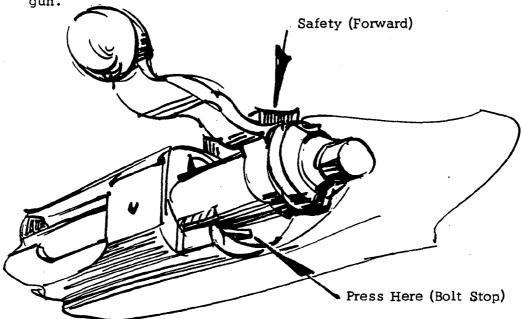
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

<u>To Disassemble</u> - Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. See sketch below. This will release bolt. Withdraw bolt final assembly from gun.



- <u>To Service</u> The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.
- <u>To Reassemble (To Gun)</u> Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.
  - Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

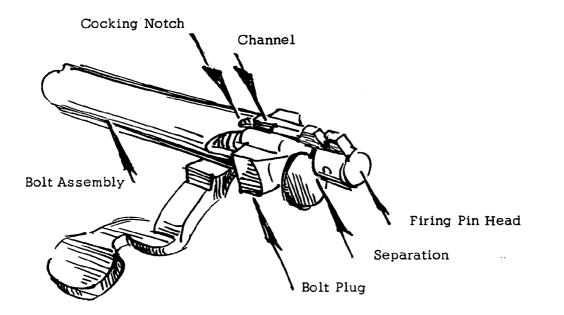
MODEL 600 Assembly 2

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BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

- <u>To Disassemble</u> Remove boit final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (see sketch below). Then turn bolt plug to unscrew firing pin assembly from bolt assembly.
- <u>To Service</u> Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.
- <u>To Reassemble</u> Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



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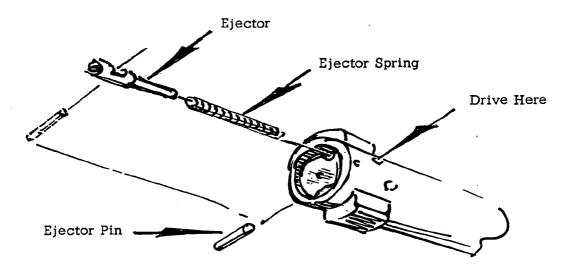
#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

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EJECTOR - EJECTOR SPRING (in Bolt Assembly) - is designed to exert outward pressure against base of seated cartridge. After extraction, the ejector pushes cartridge away from bolt face. The opposing grip of the extractor then assists ejection by spinning cartridge from gun.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. See sketch below.



To Service - Interchangeable with no adjustment required.

<u>To Reassemble</u> - Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

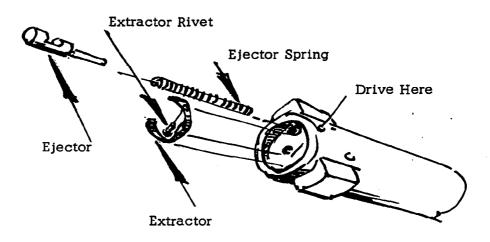
MODEL 600 Assembly 4

#### REMINGTON FIELD SERVICE MANUAL

#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly) - is designed to pull cartridge from chamber. During subsequent ejection, a spinning motion is imparted to cartridge by extractor.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet - from outside of bolt. See sketch below. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.



- <u>To Service</u> Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge case to check extractor tension.
- <u>To Reassemble</u> Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then - peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

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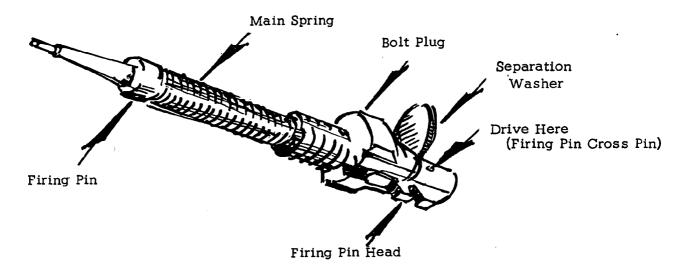
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#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

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- FIRING PIN ASSEMBLY COMPONENTS include: Firing Pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly)
- <u>To Disassemble</u> Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.

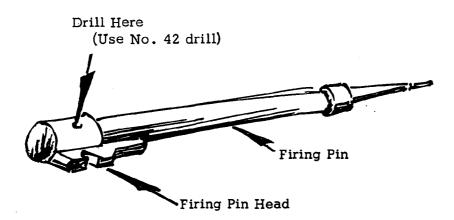


<u>To Service</u> - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill

#### FIRING PIN ASSEMBLY - COMPONENTS Continued

thru cross pin hole in firing pin head. Drill thru firing pin shank. See sketch below.



<u>To Reassemble</u> - Reassemble all parts of FIRING PIN ASSEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug. (

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FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

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- <u>To Disassemble</u> Unscrew <u>sight screw</u> (2). A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble front sight assembly from rib on barrel.
- <u>To Service</u> Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.
- <u>To Reassemble</u> Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

REAR SIGHT ASSEMBLY - includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage Screw.

- <u>To Disassemble</u> Unscrew <u>sight screw</u> (2) in rear sight base. A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.
- <u>To Service</u> All parts of rear sight assembly are interchangeable. No factory fitting required.
  - Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.
- <u>To Reassemble</u> Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

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#### REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE

ELEVATION SCREW - is designed to tighten position of rear sight eyepiece at any selected elevation.

<u>To Disassemble</u> - A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW - is designed to tighten rear sight leaf at any selected windage position on base.

<u>To Disassemble</u> - Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

<u>To Service</u> - All parts are interchangeable. No factory fitting required.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

<u>To Reassemble</u> - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

<u>To Disassemble</u> - Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small <u>rear sight nut</u> will also disassemble from beneath the rearmost rear sight hole.

To Service - Rib is interchangeable with no adjustment required.

<u>To Reassemble</u> - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

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TRIGGER GUARD - is designed of light weight Du Pont "Zytel" material to enclose trigger, magazine, and mount front and rear guard screws for assembling stock to receiver.

<u>To Disassemble</u> - Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Service - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain both front and rear guard screws are tightened <u>evenly</u> and securely to receiver.

STOCK ASSEMBLY - is designed with Monte Carlo, pistol grip, and custom checkered at grip and fore end, lacquer finished.

- <u>To Disassemble</u> Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.
- <u>To Service</u> Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw (2). Barrel is free floating.

To <u>Reassemble</u> - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

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BUTT PLATE BUTT PLATE SCREW (2)

- <u>To Disassemble</u> Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.
- <u>To Service</u> Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

<u>To Disassemble</u> - Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

MAGAZINE FOLLOWER -MAGAZINE SPRING - are designed to feed cartridges from magazine into loading position as bolt is operated.

<u>To Disassemble</u> - Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screw.

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MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

<u>To Disassemble</u> - Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY - in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

<u>To Disassemble</u> - Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Sectional View.

<u>To Service</u> - Interchangeable as replacement assembly. Safety assembly is a factory-welded assembly of safety and corrugated safety thumbpiece. All other parts designed to operate and position safety assembly (as listed in preceding paragraph) are interchangeable as replacements also. No adjustment required.

<u>To Reassemble</u> - Follow reverse order.

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TRIGGER ASSEMBLY - is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

<u>To Disassemble</u> - Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver. See Sectional View.

<u>To Service</u> - Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

<u>To Reassemble</u> - Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY - COMPONENTS - See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY - is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of springloaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

<u>To Disassemble</u> - Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring. See Sectional View.

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- <u>To Service</u> Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.
- <u>To Reassemble</u> Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage <u>flat end</u> of sear spring upwards against sear and safety cam. <u>Closed end</u> of sear spring seats into housing.

TRIGGER & TRIGGER CONNECTOR - are designed to support sear in "cocked" engagement with firing pin head. As trigger is pulled, trigger connector is disengaged from lower shoulder on sear. Unsupported sear then is forced down by forward motion of firing pin. Hence, gun is "fired".

- <u>To Disassemble</u> Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.
  - Note: Care must be taken to prevent dislodging trigger spring.
- <u>To Service</u> Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.
- <u>To Reassemble</u> Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

- <u>To Disassemble</u> Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.
- <u>To Service</u> Trigger housing interchangeable as replacement. No factory assembly required.

<u>To Reassemble</u> - Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - See Sketch below. Remove stock assembly and trigger guard.

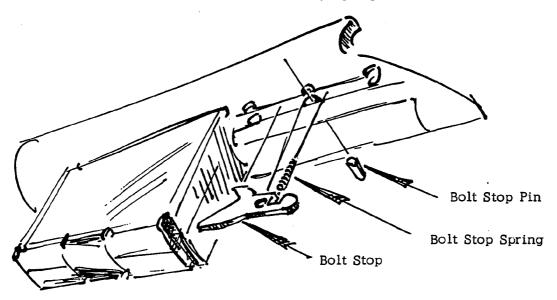
Engagement View Hole Sear Spring Stop Screw Adjusting Screw Trigger Pin Trigger Spring

- IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).
- Note: All adjusting (2) and stop (1) screws are factory sealed with an adhesive cement.
- <u>Pull of Trigger</u> is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.
- <u>Travel of Trigger</u> is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin <u>will not fall</u> or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin <u>will</u> <u>fall</u> or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

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BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

<u>To Disassemble</u> - Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. See sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



<u>To Service</u> - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure bolt stop spring located properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver. MODEL 600 Assembly 16

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BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

- <u>To Disassemble</u> Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).
- <u>To Service</u> Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

<u>To Reassemble</u> - Follow reverse order.

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SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) - include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quick-detachable (Q.D.) type.

#### Assembly - Swivel Screws to Stock

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<u>Rear Swivel Screw</u> - Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

#### <u>Assembly - Swivel Assembly (2) Q.D.</u>

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin.



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw. MODEL 600 Assembly 18

#### REMINGTON FIELD SERVICE MANUAL

#### SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE Continued

#### <u>Assembly - Strap to Assembled Swivels</u>

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. Then insert strap thru front swiyel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

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Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

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Instructions for loading, unloading, assembly, disassembly and care are contained in instruction folder (RD 5473) supplied with each Carbine. Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION

<u>Malfunction</u>	<u>Caus</u>	se	Corr	rection
Firing		Firing pin damaged. Firing pin binds.	1. 2.	Replace. Free up or replace.
		Firing pin protrusion faulty.	3.	
		Trigger assembly out of adjustment.		Adjust.
	5.	Faulty ammunition.	5.	Replace ammunition.
Unlocking	1.	See Extraction.	1.	See Extraction.
<b>,</b>	2.	Upset extraction cam on bolt handle.	2.	Smooth up bolt handle cam.
		Burr at ejector hole in bolt.		Deburr.
		Blown or set back primer on shell.		Ammunition may be at fault.
Extraction	1.	Fouled, rough, or enlarged chamber.	1.	Polish if fouled or rough. Replace barrel assembly if enlarged.
	2.	Extractor broken or damaged.	2.	Fit new extractor and rivet.
		Not enough hook space on extractor.		Fit new extractor and rivet.
		Height of claw not correct.		Fit new extractor and rivet.

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<b>Malfunction</b>	Cause	Correction
Bolt Binds	<ol> <li>Guard screws protrude into bolt track.</li> <li>Receiver plug screws protrude into</li> </ol>	<ol> <li>File ends of screws.</li> <li>File ends of screws.</li> </ol>
	bolt track. 3. Bolt handle interferes in stock. 4. Damage at rear of bolt lugs.	<ol> <li>Clear stock or fit new stock.</li> <li>Stone to blend. Check head space.</li> </ol>
Ejection	<ol> <li>Burr at ejector hole in bolt.</li> <li>Ejector binds or fails to retract far</li> </ol>	<ol> <li>Deburr.</li> <li>Free up or replace.</li> </ol>
	enough. 3. Extractor binds.	3. Adjust or fit new extractor (and rivet).
Bolt Pulls Out	<ol> <li>Bolt stop or bolt release binds.</li> <li>Bolt stop or bolt release broken.</li> <li>Bolt stop spring damaged.</li> </ol>	<ol> <li>Free up.</li> <li>Replace.</li> <li>Replace.</li> </ol>
Feeding	<ol> <li>Magazine follower binds.</li> <li>Weak or defective follower spring.</li> <li>Magazine spring caught under guard.</li> <li>Damaged chamfer on bolt head.</li> <li>Tabs on follower bent.</li> </ol>	<ol> <li>Adjust side angle on magazine.</li> <li>Replace spring.</li> <li>Correct.</li> <li>Replace bolt, or stone smooth.</li> <li>Straighten or replace follower.</li> </ol>
Loading	<ol> <li>Damaged receiver rails.</li> <li>Sharp edge - rear end of chamber.</li> <li>Rough loading ramp in receiver.</li> </ol>	<ol> <li>Polish or reshape.</li> <li>Remove sharpness.</li> <li>Polish ramp.</li> </ol>

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cau</u>	se	<u>Co</u>	rrection
Locking	1. 2. 3. 4.	Shallow throat. Min. head space. Damaged chamber. Extractor interferes with shell rim.	1. 2. 3. 4.	Ream. Re-head. Re-head. Fit new extractor (grind relief
	5.	Ejector binds or fails to retract far enough.	5.	in new extractor behind claw). Free up or replace.
	6. 7.	Burr at ejector hole in bolt. Sharp corners in bolt lugs.	6. 7.	Deburr. Stone radius.
Cocking (see Trigger Adjustment)	1.	Trigger adjusting screw at rear out of adjustment (improper horizontal engagement of sear and connector).	1.	Adjust.
	2.	Improper vertical engagement of sear and connector.	2.	Fit new trigger assembly.
	3. 4.	Trigger doesn't retract. Corners on sear or connector rounded.	3. 4.	Fit new trigger assembly. Fit new sear and safety cam or connector.
Bulges or	1.	Oversize chamber.	1.	Replace barrel assembly.
Blows Cases	2.	Max. head space.	2.	Fit new bolt.
Safety	1.	Safe binds (safe works hard).	1.	
	2.	Safety snap washer stretched out (safe works too freely).	2.	Replace washer or reseat in safety pivot pin slot.
	3.	Safety damaged.	3.	Replace safety.

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### MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

2.

Tighten or change sights.

<u>Malfunction</u>	Cause	Correction
Accuracy		
- Group Size	<ol> <li>Crown of barrel damaged.</li> <li>Barrel bore fouled.</li> <li>Enlarged bore.</li> <li>Improper bedding of barrel in stock.</li> <li>Loose sights.</li> </ol>	<ol> <li>Recrown.</li> <li>Lead or replace barrel.</li> <li>Replace barrel.</li> <li>Refloat barrel.</li> <li>Tighten or replace.</li> </ol>
- Point of	1. Barrel not straight.	1. Straighten or replace barrel.

SERVICE MANUAL **REMINGTON** FIELD

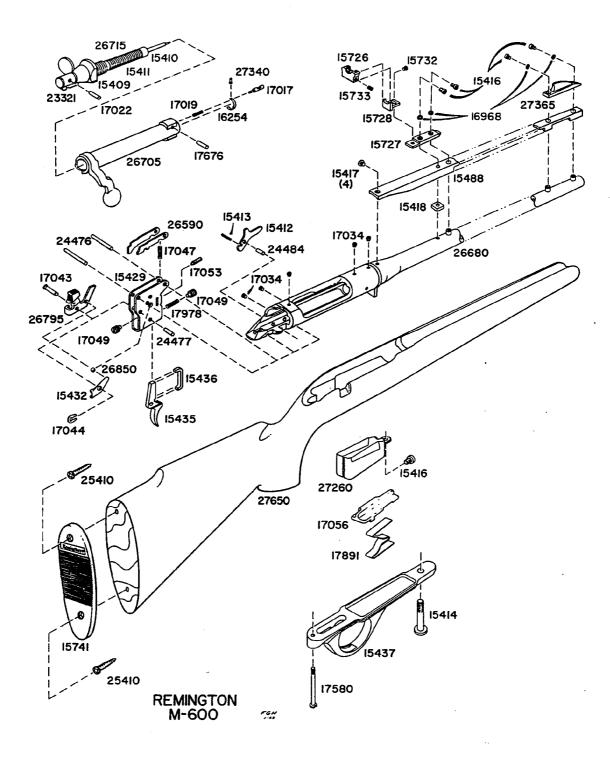
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2. Improper or loose sights.

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The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



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This SERVICE MANUAL supplement includes a brief design function, recommended method of disassembly, and assembly of each part. Any necessary adjustment or care in assembly is included. A final section on malfunctions and a complete index of gun parts completes the supplement. Close-up line drawings as well as a complete sectional view serve to illustrate text.

The Instruction Folder/Parts List, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

<u>Precaution:</u> Make sure no live cartridges remain in gun before cleaning, servicing, or shipping.

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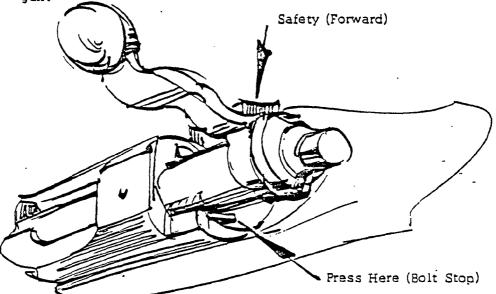
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

<u>To Disassemble</u> - Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. See sketch below. This will release bolt. Withdraw bolt final assembly from gun.



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- <u>To Service</u> The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.
- <u>To Reassemble (To Gun)</u> Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.
  - Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement: then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

MCDEL 600 Assembly 2

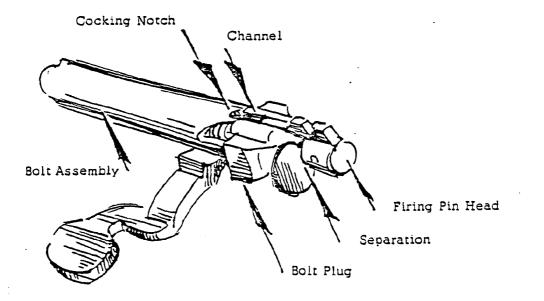
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#### REMINGTON FIELD SERVICE MANUAL

BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

- <u>To Disassemble</u> Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (see sketch below). Then turn bolt plug to unscrew firing pin assembly from bolt assembly.
- <u>To Service</u> Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.
- <u>To Reassemble</u> Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



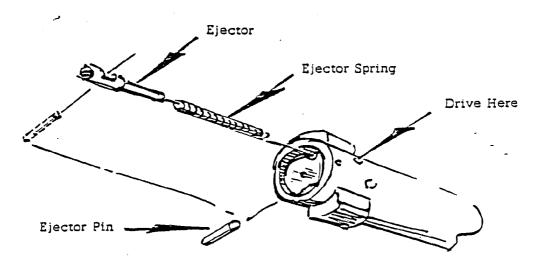
## BOLT FINAL ASSEMBLY - COMPONENTS Continued

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EJECTOR - EJECTOR SPRING (in Bolt Assembly) - is designed to exert outward pressure against base of seated cartridge. After extraction, the ejector pushes cartridge away from bolt face. The opposing grip of the extractor then assists ejection by spinning cartridge from gun.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. See sketch below.



To Service - Interchangeable with no adjustment required.

<u>To Reassemble</u> - Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

'MCDEL 600 Assembly 4

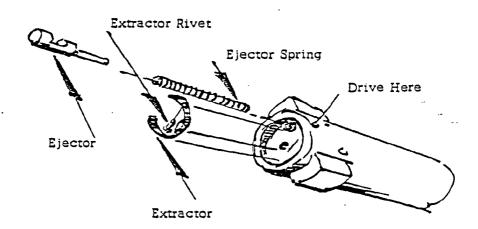
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## REMINGTON FIELD SERVICE MANUAL

## BOLT FINAL ASSEMBLY - COMPONENTS Continued

EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly) - is designed to pull cartridge from chamber. During subsequent ejection, a spinning motion is imparted to cartridge by extractor.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet - from outside of bolt. See sketch below. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.



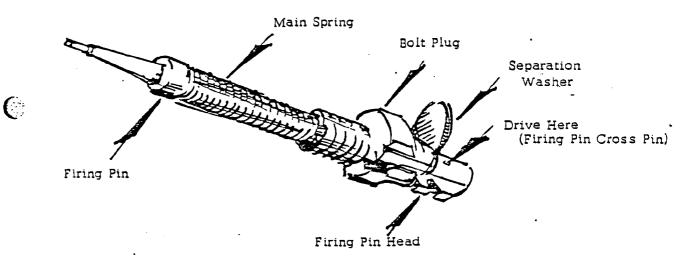
- <u>To Service</u> Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge case to check extractor tension.
- <u>To Reassemble</u> Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then - peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

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#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

- FIRING PIN ASSEMBLY COMPONENTS include: Firing Pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly)
- <u>To Disassemble</u> Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



<u>To Service</u> - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill MODEL 600 Assembly

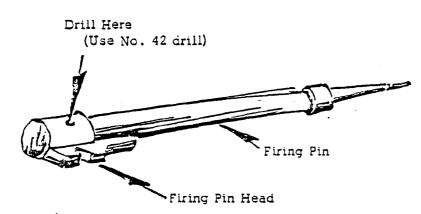
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## REMINGTON FIELD SERVICE MANUAL

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## FIRING PIN ASSEMBLY - COMPONENTS Continued

thru cross pin hole in firing pin head. Drill thru firing pin shank. See sketch below.



<u>To Reassemble</u> - Reassemble all parts of FIRING PIN ASSEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

<u>To Disassemble</u> - Unscrew <u>sight screw</u> (2). A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble front sight assembly from rib on barrel.

<u>To Service</u> - Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

<u>To Reassemble</u> - Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

REAR SIGHT ASSEMBLY - includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage Screw.

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<u>To Disassemble</u> - Unscrew <u>sight screw</u> (2) in rear sight base. A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.

- <u>To Service</u> All parts of rear sight assembly are interchangeable. No factory fitting required.
  - Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.
- <u>To Reassemble</u> Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

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## REMINGTON FIELD SERVICE MANUAL

## REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE

ELEVATION SCREW - is designed to tighten position of rear sight eyepiece at any selected elevation.

<u>To Disassemble</u> - A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW - is designed to tighten rear sight leaf at any selected windage position on base.

<u>To Disassemble</u> - Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

<u>To Service</u> - All parts are interchangeable. No factory fitting required.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

<u>To Disassemble</u> - Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

. To Service - Rib is interchangeable with no adjustment required.

<u>To Reassemble</u> - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

TRIGGER GUARD - is designed of light weight Du Pont "Zytel" material to enclose trigger, magazine, and mount front and rear guard screws for assembling stock to receiver.

<u>To Disassemble</u> - Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

STOCK ASSEMBLY - is designed with Monte Carlo, pistol grip, and custom checkered at grip and fore end, lacquer finished.

<u>To Disassemble</u> - Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw (2). Barrel is free floating.

To Reassemble - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

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BUTT PLATE BUTT PLATE SCREW (2)

<u>To Disassemble</u> - Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

<u>To Service</u> - Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

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## REMINGTON •FIELD SERVICE MANUAL

#### MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

<u>To Disassemble</u> - Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

MAGAZINE FOLLOWER -MAGAZINE SPRING - are designed to feed cartridges from magazine into loading position as bolt is operated.

<u>To Disassemble</u> - Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Service - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screw.

MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

<u>To Disassemble</u> - Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY - in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

<u>To Disassemble</u> - Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Sectional View.

<u>To Service</u> - Interchangeable as replacement assembly. Safety assembly is a factory-welded assembly of safety and corrugated safety thumbpiece. All other parts designed to operate and position safety assembly (as listed in preceding paragraph) are interchangeable as replacements also. No adjustment required.

<u>To Reassemble</u> - Follow reverse order.

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- <u>To Service</u> Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.
- <u>To Reassemble</u> Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage <u>flat end</u> of sear spring upwards against sear and safety cam. <u>Closed end</u> of sear spring seats into housing.

TRIGGER & TRIGGER CONNECTOR - are designed to support sear in "cocked" engagement with firing pin head. As trigger is pulled, trigger connector is disengaged from lower shoulder on sear. Unsupported sear then is forced down by forward motion of firing pin. Hence, gun is "fired".

- <u>To Disassemble</u> Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.
  - Note: Care must be taken to prevent dislodging trigger spring.

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- <u>To Service</u> Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.
- <u>To Reassemble</u> Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

<u>To Disassemble</u> - Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.

<u>To Service</u> - Trigger housing interchangeable as replacement. No factory assembly required.

MODEL 600 Assembly 14

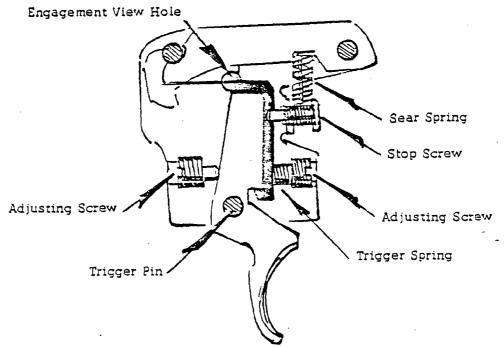
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## REMINGTON FIELD SERVICE MANUAL

<u>To Reassemble</u> - Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - See Sketch below. Remove stock assembly and trigger guard.



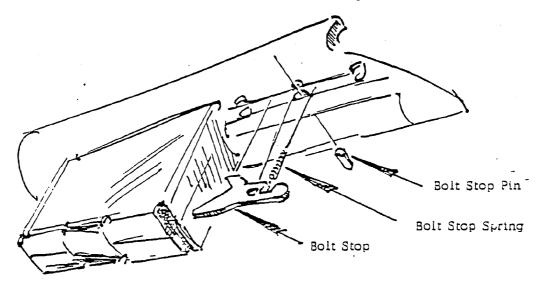
IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).

- Note: All adjusting (2) and stop (1) screws are factory sealed with an adhesive cement.
- <u>Pull of Trigger</u> is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.
- <u>Travel of Trigger</u> is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin will fall or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

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BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

<u>To Disassemble</u> - Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. See sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



<u>To Service</u> - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure bolt stop spring located properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver. MODEL 600 Assembly 16

## REMINGTON FIELD SERVICE MANUAL

BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

- <u>To Disassemble</u> Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).
- <u>To Service</u> Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

<u>To Reassemble</u> - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) - include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quickdetachable (Q.D.) type.

#### Assembly - Swivel Screws to Stock

<u>Rear Swivel Screw</u> - Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

#### Front Swivel Screw - Use No. 13 drill

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at 90° with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

## Assembly - Swivel Assembly (2) O.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin.

Locking Plate Attachment Pin

7/8" Swivel (Q.D.)

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Release Plunger

After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw. MODEL 600 Assembly 18

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## REMINGTON FIELD SERVICE MANUAL

## SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE Continued

### Assembly - Strap to Assembled Swivels

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Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. Then insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

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Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

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Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction. MODEL 500 Cycle of Operation 20

## REMINGTON FIELD SERVICE MANUAL

### ETECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

## LOCKING

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Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with receil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

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Instructions for loading, unloading, assembly, disassembly and care are contained in instruction folder (RD 5473) supplied with each Carbine. Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

Malfunction	Cause		Con	Correction	
Firing	1.	Firing pin damaged.	1.	Replace.	
-	2.	Firing pin binds.	2.	Free up or replace.	
	3.	Firing pin protrusion faulty.	3.	Replace firing pin.	
	4.	Trigger assembly out of adjustment.	4.	Adjust.	
• •	5.	Faulty ammunition.	5.	Replace ammunition.	( ) E
Unlocking	1.	See Extraction.	1.	See Extraction.	
	2.	Upset extraction cam on bolt handle.	2.	Smooth up bolt handle cam.	
	3.	Burr at ejector hole in bolt.	3.	Deburr.	
	4.	Blown or set back primer on shell.	4.	Ammunition may be at fault.	
Extraction	۱.	Fouled, rough, or enlarged chamber.	1.	Polish if fouled or rough. Replace barrel assembly if enlarged.	
	2.	Extractor broken or damaged.	2.	Fit new extractor and rivet.	
•	3.	Not enough hook space on extractor.	3.	Pit new extractor and rivet.	ካ
	4.	Height of claw not correct.	4.	Fit new extractor and rivet.	raye

## MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION

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MODEL 600 Malfunctions

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<u>Malfunction</u>	Cause	Correction
Bolt Binds	1. Guard screws protrude into bolt track.	1. File ends of screws.
	<ol> <li>Receiver plug screws protrude into bolt track.</li> </ol>	2. File ends of screws.
	3. Bolt handle Interferes in stock.	3. Clear stock or fit new stock.
	4. Damage at rear of bolt lugs.	4. Stone to blend. Check head space.
Ejection	Burr at ejector hole in bolt.	1. Deburr.
	2. Ejector binds or fails to retract far enough.	2. Free up or replace.
	3. Extractor binds.	3. Adjust or fit new extractor (and rivet).
Bolt Pulls	1. Bolt stop or bolt release binds.	l. Free up.
Out	2. Bolt stop or bolt release broken.	2. Replace.
	3. Bolt stop spring damaged.	3. Replace.
Feeding	1. Magazine follower binds.	1. Adjust side angle on magazine.
	2. Weak or defective follower spring.	2. Replace spring.
	3: Magazine spring caught under guard.	3. Correct.
	<ol> <li>Damaged chamfer on bolt head.</li> </ol>	4. Replace bolt, or stone smooth.
	5. Tabs on follower bent.	5. Stralghten or replace follower.
Loading	1. Damaged receiver rails.	1. Polish or reshape.
	2. Sharp edge - rear end of chamber.	2. Remove sharpness.
	3, Rough loading ramp in receiver.	3. Pollsh ramp.
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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

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V	<u>Malfunction</u>	<u>Cai</u> u	se	Co	prection
·L	ocking	1.	Shallow throat.	1.	Ream.
		2.	Min. head space.	2.	Re-head.
		3.	Damaged chamber.	З.	Re-head.
		4.	Extractor interferes with shell rim.	4.	Fit new extractor (grind relief in new extractor behind claw).
		5.	Ejector binds or fails to retract far enough.	5.	Free up or replace.
		6.	Burr at ejector hole in bolt.	6.	Debu <b>r.</b>
		7.	Sharp corners in bolt lugs.	7.	Stone radius,
(5	ocking see Trigger Idjustment)	1.	Trigger adjusting screw at rear out of adjustment (improper horizontal engagement of sear and connector).		Adjust.
		2.	Improper vertical engagement of sear and connector.	2.	Fit new trigger assembly.
		3.	Trigger doesn't retract.	З.	Fit new trigger assembly.
		4.	Corners on sear or connector rounded.	4.	Fit new sear and safety can or connector.
Bu	alges or	1.	Oversize chamber.	1.	Replace barrel assembly.
BI	lows Cases	2.	Max. head space.	2.	Fit new bolt.
¢.	afety	1.	Safe binds (safe works hard).	1.	Free up.
50	nety	2.		-	Replace washer or reseat in
,		-	(safe works too freely).		safety pivot pin slot.
•		3.	Safety damaged.	3.	Replace safety.

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> MODEL 600 Malfunctions Page 23

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	Cause	Correction
Accuracy		
- Group	I. Crown of barrel damaged.	1. Recrown.
Size	2. Barrel bore fouled.	2. Lead or replace barrel.
	3. Enlarged bore.	3. Replace barrel.
	4. Improper bedding of barrel in stock	. 4. Refloat barrel.
	5. Loose sights.	5. Tighten or replace.

- Point of Impact Barrel not straight.
 Improper or loose sights.

1. Straighten or replace barrel.

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2. Tighten or change sights.

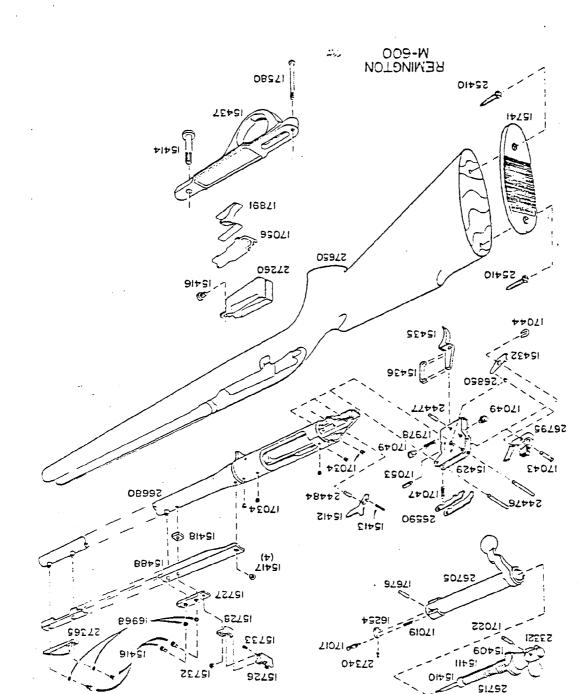
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REMINGTON FIELD SERVICE MANUAL

MCDEL 500 Sectional View 25

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MODEL 600

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The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



This SERVICE MANUAL supplement includes a brief design function, recommended method of disassembly, and assembly of each part. Any necessary adjustment or care in assembly is included. A final section on malfunctions and a complete index of gun parts completes the supplement. Close-up line drawings as well as a complete sectional view serve to illustrate text.

The Instruction Folder/Parts List, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

<u>Precaution</u>: Make sure no live cartridges remain in gun before cleaning, servicing, or shipping.

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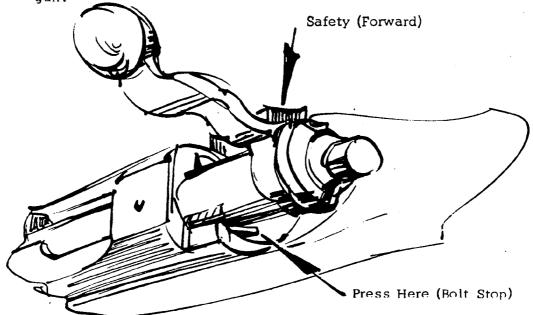
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

<u>To Disassemble</u> - Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. See sketch below. This will release bolt. Withdraw bolt final assembly from gun.



- <u>To Service</u> The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.
- <u>To Reassemble (To Gun)</u> Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.
  - Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

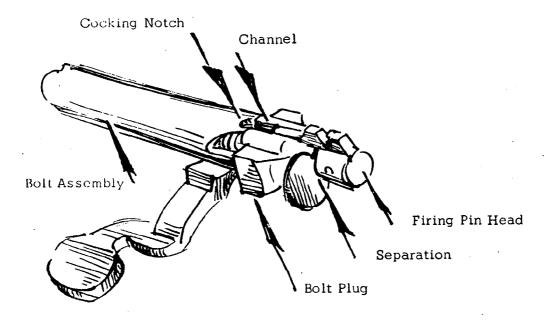
MODEL 600 Assembly 2

## REMINGTON FIELD SERVICE MANUAL

BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

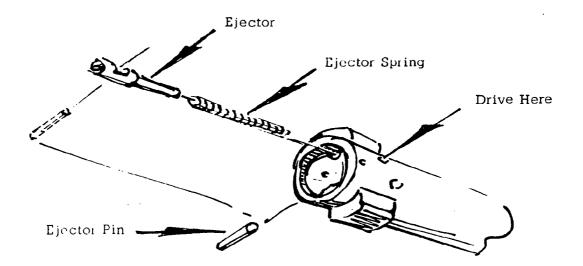
- <u>To Disassemble</u> Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (see sketch below). Then turn bolt plug to unscrew firing pin assembly from bolt assembly.
- <u>To Service</u> Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.
- <u>To Reassemble</u> Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



## BOLT FINAL ASSEMBLY - COMPONENTS Continued

EJECTOR - EJECTOR SPRING (in Bolt Assembly) - is designed to exert outward pressure against base of seated cartridge. After extraction, the ejector pushes cartridge away from bolt face. The opposing grip of the extractor then assists ejection by spinning cartridge from gun.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. See sketch below.



To Service - Interchangeable with no adjustment required.

<u>To Reassemble</u> - Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

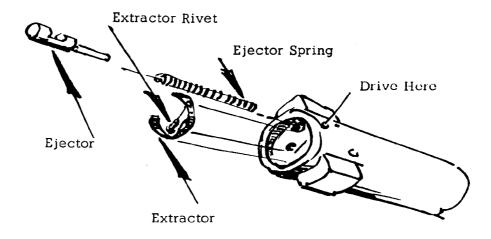
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

MODEL 600 Assembly 4

## REMINGTON FIELD SERVICE MANUAL

## BOLT FINAL ASSEMBLY - COMPONENTS Continued

- EXTRACTOR EXTRACTOR RIVET (in Bolt Assembly) is designed to pull cartridge from chamber. During subsequent ejection, a spinning motion is imparted to cartridge by extractor.
- <u>To Disassemble</u> Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet - from outside of bolt. See sketch below. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

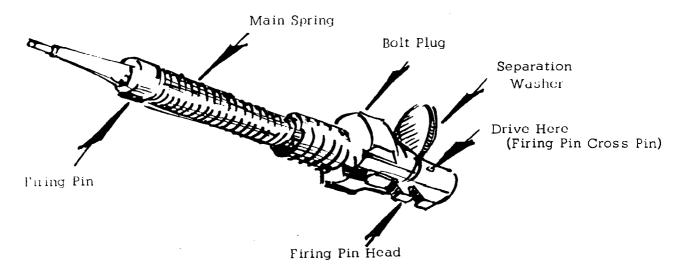


- <u>To Service</u> Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge case to check extractor tension.
- <u>To Reassemble</u> Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then - peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

### BOLT FINAL ASSEMBLY - COMPONENTS Continued

- FIRING PIN ASSEMBLY COMPONENTS include: Firing Pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly)
- <u>To Disassemble</u> Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



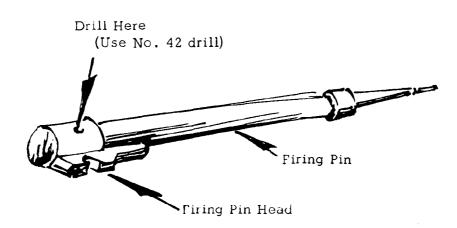
<u>To Service</u> - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill MODEL 600 Assembly b

## REMINGTON FIELD SERVICE MANUAL

## FIRING PIN ASSEMBLY - COMPONENTS Continued

thru cross pin hole in firing pin head. Drill thru firing pin shank. See sketch below.



<u>To Reassemble</u> - Reassemble all parts of FIRING PIN ASSEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

<u>To Disassemble</u> - Unscrew <u>sight screw</u> (2). A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble front sight assembly from rib on barrel.

- <u>To Service</u> Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.
- <u>To Reassemble</u> Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

REAR SIGHT ASSEMBLY - includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leal, Windage Screw.

- <u>To Disassemble</u> Unscrew <u>sight screw</u> (2) in rear sight base. A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.
- <u>To Service</u> All parts of rear sight assembly are interchangeable. No factory fitting required.
  - Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.
- <u>To Reassemble</u> Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

- MODEL 600 Assembly 8

## REMINGTON FIELD SERVICE MANUAL

## REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE

ELEVATION SCREW - is designed to tighten position of rear sight exercise at any selected elevation.

<u>To Disassemble</u> - A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF

WINDAGE SCREW - is designed to tighten rear sight leaf at any selected windage position on base.

<u>To Disassemble</u> - Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

<u>To Service</u> - All parts are interchangeable. No factory fitting required.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

 $\frac{T_{O} D isassemble}{rib screw}$  - Remove front and rear sights. Unscrew and remove Lift and disassemble rib from barrel.

Note: When rib is removed, a small <u>rear sight nut</u> will also disassemble from beneath the rearmost rear sight hole.

To Service - Rib is interchangeable with no adjustment required.

<u>To Reassemble</u> - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

TRIGGER GUARD - is designed of light weight Du Pont "Zytel" material to enclose trigger, magazine, and mount front and rear guard screws for assembling stock to receiver.

<u>To Disassemble</u> - Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

- Note: Stock assembly can also be disassembled when trigger guard is removed.
- To Service Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

STOCK ASSEMBLY - is designed with Monte Carlo, pistol grip, and custom checkered at grip and fore end, lacquer finished.

- <u>To Disassemble</u> Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.
- <u>To Service</u> Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw (2). Barrel is free floating.

To Reassemble - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

- <u>To Disassemble</u> Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.
- <u>To Service</u> Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

<u>To Disassemble</u> - Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

MAGAZINE FOLLOWER -MAGAZINE SPRING - are designed to feed cartridges from magazine into loading position as bolt is operated.

<u>To Disassemble</u> - Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screw.

MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

<u>To Disassemble</u> - Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY - in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

<u>To Disassemble</u> - Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Sectional View.

<u>To Service</u> - Interchangeable as replacement assembly. Safety assembly is a factory-welded assembly of safety and corrugated safety thumbpiece. All other parts designed to operate and position safety assembly (as listed in preceding paragraph) are interchangeable as replacements also. No adjustment required.

To Reassemble - Follow reverse order.

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# REMINGTON FIELD SERVICE MANUAL

TRIGGER ASSEMBLY - is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

<u>To Disassemble</u> - Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver. See Sectional View.

<u>To Service</u> - Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

<u>To Reassemble</u> - Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY - COMPONENTS - See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY - is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of springloaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

<u>To Disassemble</u> - Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring. See Sectional View.

- <u>To Service</u> Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.
- <u>To Reassemble</u> Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage <u>flat end</u> of sear spring upwards against sear and safety cam. <u>Closed end</u> of sear spring seats into housing.

TRIGGER & TRIGGER CONNECTOR - are designed to support sear in "cocked" engagement with firing pin head. As trigger is pulled, trigger connector is disengaged from lower shoulder on sear. Unsupported sear then is forced down by forward motion of firing pin. Hence, gun is "fired".

- <u>To Disassemble</u> Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.
  - Note: Care must be taken to prevent dislodging trigger spring.
- <u>To Service</u> Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.
- <u>To Reassemble</u> Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

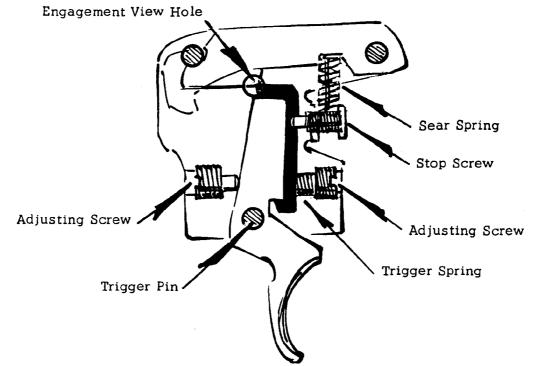
- <u>To Disassemble</u> Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.
- <u>To Service</u> Trigger housing interchangeable as replacement. No factory assembly required.

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<u>To Reassemble</u> - Follow reverse order. Restake adjusting screws to secure in location.

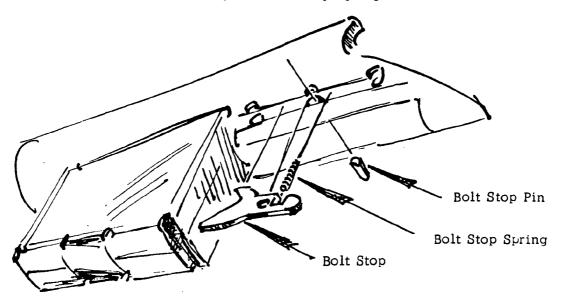
TRIGGER ADJUSTMENT - See Sketch below. Remove stock assembly and trigger guard.



- IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).
- Note: All adjusting (2) and stop (1) screws are factory sealed with an adhesive cement.
- <u>Pull of Trigger</u> is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.
- <u>Travel of Trigger</u> is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin <u>will not fall</u> or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin <u>will</u> <u>fall</u> or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

<u>To Disassemble</u> - Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. See sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



<u>To Service</u> - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure bolt stop spring located properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver. MODEL 600 Assembly 16

# REMINGTON FIELD SERVICE MANUAL

BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

- <u>To Disassemble</u> Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).
- <u>To Service</u> Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

<u>To Reassemble</u> - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) - include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quick-detachable (Q.D.) type.

## Assembly - Swivel Screws to Stock

<u>Rear Swivel Screw</u> - Use No. 15 size drill (.180"). Locate screw hole  $2 \frac{1}{2}$  inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

# Assembly - Swivel Assembly (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin.



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

MODEL 600 Assembly 18

# REMINGTON FIELD SERVICE MANUAL

# SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE Continued

Assembly - Strap to Assembled Swivels

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. Then insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

# <u>FIRING</u>

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

## UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

## COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction. MODEL 600 Cycle of Operation 20

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## EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

## FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

## LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

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Instructions for loading, unloading, assembly, disassembly and care are contained in instruction folder (RD 5473) supplied with each Carbine. Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION

Malfunction	Cause	Correction	E M I ] S E R V
Firing	1. Firing pin damaged.	l. Replace.	ICI
	2. Firing pin binds.	2. Free up or replace.	ын
	3. Firing pin protrusion faulty.	<ol><li>Replace firing pin.</li></ol>	MN
	<ol> <li>Trigger assembly out of adjustment.</li> </ol>	4. Adjust.	A .
	5. Faulty ammunition.	5. Replace ammunition.	MANUAL
Unlocking	1. See Extraction.	1. See Extraction.	
-	2. Upset extraction cam on bolt handle.	2. Smooth up bolt handle cam.	
	3. Burr at ejector hole in bolt.	3. Deburr.	
	4. Blown or set back primer on shell.	4. Ammunition may be at fault.	
Extraction	1. Fouled, rough, or enlarged chamber.	<ol> <li>Polish if fouled or rough. Replace barrel assembly if enlarged.</li> </ol>	
	2. Extractor broken or damaged.	2. Fit new extractor and rivet.	5
	3. Not enough hook space on extractor.		. P
	4. Height of claw not correct.	4. Fit new extractor and rivet.	Page
	4. Height of claw hot concert.	The new exhibition and fivel.	Page 2
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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<b>Malfunction</b>	Cause		Correction		
Bolt Binds	1.	Guard screws protrude into bolt track.	1.	File ends of screws.	
	2.	Receiver plug screws protrude into bolt track.	2.	File ends of screws.	
	3.	Bolt handle interferes in stock.	3.	Clear stock or fit new stock.	
	4.	Damage at rear of bolt lugs.	4.	Stoneto blend. Check head space.	
Ejection	1.	Burr at ejector hole in bolt.	1.	Deburr.	
	2.	Ejector binds or fails to retract far enough.	2.	Free up or replace.	
	3.	Extractor binds.	3.	Adjust or fit new extractor (and rivet).	
Bolt Pulls	1.	Bolt stop or bolt release binds.	1.	Free up.	
Out	2.	Bolt stop or bolt release broken.	2.	Replace.	
	3.	Bolt stop spring damaged.	3.	Replace.	
Feeding	1.	Magazine follower binds.	1.	Adjust side angle on magazine.	
	2.	Weak or defective follower spring.	2.	Replace spring.	
	3.	Magazine spring caught under guard.	з.	Correct.	
	4.	Damaged chamfer on bolt head.	4.	Replace bolt, or stone smooth.	
	5.	Tabs on follower bent.	5.	Straighten or replace follower.	
Loading	1.	Damaged receiver rails.	1.	Polish or reshape.	
	2.	Sharp edge - rear end of chamber.	2.	Remove sharpness.	
	3.	Rough loading ramp in receiver.	3.	Polish ramp.	

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

Malfunction	Cau	ISE AND	Co	prrection
Locking	1.	Shallow throat.	1.	Ream.
_	2.	Min. head space.	2.	Re-head.
	3.	Damaged chamber.	З.	Re-head.
	4.	Extractor interferes with shell rim.	4.	Fit new extractor (grind relief in new extractor behind claw).
	5.	Ejector binds or fails to retract far enough.	5.	Free up or replace.
	6.	Burr at ejector hole in bolt.	6.	Deburr.
	7.	Sharp corners in bolt lugs.	7.	Stone radius.
Cocking (see Trigger Adjustment)	1.	Trigger adjusting screw at rear out of adjustment (improper horizontal engagement of sear and connector).		Adjust.
	2.	Improper vertical engagement of sear and connector.		Fit new trigger assembly.
	З.	Trigger doesn't retract.	3.	Fit new trigger assembly.
	4.	Corners on sear or connector rounded.	4.	Fit new sear and safety cam or connector.
Bulges or	1.	Oversize chamber.	1.	Replace barrel assembly.
Blows Cases	2.	Max. head space.	2.	Fit new bolt.
	1	Onto his do (anto morte hard)	,	Free up
Safety	1.	- •		Free up.
	2.	Safety snap washer stretched out (safe works too freely).	2.	Replace washer or reseat in safety pivot pin slot.
	3.	Safety damaged.	3.	Replace safety.

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

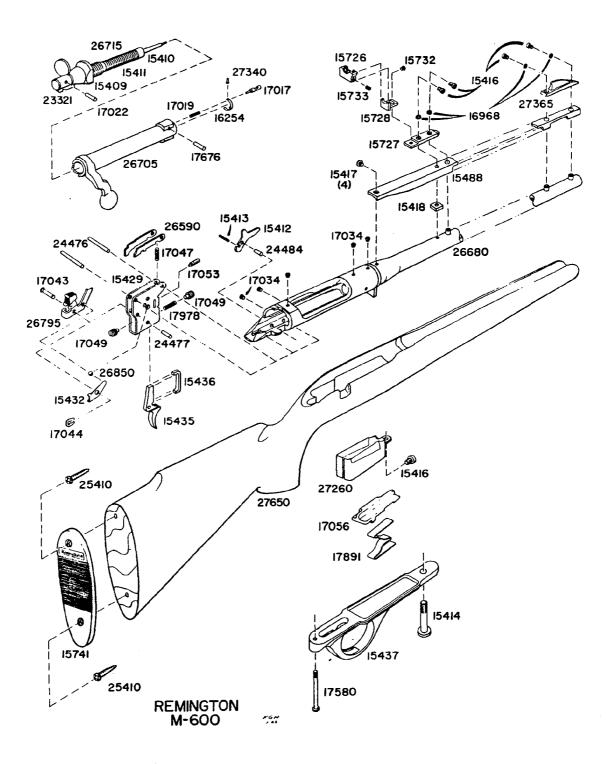
<u>Malfunction</u>	Cause	Correction
Accuracy		
- Group	1. Crown of barrel damaged.	1. Recrown.
Size	2. Barrel bore fouled.	2. Lead or replace barrel.
	3. Enlarged bore.	3. Replace barrel.
	4. Improper bedding of barrel in stock.	4. Refloat barrel.
	5. Loose sights.	5. Tighten or replace.
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- Point of Impact

- Barrel not straight.
   Improper or loose sights.
- Straighten or replace barrel.
   Tighten or change sights.

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# MODEL 600 - FIELD SERVICE MANUAL

# JUNE - 1965

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The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



This SERVICE MANUAL supplement includes a brief design function, recommended method of disassembly, and assembly of each part. Any necessary adjustment or care in assembly is included. A final section on malfunctions and a complete index of gun parts completes the supplement. Close-up line drawings as well as a complete sectional view serve to illustrate text.

The Instruction Folder/Parts List, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

<u>Precaution</u>: Make sure no live cartridges remain in gun before cleaning, servicing, or shipping.

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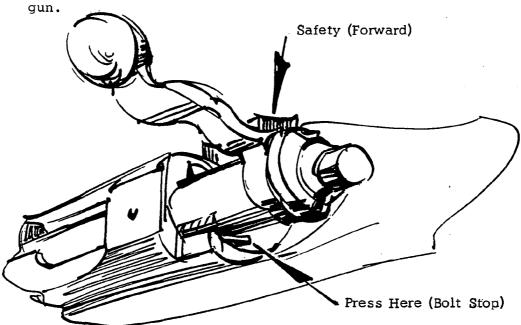
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

<u>To Disassemble</u> - Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. See sketch below. This will release bolt. Withdraw bolt final assembly from

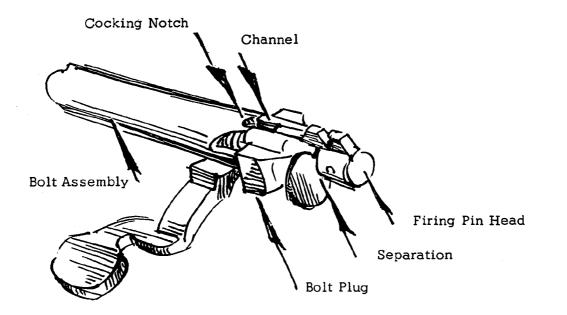


- <u>To Service</u> The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.
- <u>To Reassemble (To Gun)</u> Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.
  - Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

# FIRING PIN ASSEMBLY from BOLT ASSEMBLY

- <u>To Disassemble</u> Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (see sketch below). Then turn bolt plug to unscrew firing pin assembly from bolt assembly.
- <u>To Service</u> Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.
- <u>To Reassemble</u> Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.

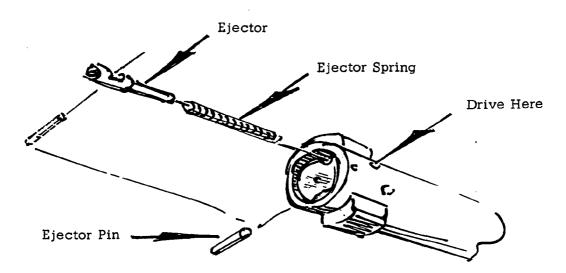


BOLT FINAL ASSEMBLY - COMPONENTS Continued

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EJECTOR - EJECTOR SPRING (in Bolt Assembly) - is designed to exert outward pressure against base of seated cartridge. After extraction, the ejector pushes cartridge away from bolt face. The opposing grip of the extractor then assists ejection by spinning cartridge from gun.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. See sketch below.



<u>To Service</u> - Interchangeable with no adjustment required.

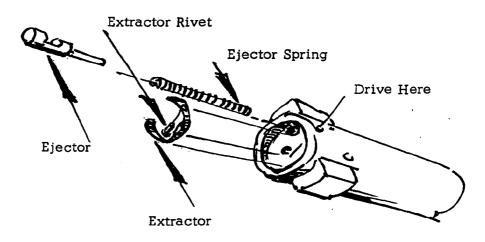
<u>To Reassemble</u> - Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

BOLT FINAL ASSEMBLY - COMPONENTS Continued

EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly) - is designed to pull cartridge from chamber. During subsequent ejection, a spinning motion is imparted to cartridge by extractor.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet - from outside of bolt. See sketch below. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

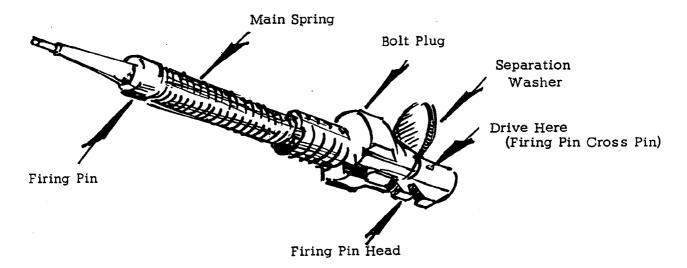


- <u>To Service</u> Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge case to check extractor tension.
- <u>To Reassemble</u> Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then - peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

## BOLT FINAL ASSEMBLY - COMPONENTS Continued

- FIRING PIN ASSEMBLY COMPONENTS include: Firing Pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly)
- <u>To Disassemble</u> Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.

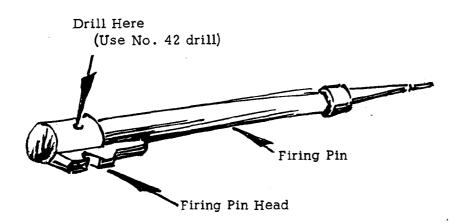


<u>To Service</u> - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill

# FIRING PIN ASSEMBLY - COMPONENTS Continued

thru cross pin hole in firing pin head. Drill thru firing pin shank. See sketch below.



<u>To Reassemble</u> - Reassemble all parts of FIRING PIN ASSEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug. ſ

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

<u>To Disassemble</u> - Unscrew <u>sight screw</u> (2). A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble front sight assembly from rib on barrel.

- <u>To Service</u> Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.
- <u>To Reassemble</u> Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

REAR SIGHT ASSEMBLY - includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage Screw.

- <u>To Disassemble</u> Unscrew <u>sight screw</u> (2) in rear sight base. A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.
- <u>To Service</u> All parts of rear sight assembly are interchangeable. No factory fitting required.
  - Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.
- <u>To Reassemble</u> Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

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MODEL 600 Assembly 8

# REMINGTON FIELD SERVICE MANUAL

## REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE

ELEVATION SCREW - is designed to tighten position of rear sight eyepiece at any selected elevation.

<u>To Disassemble</u> - A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW - is designed to tighten rear sight leaf at any selected windage position on base.

<u>To Disassemble</u> - Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

- <u>To Service</u> All parts are interchangeable. No factory fitting required.
  - Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

<u>To Reassemble</u> - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

<u>To Disassemble</u> - Remove front and rear sights. Unscrew and remove <u>rib screw</u> (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

<u>To Service</u> - Rib is interchangeable with no adjustment required.

<u>To Reassemble</u> - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

TRIGGER GUARD - is designed of light weight Du Pont "Zytel" material to enclose trigger, magazine, and mount front and rear guard screws for assembling stock to receiver.

- <u>To Disassemble</u> Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.
  - Note: Stock assembly can also be disassembled when trigger guard is removed.

To Service - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

STOCK ASSEMBLY - is designed with Monte Carlo, pistol grip, and custom . checkered at grip and fore end, lacquer finished.

- <u>To Disassemble</u> Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.
- <u>To Service</u> Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw (2). Barrel is free floating.

<u>To Reassemble</u> - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

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- <u>To Disassemble</u> Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.
- <u>To Service</u> Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

<u>To Disassemble</u> - Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

MAGAZINE FOLLOWER -MAGAZINE SPRING - are designed to feed cartridges from magazine into loading position as bolt is operated.

<u>To Disassemble</u> - Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screw.

MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

<u>To Disassemble</u> - Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY - in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

<u>To Disassemble</u> - Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Sectional View.

<u>To Service</u> - Interchangeable as replacement assembly. Safety assembly is a factory-welded assembly of safety and corrugated safety thumbpiece. All other parts designed to operate and position safety assembly (as listed in preceding paragraph) are interchangeable as replacements also. No adjustment required.

<u>To Reassemble</u> - Follow reverse order.

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# REMINGTON FIELD SERVICE MANUAL

TRIGGER ASSEMBLY - is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

<u>To Disassemble</u> - Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver. See Sectional View.

<u>To Service</u> - Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

<u>To Reassemble</u> - Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY - COMPONENTS - See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY - is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of springloaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

<u>To Disassemble</u> - Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring. See Sectional View.

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- <u>To Service</u> Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.
- <u>To Reassemble</u> Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage <u>flat end</u> of sear spring upwards against sear and safety cam. <u>Closed end</u> of sear spring seats into housing.

TRIGGER & TRIGGER CONNECTOR - are designed to support sear in "cocked" engagement with firing pin head. As trigger is pulled, trigger connector is disengaged from lower shoulder on sear. Unsupported sear then is forced down by forward motion of firing pin. Hence, gun is "fired".

- <u>To Disassemble</u> Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.
  - Note: Care must be taken to prevent dislodging trigger spring.
- <u>To Service</u> Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.
- <u>To Reassemble</u> Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

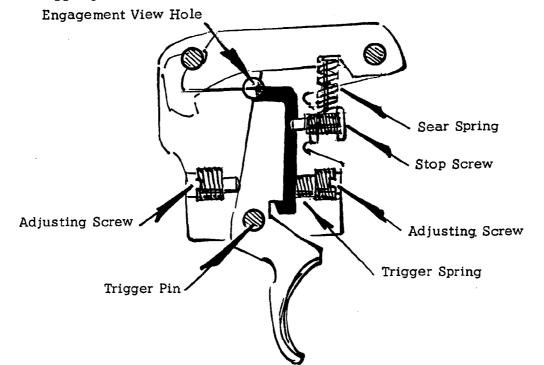
- <u>To Disassemble</u> Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.
- <u>To Service</u> Trigger housing interchangeable as replacement. No factory assembly required.

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<u>To Reassemble</u> - Follow reverse order. Restake adjusting screws to secure in location.

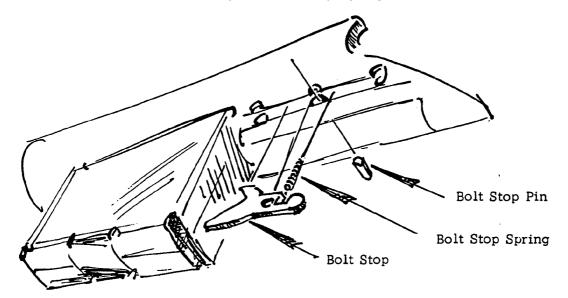
TRIGGER ADJUSTMENT - See Sketch below. Remove stock assembly and trigger guard.



- IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).
- Note: All adjusting (2) and stop (1) screws are factory sealed with an adhesive cement.
- <u>Pull of Trigger</u> is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.
- <u>Travel of Trigger</u> is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin <u>will not fall</u> or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin <u>will</u> <u>fall</u> or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

<u>To Disassemble</u> - Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. See sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



<u>To Service</u> - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure bolt stop spring located properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

## REMINGTON FIELD SERVICE MANUAL

BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

- <u>To Disassemble</u> Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).
- <u>To Service</u> Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

<u>To Reassemble</u> - Follow reverse order.

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SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) - include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quick-detachable (Q.D.) type.

#### Assembly - Swivel Screws to Stock

<u>Rear Swivel Screw</u> - Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

Assembly - Swivel Assembly (2) Q.D.

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Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin.

		Locking Plate
	Res	Attachment Pin
7/8" Swivel (Q.D.) /		
	Release Plunger	

After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

# REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE Continued

#### Assembly - Strap to Assembled Swivels

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. Then insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### <u>FIRING</u>

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

MODEL 600 Cycle of Operation 20

#### REMINGTON FIELD SERVICE MANUAL

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

# LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Instructions for loading, unloading, assembly, disassembly and care are contained in instruction folder (RD 5473) supplied with each Carbine.

> MODEL 600 Malfunctions

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION

Malfunction	ause Correction		ERVI	
Firing	<ol> <li>Firing pin damaged.</li> <li>Firing pin binds.</li> <li>Firing pin protrusion faulty.</li> <li>Trigger assembly out of adjustment.</li> <li>Faulty ammunition.</li> </ol>	<ol> <li>Replace.</li> <li>Free up or replace.</li> <li>Replace firing pin.</li> <li>Adjust.</li> <li>Replace ammunition.</li> </ol>	ICE MANUAL	
Unlocking	<ol> <li>See Extraction.</li> <li>Upset extraction cam on bolt handle.</li> <li>Burr at ejector hole in bolt.</li> <li>Blown or set back primer on shell.</li> </ol>	<ol> <li>See Extraction.</li> <li>Smooth up bolt handle cam.</li> <li>Deburr.</li> <li>Ammunition may be at fault.</li> </ol>		
Extraction	<ol> <li>Fouled, rough, or enlarged chamber.</li> <li>Extractor broken or damaged.</li> <li>Not enough hook space on extractor.</li> <li>Height of claw not correct.</li> </ol>	<ol> <li>Polish if fouled or rough. Replace barrel assembly if enlarged.</li> <li>Fit new extractor and rivet.</li> <li>Fit new extractor and rivet.</li> <li>Fit new extractor and rivet.</li> </ol>	Page 21	

# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	Cause	Correction
Bolt Binds	1. Guard screws protrude into bolt track.	1. File ends of screws.
	<ol> <li>Receiver plug screws protrude into bolt track.</li> </ol>	2. File ends of screws.
	3. Bolt handle interferes in stock.	3. Clear stock or fit new stock.
	4. Damage at rear of bolt lugs.	4. Stoneto blend. Check head space.
Ejection	1. Burr at ejector hole in bolt.	1. Deburr.
	<ol> <li>Ejector binds or fails to retract far enough.</li> </ol>	2. Free up or replace.
	3. Extractor binds.	3. Adjust or fit new extractor (and rivet).
Bolt Pulls	1. Bolt stop or bolt release binds.	l. Free up.
Out	2. Bolt stop or bolt release broken.	2. Replace.
	3. Bolt stop spring damaged.	3. Replace.
Feeding	1. Magazine follower binds.	1. Adjust side angle on magazine.
	2. Weak or defective follower spring.	2. Replace spring.
	3. Magazine spring caught under guard.	3. Correct.
	4. Damaged chamfer on bolt head.	4. Replace bolt, or stone smooth.
	5. Tabs on follower bent.	5. Straighten or replace follower.
Loading	1. Damaged receiver rails.	1. Polish or reshape.
	2. Sharp edge - rear end of chamber.	2. Remove sharpness.
	3. Rough loading ramp in receiver.	<ol><li>Polish ramp.</li></ol>

FIELD SERVICE MANUAL

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	Cause		<u>Co</u>	Correction	
Locking	1.	Shallow throat.	1.	Ream.	
	2.	Min. head space.	2.	Re-head.	
	3.	Damaged chamber.	З.	Re-head.	
	4.	Extractor interferes with shell rim.	4.	Fit new extractor (grind relief in new extractor behind claw).	
	5.	Ejector binds or fails to retract far enough.	5.	Free up or replace.	
	6.	Burr at ejector hole in bolt.	6.	Deburr.	
	7.	Sharp corners in bolt lugs.	7.	Stone radius.	
Cocking (see Trigger Adjustment)	1.	Trigger adjusting screw at rear out of adjustment (improper horizontal engagement of sear and connector).	1.	Adjust.	
,	2.	Improper vertical engagement of sear and connector.	2.	Fit new trigger assembly.	
	3.	Trigger doesn't retract.	3.	Fit new trigger assembly.	
	4.	Corners on sear or connector rounded.	4.	Fit new sear and safety cam or connector.	
Bulges or	1.	Oversize chamber.	1.	Replace barrel assembly.	
Blows Cases	2.	Max. head space.	2.	Fit new bolt.	
Safety	1.	Safe binds (safe works hard).	1.	Free up.	
balety	2.	Safety snap washer stretched out (safe works too freely).	2.	Replace washer or reseat in safety pivot pin slot.	
	3.	Safety damaged.	3.	Replace safety.	

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

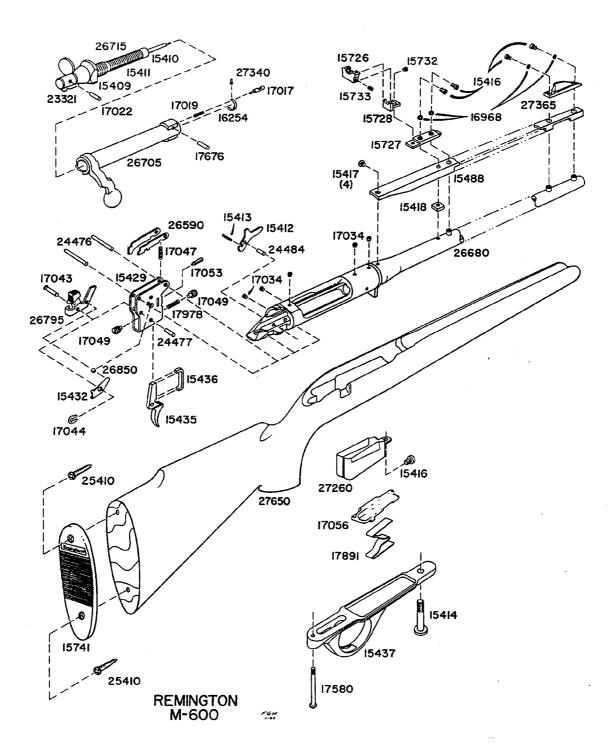
<u>Malfunction</u>	Cause	Correction
Accuracy		
- Group Size	<ol> <li>Crown of barrel damaged.</li> <li>Barrel bore fouled.</li> <li>Enlarged bore.</li> <li>Improper bedding of barrel in stock.</li> <li>Loose sights.</li> </ol>	<ol> <li>Recrown.</li> <li>Lead or replace barrel.</li> <li>Replace barrel.</li> <li>Refloat barrel.</li> <li>Tighten or replace.</li> </ol>
- Point of Impact	<ol> <li>Barrel not straight.</li> <li>Improper or loose sights.</li> </ol>	<ol> <li>Straighten or replace barrel.</li> <li>Tighten or change sights.</li> </ol>

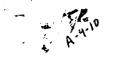
REMINGTON SERVICE MANUAL FIELD

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The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



This SERVICE MANUAL supplement includes a brief design function, recommended method of disassembly, and assembly of each part. Any necessary adjustment or care in assembly is included. A final section on malfunctions and a complete index of gun parts completes the supplement. Close-up line drawings as well as a complete sectional view serve to illustrate text.

The Instruction Folder/Parts List, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

Precaution:

Make sure no live cartridges remain in gun before cleaning, servicing, or shipping.

<sup>™</sup>MODEL 600 <sup>™</sup> Index

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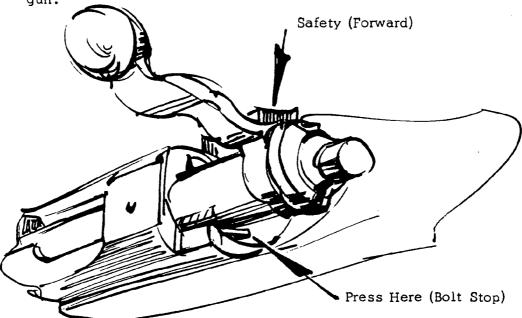
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

<u>To Disassemble</u> - Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. See sketch below. This will release bolt. Withdraw bolt final assembly from gun.



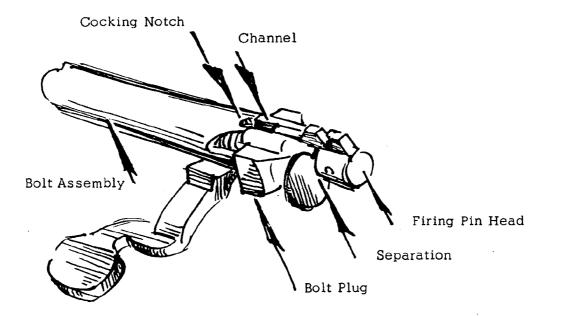
- <u>To Service</u> The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.
- <u>To Reassemble (To Gun)</u> Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.
  - Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

# REMINGTON FIELD SERVICE MANUAL

BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

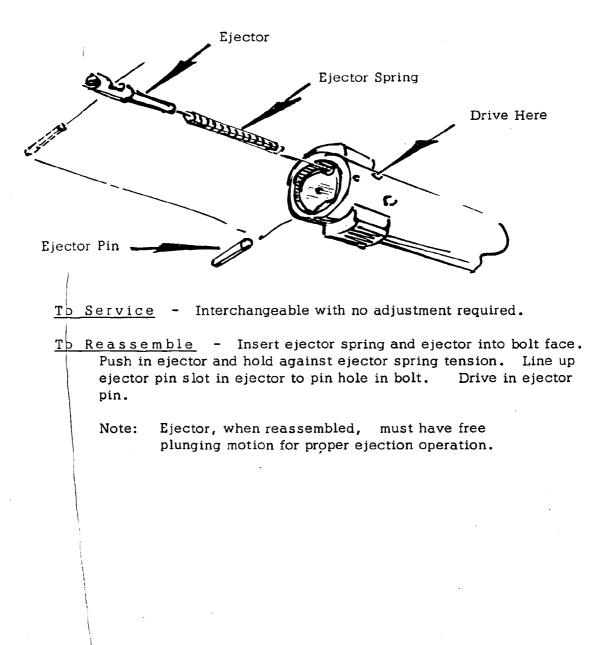
- <u>To Disassemble</u> Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (see sketch below). Then turn bolt plug to unscrew firing pin assembly from bolt assembly.
- <u>To Service</u> Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.
- <u>To Reassemble</u> Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



# BOLT FINAL ASSEMBLY - COMPONENTS Continued

EJECTOR - EJECTOR SPRING (in Bolt Assembly) - is designed to exert outward pressure against base of seated cartridge. After extraction, the ejector pushes cartridge away from bolt face. The opposing grip of the extractor then assists ejection by spinning cartridge from gun.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. See sketch below.

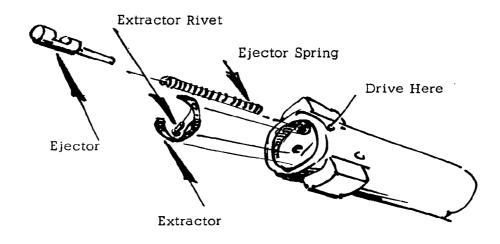


# REMINGTON FIELD SERVICE MANUAL

#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly) - is designed to pull cartridge from chamber. During subsequent ejection, a spinning motion is imparted to cartridge by extractor.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet - from outside of bolt. See sketch below. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.



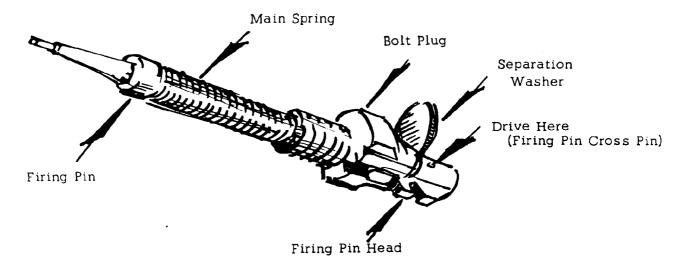
- <u>To Service</u> Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge case to check extractor tension.
- <u>To Reassemble</u> Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then - peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

# FIRING PIN ASSEMBLY - COMPONENTS include: Firing Pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly)

<u>To Disassemble</u> - Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.

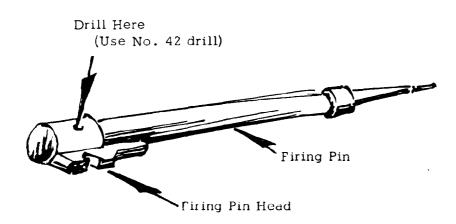


<u>To Service</u> - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill

#### FIRING PIN ASSEMBLY - COMPONENTS Continued

thru cross pin hole in firing pin head. Drill thru firing pin shank. See sketch below.



<u>To Reassemble</u> - Reassemble all parts of FIRING PIN ASSEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

- <u>To Disassemble</u> Unscrew <u>sight screw</u> (2). A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble front sight assembly from rib on barrel.
- <u>To Service</u> Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.
- <u>To Reassemble</u> Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

REAR SIGHT ASSEMBLY - includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage Screw.

- <u>To Disassemble</u> Unscrew <u>sight screw</u> (2) in rear sight base. A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.
- <u>To Service</u> All parts of rear sight assembly are interchangeable. No factory fitting required.
  - Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.
- <u>To Reassemble</u> Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REMINGTON FIELD SERVICE MANUAL

#### REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE

ELEVATION SCREW - is designed to tighten position of rear sight eyepiece at any selected elevation.

<u>To Disassemble</u> - A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW - is designed to tighten rear sight leaf at any selected windage position on base.

<u>To Disassemble</u> - Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

- <u>To Service</u> All parts are interchangeable. No factory fitting required.
  - Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

<u>To Reassemble</u> - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

<u>To Disassemble</u> - Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small <u>rear sight nut</u> will also disassemble from beneath the rearmost rear sight hole.

 $T \circ Service$  - Rib is interchangeable with no adjustment required.

<u>To Reassemble</u> - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

TRIGGER GUARD - is designed of light weight Du Pont "Zytel" material to enclose trigger, magazine, and mount front and rear guard screws for assembling stock to receiver.

- <u>To Disassemble</u> Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.
  - Note: Stock assembly can also be disassembled when trigger guard is removed.

To Service - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain both front and rear guard screws are tightened <u>evenly</u> and securely to receiver.

STOCK ASSEMBLY - is designed with Monte Carlo, pistol grip, and custom checkered at grip and fore end, lacquer finished.

- <u>To Disassemble</u> Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.
- <u>To Service</u> Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw (2). Barrel is free floating.
- <u>To Reassemble</u> Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

- <u>To Disassemble</u> Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.
- <u>To Service</u> Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.
- <u>To Reassemble</u> Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

<u>To Disassemble</u> - Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

MAGAZINE FOLLOWER -MAGAZINE SPRING - are designed to feed cartridges from magazine into loading position as bolt is operated.

<u>To Disassemble</u> - Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screw.

MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

<u>To Disassemble</u> - Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Service - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY - in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

<u>To Disassemble</u> - Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Sectional View.

<u>To Service</u> - Interchangeable as replacement assembly. Safety assembly is a factory-welded assembly of safety and corrugated safety thumbpiece. All other parts designed to operate and position safety assembly (as listed in preceding paragraph) are interchangeable as replacements also. No adjustment required.

To Reassemble - Follow reverse order.

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# REMINGTON FIELD SERVICE MANUAL

TRIGGER ASSEMBLY - is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

<u>To Disassemble</u> - Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver. See Sectional View.

<u>To Service</u> - Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

<u>To Reassemble</u> - Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY - COMPONENTS - See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY - is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of springloaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

<u>To Disassemble</u> - Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring. See Sectional View.

- <u>To Service</u> Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.
- <u>To Reassemble</u> Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage <u>flat end</u> of sear spring upwards against sear and safety cam. <u>Closed end</u> of sear spring seats into housing.

TRIGGER & TRIGGER CONNECTOR - are designed to support sear in "cocked" engagement with firing pin head. As trigger is pulled, trigger connector is disengaged from lower shoulder on sear. Unsupported sear then is forced down by forward motion of firing pin. Hence, gun is "fired".

- <u>To Disassemble</u> Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.
  - Note: Care must be taken to prevent dislodging trigger spring.
- <u>To Service</u> Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.
- <u>To Reassemble</u> Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

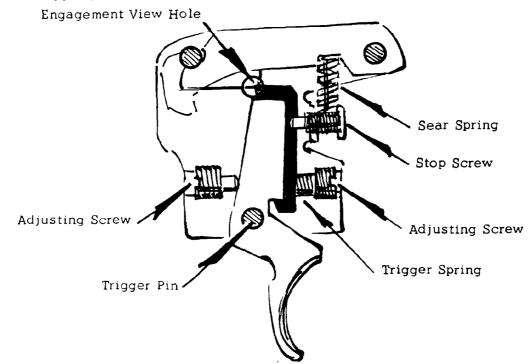
TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

- <u>To Disassemble</u> Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.
- <u>To Service</u> Trigger housing interchangeable as replacement. No factory assembly required.

#### REMINGTON FIELD SERVICE MANUAL

<u>To Reassemble</u> - Follow reverse order. Restake adjusting screws to secure in location.

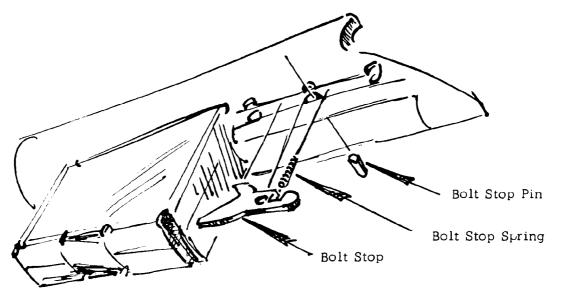
TRIGGER ADJUSTMENT - See Sketch below. Remove stock assembly and trigger guard.



- IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).
- Note: All adjusting (2) and stop (1) screws are factory sealed with an adhesive cement.
- <u>Pull of Trigger</u> is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.
- <u>Travel of Trigger</u> is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin <u>will not fall</u> or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin <u>will</u> <u>fall</u> or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

<u>To Disassemble</u> - Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. See sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



 $\underline{To Service}$  - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure bolt stop spring located properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

# REMINGTON FIELD SERVICE MANUAL

BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

- <u>To Disassemble</u> Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).
- <u>To Service</u> Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) - include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quick-detachable (Q.D.) type.

#### Assembly - Swivel Screws to Stock

<u>Rear Swivel Screw</u> - Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

#### <u>Assembly - Swivel Assembly (2) Q.D.</u>

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin.



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

# REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE Continued

#### Assembly - Strap to Assembled Swivels

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. Then insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### <u>FIRING</u>

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction. MODEL 600 Cycle of Operation 20

# REMINGTON FIELD SERVICE MANUAL

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is scated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SALETA

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

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Instructions for loading, unloading, assembly, disassembly and care are contained in instruction folder (RD 5473) supplied with each Carbine.

		MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION		
Malfunction	<u>Cau</u>	se	Corr	rection
Firing	1. 2. 3. 4. 5.	Firing pin damaged. Firing pin binds. Firing pin protrusion faulty. Trigger assembly out of adjustment. Faulty ammunition.	2. 3.	Replace. Free up or replace. Replace firing pin. Adjust. Replace ammunition.
Unlocking	1. 2. 3. 4.	See Extraction. Upset extraction cam on bolt handle. Burr at ejector hole in bolt. Blown or set back primer on shell.	2.	See Extraction. Smooth up bolt handle cam. Deburr. Ammunition may be at fault.
Extraction	1. 2. 3. 4.	Fouled, rough, or enlarged chamber. Extractor broken or damaged. Not enough hook space on extractor. Height of claw not correct.	2.	<ul> <li>Polish if fouled or rough. Replace barrel assembly if enlarged.</li> <li>Fit new extractor and rivet.</li> <li>Fit new extractor and rivet.</li> <li>Fit new extractor and rivet.</li> </ul>

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful

study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge.

Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

Malfunction	Car	<u>use</u>	Cor	Correction		
Bolt Binds	1. 2.	Guard screws protrude into bolt track. Receiver plug screws protrude into bolt track.	1. 2.	File ends of screws. File ends of screws.		
	3.	Bolt handle interferes in stock.	З.	Clear stock or fit new stock.		
	4.	Damage at rear of bolt lugs.	4.	Stone to blend. Check head space.		
Ejection	1.	Burr at ejector hole in bolt.	1.	Deburr.		
	2.	Ejector binds or fails to retract far enough.	2.	Free up or replace.		
	3.	Extractor binds.	3.	Adjust or fit new extractor (and rivet).		
Bolt Pulls	1.	Bolt stop or bolt release binds.	1.	Free up.		
Out	2.	Bolt stop or bolt release broken.	2.	-		
	3.	Bolt stop spring damaged.	3.	Replace.		
Feeding	1.	Magazine follower binds.	1.	Adjust side angle on magazine.		
	2.	Weak or defective follower spring.	2.			
	3.	Magazine spring caught under guard.	з.	Correct.		
	4.	Damaged chamfer on bolt head.	4.	Replace bolt, or stone smooth.		
	5.	Tabs on follower bent.	5.	Straighten or replace follower.		
Loading	1.	Damaged receiver rails.	1.	Polish or reshape.		
	2.	Sharp edge - rear end of chamber.	2.	Remove sharpness.		
	3.	Rough loading ramp in receiver.	З.	Polish ramp.		

FIELD SERVICE MANUAL

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	Cau	<u>se</u>	Correction	
Locking	1. 2. 3.	Shallow throat. Min. head space. Damaged chamber.	1. 2. 3.	Ream. Re-head. Re-head.
	4.	Extractor interferes with shell rim.	4.	Fit new extractor (grind relief in new extractor behind claw).
	5.	Ejector binds or fails to retract far enough.	5.	Free up or replace.
	6.	Burr at ejector hole in bolt.	6.	Deburr.
	7.	Sharp corners in bolt lugs.	7.	Stone radius.
Cocking (see Trigger Adjustment)	1. 2. 3. 4.	Trigger adjusting screw at rear out of adjustment (improper horizontal engagement of sear and connector). Improper vertical engagement of sear and connector. Trigger doesn't retract. Corners on sear or connector rounded.	1. 2. 3. 4.	Adjust. Fit new trigger assembly. Fit new trigger assembly. Fit new sear and safety cam or connector.
Bulges or	1.	Oversize chamber.	1.	Replace barrel assembly.
Blows Cases	2.	Max. head space.	2.	Fit new bolt.
Safety	1. 2. 3.	Safe binds (safe works hard). Safety snap washer stretched out (safe works too freely). Safety damaged.	1. 2. 3.	Free up. Replace washer or reseat in safety pivot pin slot. Replace safety.

MODEL 600 Malfunctions Page 23

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# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

2.

Tighten or change sights.

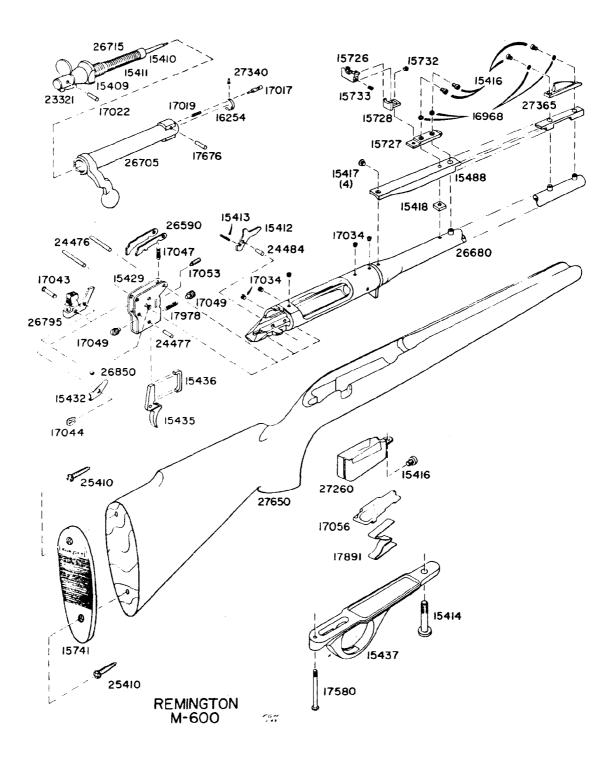
<u>Malfunction</u>	Cau	se	Cor	rrection	
Accuracy					
- Group Size		Crown of barrel damaged. Barrel bore fouled. Enlarged bore. Improper bedding of barrel in stock. Loose sights.	1. 2. 3. 4. 5.	Recrown. Lead or replace barrel. Replace barrel. Refloat barrel. Tighten or replace.	
- Point of	1.	Barrel not straight,	1.	Straighten or replace barrel.	

2. Improper or loose sights.

REMINGTON FIELD SERVICE MANUAL

Impact

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The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This bolt action repeater has the same strong action features as Standard Model 600. The barrel is turned extra heavy to keep magnum loads on target. The action, however, is custom-bedded in firm-setting epoxy at barrel bracket slot in stock. A "Delrin" tang support at rear gives added bearing in stock for the magnum action.

This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

The Monte Carlo stock is laminated for the Magnum Model 600 ---- two color select wood laminates are carefully bonded, sealed, and shaped to give strength and rigidity. Custom checkering is applied to grip and forearm of stock and protected overall with the durable and lustrous Du Pont RK-W wood finish.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

#### MODEL 600 Magnum Introduction

# REMINGTON FIELD SERVICE MANUAL

Remington has introduced a raised barrel bracket on the Magnum Model 600 Carbine. Long eye relief telescope mounts must be assembled snugly against this bracket. Rear sight may be removed to locate long relief mount bases in forward position. Standard eye relief mounts may also be assembled against bracket and to receiver by removing receiver plug screws.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

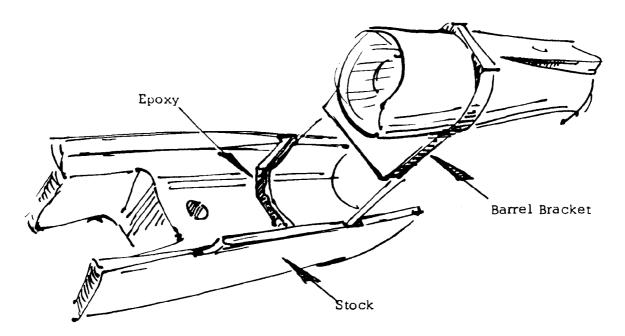
This SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

JFF:T 665 Ilion Res.Div.

STOCK ASSEMBLY - is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

<u>To Disassemble</u> - Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock. See Sketch.



NOTE: "Delrin" tang support may separate from action at rear.

- <u>To Service</u> Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.
  - NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

MODEL 600 Magnum

Assembly Page 2

#### REMINGTON FIELD SERVICE MANUAL

# STOCK ASSEMBLY - Continued

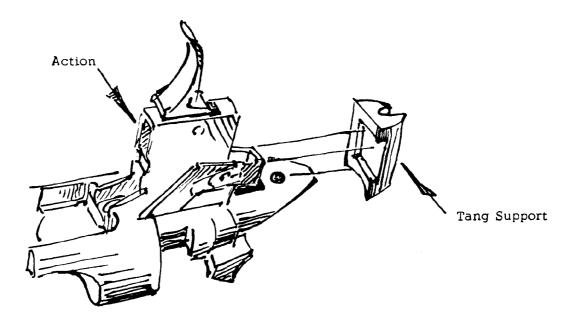
- <u>To Service</u> Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.
  - NOTE: Barrel should assemble free-floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position. Consistent accuracy is thus attained ---- shot after shot.
  - NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT.
  - NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

- <u>To Disassemble</u> Remove stock assembly. Remove loosened tang support from rear of action.
- <u>To Service</u> Replacement tang supports are interchangeable with no adjustment required.

#### TANG SUPPORT - Continued

<u>To Reassemble</u> - Tang support must be positioned at rear of action before action is replaced in stock. See sketch.



Reassemble stock assembly to action . Tighten firmly with guard screws.

TRIGGER GUARD - is designed of lightweight Du Pont "Delrin" material with expanded rib section at bottom. This insures full magazine capacity for Magnum Carbine.

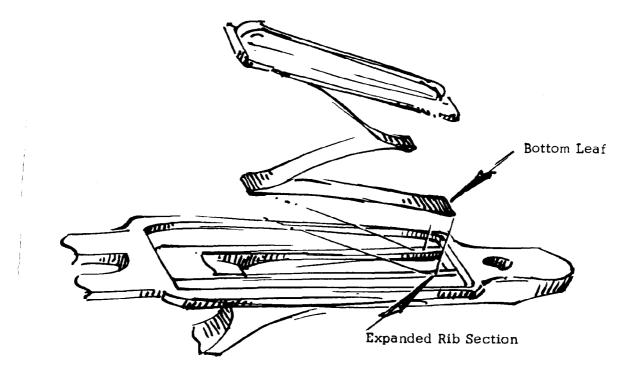
- <u>To Disassemble</u> Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.
- <u>To Service</u> Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard <u>without expanded rib</u> section on Standard Model 600.

MODEL 600 Magnum Assembly Page 4

# REMINGTON FIELD SERVICE MANUAL

TRIGGER GUARD - Continued

<u>To Reassemble</u> - Make certain bottom leaf of magazine spring locates centrally into expanded rib section of trigger guard. See sketch.



Turn both guard screws to tighten guard and stock securely to action.

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

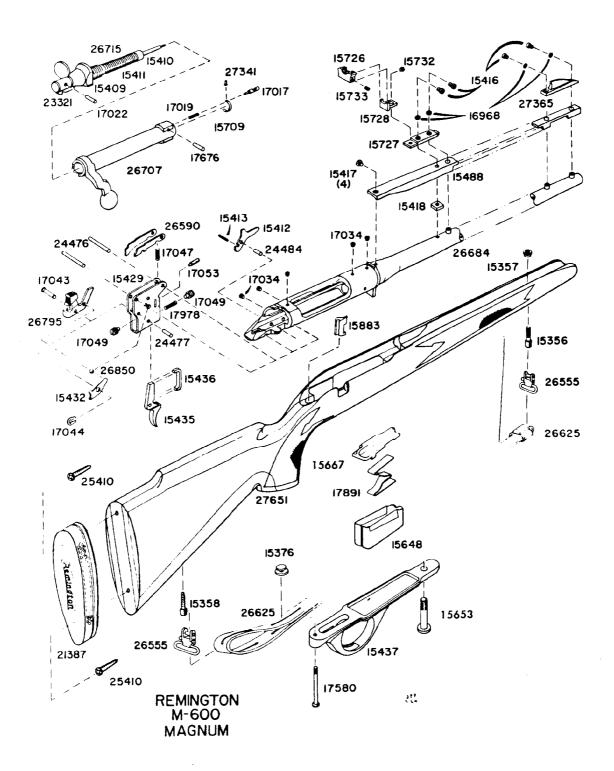
NOTE short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom leaf of magazine spring against trigger guard ---- and insures full Magnum cartridge capacity in magazine.

<u>To Reassemble</u> - Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver. MODEL 600 Magnum Sectional View

Page 6

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The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



This SERVICE MANUAL supplement includes a brief design function, recommended method of disassembly, and assembly of each part. Any necessary adjustment or care in assembly is included. A final section on malfunctions and a complete index of gun parts completes the supplement. Close-up line drawings as well as a complete sectional view serve to illustrate text.

The Instruction Folder/Parts List, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

<u>Precaution</u>: Make sure no live cartridges remain in gun before cleaning, servicing, or shipping.

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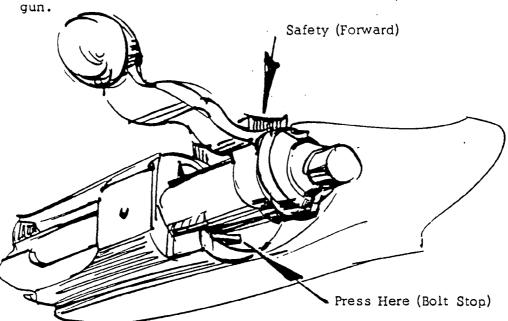
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

<u>To Disassemble</u> - Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. See sketch below. This will release bolt. Withdraw bolt final assembly from



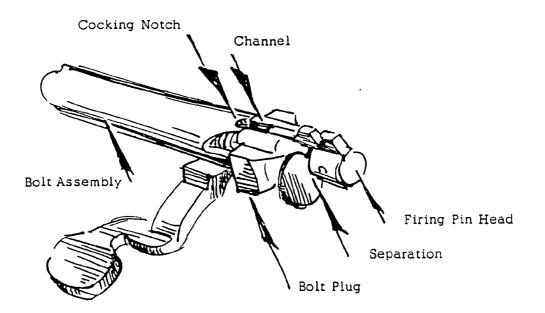
- <u>To Service</u> The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.
- <u>To Reassemble (To Gun)</u> Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.
  - Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

# REMINGTON FIELD SERVICE MANUAL

BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

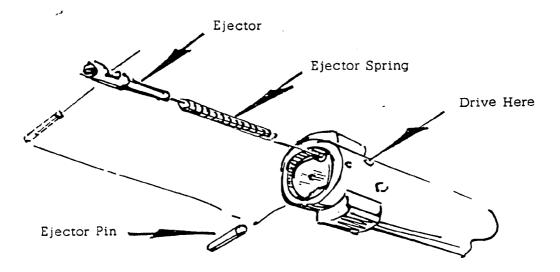
- <u>To Disassemble</u> Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (see sketch below). Then turn bolt plug to unscrew firing pin assembly from bolt assembly.
- <u>To Service</u> Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.
- <u>To Reassemble</u> Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

EJECTOR - EJECTOR SPRING (in Bolt Assembly) - is designed to exert outward pressure against base of seated cartridge. After extraction, the ejector pushes cartridge away from bolt face. The opposing grip of the extractor then assists ejection by spinning cartridge from gun.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. See sketch below.



<u>To Service</u> - Interchangeable with no adjustment required.

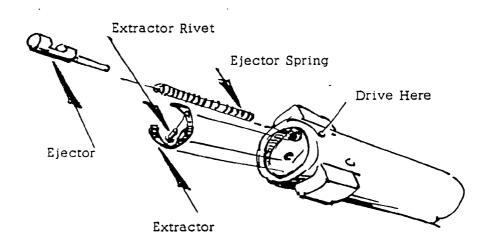
- <u>To Reassemble</u> Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.
  - Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

# REMINGTON FIELD SERVICE MANUAL

#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly) - is designed to pull cartridge from chamber. During subsequent ejection, a spinning motion is imparted to cartridge by extractor.

<u>To Disassemble</u> - Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet - from outside of bolt. See sketch below. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

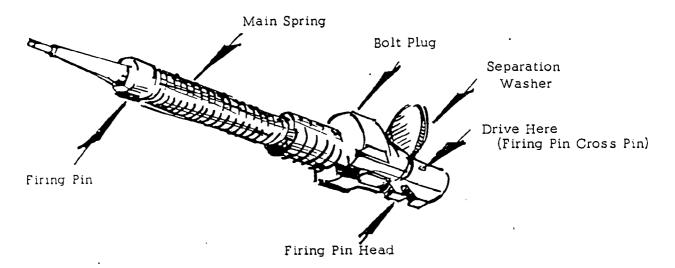


- <u>To Service</u> Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge case to check extractor tension.
- <u>To Reassemble</u> Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then - peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

#### BOLT FINAL ASSEMBLY - COMPONENTS Continued

- FIRING PIN ASSEMBLY COMPONENTS include: Firing Pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly)
- <u>To Disassemble</u> Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



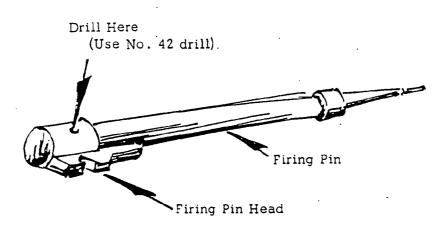
<u>To Service</u> - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

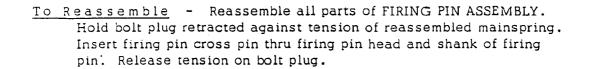
Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill

# REMINGTON FIELD SERVICE MANUAL

# FIRING PIN ASSEMBLY - COMPONENTS Continued

thru cross pin hole in firing pin head. Drill thru firing pin shank. See sketch below.





FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

<u>To Disassemble</u> - Unscrew <u>sight screw</u> (2). A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble front sight assembly from rib on barrel.

<u>To Service</u> - Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

<u>To Reassemble</u> - Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

REAR SIGHT ASSEMBLY - includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage Screw.

<u>To Disassemble</u> - Unscrew <u>sight screw</u> (2) in rear sight base. A thin white nylon <u>sight washer</u> (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.

<u>To Service</u> - All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

<u>To Reassemble</u> - Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

# REMINGTON FIELD SERVICE MANUAL

#### REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE ELEVATION SCREW - is designed to tighten position of rear sight eyepiece at any selected elevation.

<u>To Disassemble</u> - A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE

REAR SIGHT LEAF

WINDAGE SCREW - is designed to tighten rear sight leaf at any selected windage position on base.

<u>To Disassemble</u> - Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

<u>To Service</u> - All parts are interchangeable. No factory fitting required.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

<u>To Disassemble</u> - Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small <u>rear sight nut</u> will also disassemble from beneath the rearmost rear sight hole.

<u>To Service</u> - Rib is interchangeable with no adjustment required.

<u>To Reassemble</u> - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

TRIGGER GUARD - is designed of light weight Du Pont "Zytel" material to enclose trigger, magazine, and mount front and rear guard screws for assembling stock to receiver.

- <u>To Disassemble</u> Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.
  - Note: Stock assembly can also be disassembled when trigger guard is removed.

To Service - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain both front and rear guard screws are tightened <u>evenly</u> and securely to receiver.

STOCK ASSEMBLY - is designed with Monte Carlo, pistol grip, and custom checkered at grip and fore end, lacquer finished.

- <u>To Disassemble</u> Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.
- <u>To Service</u> Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw (2). Barrel is free floating.
- <u>To Reassemble</u> Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

- <u>To Disassemble</u> Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.
- <u>To Service</u> Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.
- To Reassemble Follow reverse order.

# REMINGTON FIELD SERVICE MANUAL

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

<u>To Disassemble</u> - Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

<u>To Service</u> - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazinesupport at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

MAGAZINE FOLLOWER -MAGAZINE SPRING - are designed to feed cartridges from magazine into loading position as bolt is operated.

<u>To Disassemble</u> - Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To <u>Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screw.

MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

<u>To Disassemble</u> - Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

<u>To Service</u> - Interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure magazine follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY - in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

<u>To Disassemble</u> - Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Sectional View.

<u>To Service</u> - Interchangeable as replacement assembly. Safety assembly is a factory-welded assembly of safety and corrugated safety thumbpiece. All other parts designed to operate and position safety assembly (as listed in preceding paragraph) are interchangeable as replacements also. No adjustment required.

<u>To Reassemble</u> - Follow reverse order.

#### REMINGTON FIELD SERVICE MANUAL

TRIGGER ASSEMBLY - is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

<u>To Disassemble</u> - Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver. See Sectional View.

<u>To Service</u> - Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

<u>To Reassemble</u> - Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY - COMPONENTS - See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY - is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of springloaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

<u>To Disassemble</u> - Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring. See Sectional View.

<u>To Service</u> - Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.

<u>To Reassemble</u> - Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage <u>flat end</u> of sear spring upwards against sear and safety cam. <u>Closed end</u> of sear spring seats into housing.

TRIGGER & TRIGGER CONNECTOR - are designed to support sear in "cocked" engagement with firing pin head. As trigger is pulled, trigger connector is disengaged from lower shoulder on sear. Unsupported sear then is forced down by forward motion of firing pin. Hence, gun is "fired".

<u>To Disassemble</u> - Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.

- Note: Care must be taken to prevent dislodging trigger spring.
- <u>To Service</u> Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.
- <u>To Reassemble</u> Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

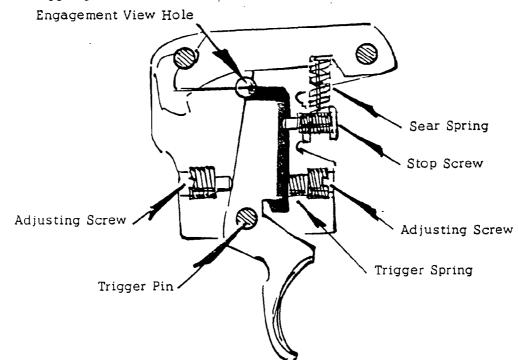
TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

- <u>To Disassemble</u> Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.
- <u>To Service</u> Trigger housing interchangeable as replacement. No factory assembly required.

#### REMINGTON FIELD SERVICE MANUAL

# <u>To Reassemble</u> - Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - See Sketch below. Remove stock assembly and trigger guard.

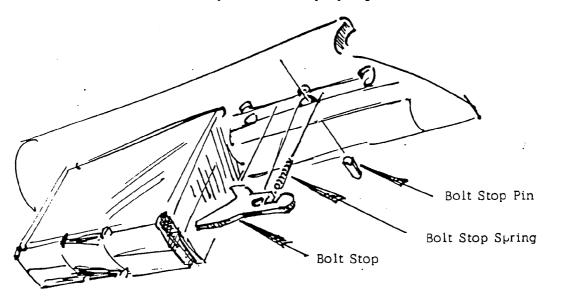


- IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).
- Note: All adjusting (2) and stop (1) screws are factory sealed with an adhesive cement.
- <u>Pull of Trigger</u> is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.
- <u>Travel of Trigger</u> is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin <u>will not fall</u> or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin <u>will</u> <u>fall</u> or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

# REMINGTON

BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

<u>To Disassemble</u> - Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. See sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



<u>To Service</u> - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

<u>To Reassemble</u> - Follow reverse order. Make sure bolt stop spring located properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

# REMINGTON FIELD SERVICE MANUAL

BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

- <u>To Disassemble</u> Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).
- <u>To Service</u> Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

# REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) - include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper. fastener. Strap is 7/8" wide. Swivel assemblies are guickdetachable (Q.D.) type.

#### Assembly - Swivel Screws to Stock

Rear Swivel Screw - Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

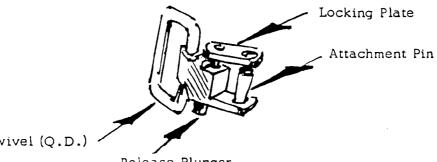
Front Swivel Screw - Use No. 13 drill

- Use 3/8 inch drill. Front Swivel Nut

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at 90° with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

#### Assembly - Swivel Assembly (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin.



7/8" Swivel (O.D.)

Release Plunger

After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

# REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE Continued

#### Assembly - Strap to Assembled Swivels

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. Then insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

# MODEL 600 Cycle of Operation 20

# REMINGTON FIELD SERVICE MANUAL

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Instructions for loading, unloading, assembly, disassembly and care are contained in instruction folder (RD 5473) supplied with each Carbine. Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION

Malfunction	Cause	Correction	E M I N S E R V I
Firing 	<ol> <li>Firing pin damaged.</li> <li>Firing pin binds.</li> <li>Firing pin protrusion faulty.</li> <li>Trigger assembly out of adjustment.</li> <li>Faulty ammunition.</li> </ol>	<ol> <li>Replace.</li> <li>Free up or replace.</li> <li>Replace firing pin.</li> <li>Adjust.</li> <li>Replace ammunition.</li> </ol>	IGTON CE MANUAL
Unlocking	<ol> <li>See Extraction.</li> <li>Upset extraction cam on bolt handle.</li> <li>Burr at ejector hole in bolt.</li> <li>Blown or set back primer on shell.</li> </ol>	<ol> <li>See Extraction.</li> <li>Smooth up bolt handle cam.</li> <li>Deburr.</li> <li>Ammunition may be at fault.</li> </ol>	
Extraction	<ol> <li>Fouled, rough, or enlarged chamber.</li> <li>Extractor broken or damaged.</li> <li>Not enough hook space on extractor.</li> <li>Height of claw not correct.</li> </ol>	<ol> <li>Polish if fouled or rough. Replace barrel assembly if enlarged.</li> <li>Fit new extractor and rivet.</li> <li>Fit new extractor and rivet.</li> <li>Fit new extractor and rivet.</li> </ol>	MODEL 600 Malfunctions Page 21

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## MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

	<u>Malfunction</u>	Car	use	Cor	rrection
	Bolt Binds	1.		•	File ends of screws.
		2.	Receiver plug screws protrude into bolt track.	2.	File ends of screws.
		3.	Bolt handle interferes in stock.	з.	Clear stock or fit new stock.
		4.	Damage at rear of bolt lugs.	4.	Stone to blend. Check head space.
1					
	Ejection	1.	Burr at ejector hole in bolt.	1.	Deburr.
	. '	2.	Ejector binds or fails to retract far enough.	2.	Free up or replace.
		3.	Extractor binds.	3.	Adjust or fit new extractor (and rivet).
	Bolt Pulls	1.	Bolt stop or bolt release binds.	1.	Free up.
	Out	2.	Bolt stop or bolt release broken.	2.	Replace.
		3.	Bolt stop spring damaged.	3.	Replace.
	Feeding	1.	Magazine follower binds.	1.	Adjust side angle on magazine.
	<b>,</b>	2.	Weak or defective follower spring.	2.	Replace spring.
		3.	Magazine spring caught under guard.	3.	
		4.	Damaged chamfer on bolt head.	4.	Replace bolt, or stone smooth.
		5.	Tabs on follower bent.	5.	Straighten or replace follower.
	Loading	1.	Damaged receiver rails.	1.	Polish or reshape.
		2.	Sharp edge - rear end of chamber.	2.	Remove sharpness.
		3.	Rough loading ramp in receiver.	3.	Polish ramp.

REMINGTON FIELD SERVICE MANUAL

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MODEL 600 Malfunctions Page 22

# MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	Cause		Correction		
Locking	1. 2.	Shallow throat. Min. head space.	1. 2.	Ream. Re-head.	
	3.	Damaged chamber.	З.	Re-head.	
	4.	Extractor interferes with shell rim.	4.	Fit new extractor (grind relief in new extractor behind claw).	
	5.	Ejector binds or fails to retract far enough.	5.	Free up or replace.	
	6.	Burr at ejector hole in bolt.	6.	Deburr.	
	7.	Sharp corners in bolt lugs.	7.	Stone radius.	
Cocking	1.	Trigger adjusting screw at rear out	1.	Adjust.	
(see Trigger Adjustment)	••	of adjustment (improper horizontal engagement of sear and connector).	••	Aujust.	
	2.	Improper vertical engagement of sear and connector.	2.	Fit new trigger assembly.	
	3.	Trigger doesn't retract.	3.	Fit new trigger assembly.	
	4.	Corners on sear or connector rounded.	4.	Fit new sear and safety cam or connector.	
Bulges or	1.	Oversize chamber.	1.	Replace barrel assembly.	
Blows Cases	2.	Max. head space.	2.	Fit new bolt.	
Safety	1.	Safe binds (safe works hard).	1.	Free up.	
······································	2.	Safety snap washer stretched out (safe works too freely).	2.	Replace washer or reseat in safety pivot pin slot.	
	3.	Safety damaged.	3.	Replace safety.	

REMINGTON FIELD SERVICE MANUAL

MODEL 600 Malfunctions Page 23

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## MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

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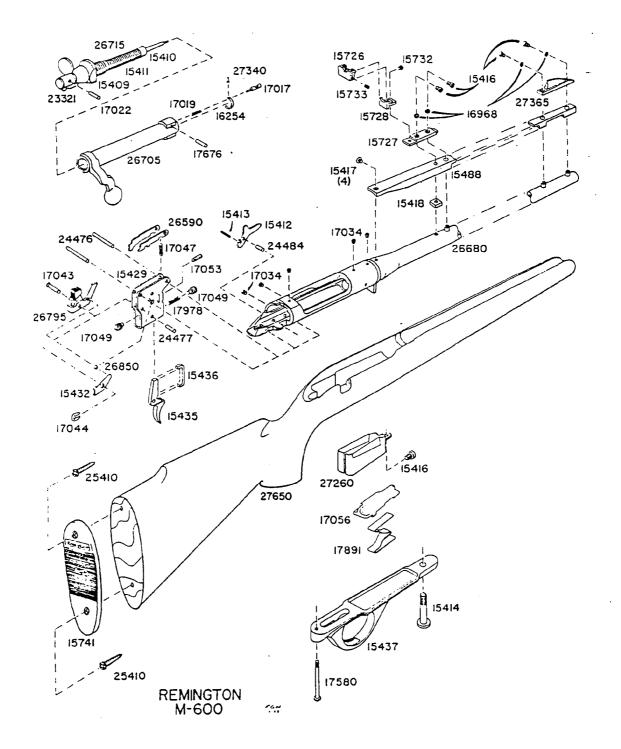
<u>Malfunction</u>	Ca	use	Co	rrection .
Accuracy				
- Group	1.	Crown of barrel damaged.	1.	Recrown.
Size	2.	Barrel bore fouled.	2.	Lead or replace barrel.
	3.	Enlarged bore.	3.	Replace barrel.
	4.	Improper bedding of barrel in stock.	4.	Refloat barrel.
	5.	Loose sights.	5.	Tighten or replace.
- Point of	1.	Barrel not straight.	1.	Straighten or replace barrel.
Impact	2.	Improper or loose sights.	2.	Tighten or change sights.

REMINGTON FIELD SERVICE MANUAL

MODEL 600 Malfunctions Page 24

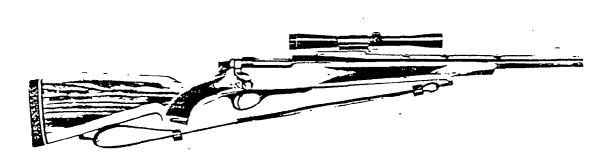
MODEL 600 Sectional View 25

## REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This bolt action repeater has the same strong action features as Standard Model 600. The barrel is turned extra heavy to keep magnum loads on target. The action, however, is custom-bedded in firm-setting epoxy at barrel bracket slot in stock. A "Delrin" tang support at rear gives added bearing in stock for the magnum action.

This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

The Monte Carlo stock is laminated for the Magnum Model 600 ---- two color select wood laminates are carefully bonded, sealed, and shaped to give strength and rigidity. Custom checkering is applied to grip and forearm of stock and protected overall with the durable and lustrous Du Pont RK-W wood finish.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum. MODEL 600 Magnum Introduction

## REMINGTON FIELD SERVICE MANUAL

Remington has introduced a raised barrel bracket on the Magnum Model 600 Carbine. Long eye relief telescope mounts must be assembled snugly against this bracket. Rear sight may be removed to locate long relief mount bases in forward position. Standard eye relief mounts may also be assembled against bracket and to receiver by removing receiver plug screws.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

This SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

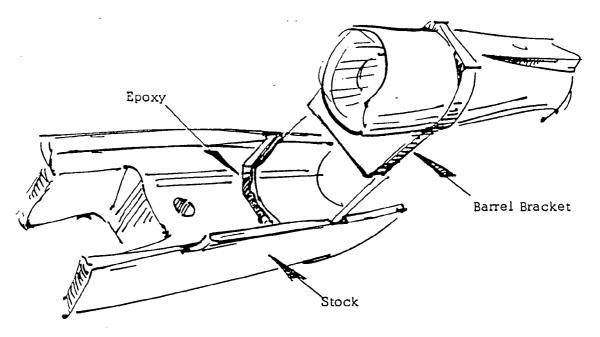
MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

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## REMINGTON FIELD SERVICE MANUAL

STOCK ASSEMBLY - is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

<u>To Disassemble</u> - Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock. See Sketch.



NOTE: "Delrin" tang support may separate from action at rear.

- <u>To Service</u> Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.
  - NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

MODEL 600 Magnum

Assembly

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## REMINGTON FIELD SERVICE MANUAL

## STOCK ASSEMBLY - Continued

- <u>To Service</u> Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.
  - NOTE: Barrel should assemble free-floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position. Consistent accuracy is thus attained ---- shot after shot.
  - NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT.
  - NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

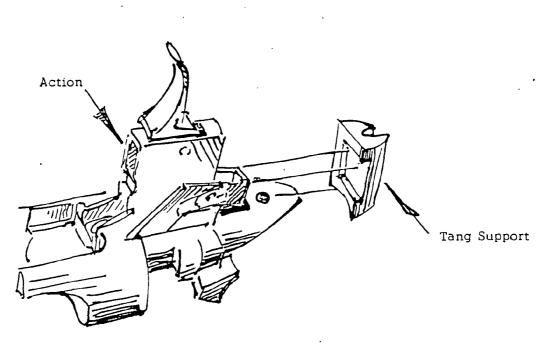
TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

- <u>To Disassemble</u> Remove stock assembly. Remove loosened tang support from rear of action.
- <u>To Service</u> Replacement tang supports are interchangeable with no adjustment required.

## REMINGTON FIELD SERVICE MANUAL

## TANG SUPPORT - Continued

<u>To Reassemble</u> - Tang support must be positioned at rear of action before action is replaced in stock. See sketch.



Reassemble stock assembly to action. Tighten firmly with guard screws.

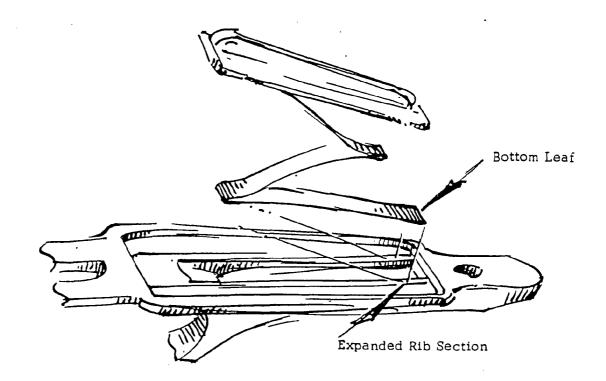
TRIGGER GUARD - is designed of lightweight Du Pont "Delrin" material with expanded rib section at bottom. This insures full magazine capacity for Magnum Carbine.

- <u>To Disassemble</u> Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.
- <u>To Service</u> Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard <u>without expanded rib</u> section on Standard Model 600.

## REMINGTON FIELD SERVICE MANUAL

TRIGGER GUARD - Continued

<u>To Reassemble</u> - Make certain bottom leaf of magazine spring locates centrally into expanded rib section of trigger guard. See sketch.



Turn both guard screws to tighten guard and stock securely to action.

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## REMINGTON FIELD SERVICE MANUAL

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom leaf of magazine spring against trigger guard ---- and insures full Magnum cartridge capacity in magazine.

<u>To Reassemble</u> - Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

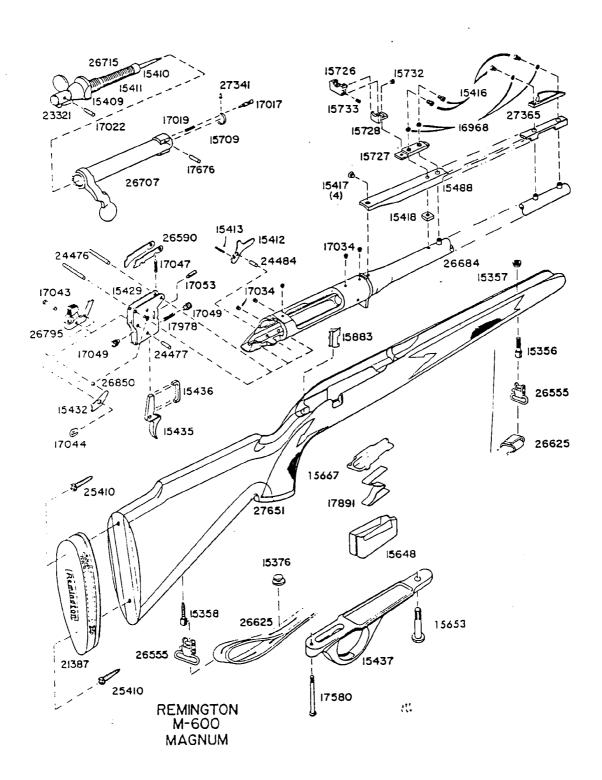


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MODEL 600 Magnum Sectional View

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REMINGTON FIELD SERVICE MANUAL



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## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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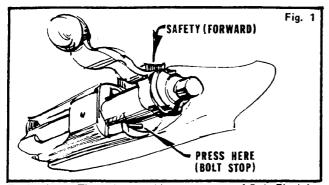
Send all guns for factory service and inquiries on service and parts to

REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357 All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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### BOLT FINAL ASSEMBLY

To Disassemble – Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service – The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun) – Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; the turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

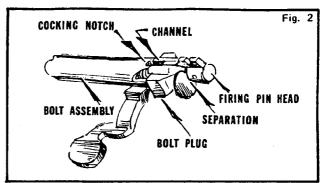
BOLT FINAL ASSEMBLY – COMPONENTS – Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly – which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

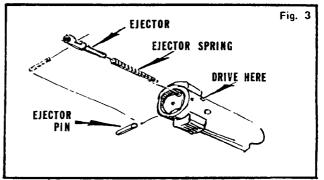
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation, washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

## EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

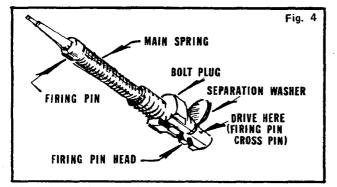
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet insde bolt rim; then – peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

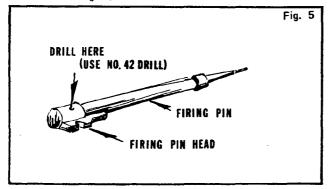
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service – All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY – Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassembly rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** – includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

## REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

**RIB** – is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble – Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble ~ Follow reverse order. Tighten guard screws securely.

**STOCK ASSEMBLY - COMPONENTS** 

## BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service – Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY – is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magainze support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

## MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER – is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function property with assembled spacer.

**SAFETY ASSEMBLY** — in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

To Disassemble – Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Exploded View.

To Reassemble - Follow reverse order.

**TRIGGER ASSEMBLY** – is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

To Disassemble – Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver.

To Service – Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

To Reassemble – Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY – COMPONENTS – See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY – is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of spring–loaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

To Disassemble – Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring.

To Service – Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.

To Reassemble – Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage flat end of sear spring upwards against sear and safety cam. Closed end of sear spring seats into housing.

#### **TRIGGER & TRIGGER CONNECTOR**

To Disassemble – Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.

Note: Care must be taken to prevent dislodging trigger spring.

To Service – Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.

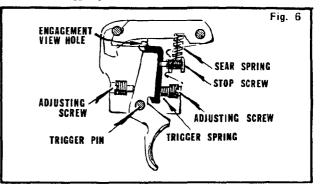
To Reassemble – Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

## TRIGGER HOUSING

To Disassemble – Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety carn assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2) trigger stop screw.

To Reassemble – Follow reverse order. Restake adjusting screws to secure in location.

**TRIGGER ADJUSTMENT** - (See Fig. 6). Remove stock assembly and trigger guard.



**IMPORTANT:** No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).

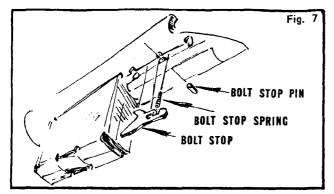
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

Pull of Trigger --- is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

Travel of trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire " as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin will fall or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. (See Fig. 7). Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Reassemble – Follow reverse order. Make sure bolt stop spring locates properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

**BARREL ASSEMBLY** – is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

**To Disassemble** – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) – include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick – detachable (Q. D. ) type.

#### ASSEMBLE - SWIVEL SCREWS TO STOCK

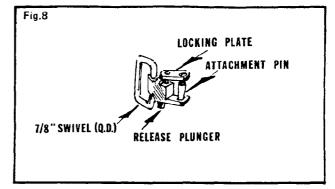
Rear Swivel Screw – Use No. 15 size drill(.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw – Use No. 13 drill. Front Swivel Nut – Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of ,225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightend to stock with front swivel nut.

## ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 8).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

## ASSEMBLE – STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable ( $\Omega$ , D, ) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

### CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives tiring pin forward to strike primer.

## UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

## COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

## EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector, As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

## LOCKING

Locking cycle is accomplised by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

## SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety had two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS

## **Cause and Correction**

## FIRING

Cause:	1. Firing pin damaged.
	2. Firing pin binds.
	3. Firing pin protrusion faulty.
	4. Trigger assembly out of adjustment.
	5. Faulty ammunition.
Correction:	1. Replace.
	2. Free up or replace.
	3. Replace firing pin.
	4. Adjust.
	5. Replace ammunition.

## UNLOCKING

- Cause:1. See Extraction.2. Upset extraction cam on bolt handle.3. Burr at ejector hole in bolt.4. Blown or set back primer on shell.Correction:1. See Extraction.2. Smooth up bolt handle cam.3. Deburr.
  - 4. Ammunition may be at fault.

## MODEL 600

EXTRACTIC	DN	LOADING	
Cause:	<ol> <li>Fouled, rough, or enlarged chamber.</li> <li>Extractor broken or damaged.</li> <li>Not enough hook space on extractor.</li> </ol>	Cause:	1. Damaged receiver rails. 2. Sharp edge— rear end of chamber. 3. Rough loading ramp in receiver.
Correction:	<ol> <li>Height of claw not correct.</li> <li>Polish if fouled or rough. Replace barrel assembly if enlarged.</li> </ol>	Correction:	<ol> <li>Polish or reshape.</li> <li>Remove sharpness.</li> <li>Polish ramp.</li> </ol>
	<ol> <li>2. Fit new extractor and rivet.</li> <li>3. Fit new extractor and rivet.</li> <li>4. Fit new extractor and rivet.</li> </ol>	LOCKING	
BOLT BINDS	3	Cause:	1. Shallow throat. 2. Min. head space.
Cause :	<ol> <li>Guard screws protrude into bolt track.</li> <li>Receiver plug screws protrude into bolt track</li> <li>Bolt handle enterferes in stock.</li> <li>Damage at rear of bolt lugs.</li> </ol>		<ol> <li>Damaged chamber.</li> <li>Extractor interferes with shell rim.</li> <li>Ejector binds or fails to retract far enough.</li> <li>Burr at ejector hole in bolt.</li> <li>Sharp corners in bolt lugs.</li> </ol>
Correction:	<ol> <li>File end of screws.</li> <li>File ends of screws.</li> <li>Clear stock or fit new stock.</li> <li>Stone to blend. Check head space.</li> </ol>	Correction:	<ol> <li>Charle Sectors in Bort rags.</li> <li>Ream.</li> <li>Reachead.</li> <li>Fit new extractor (grind relief in new extractor behind claw).</li> </ol>
EJECTION			5. Free up or replace. 6. Deburr.
Cause:	<ol> <li>Burr at ejector hole in bolt.</li> <li>Ejector binds or fails to retract far enough.</li> <li>Extractor binds.</li> </ol>	COCKING (	7. Stone radius. See trigger Adjustment)
Correction:	1. Deburr. 2. Free up or replace. 3. Adjust or fit new extractor (and rivet).	Cause:	<ol> <li>Trigger adjusting screw at rear out of adjust- ment (improper horizontal engagement of rear and connector)</li> </ol>
BOLT PULL	S OUT		sear and connector.) 2. Improper vertical engagement of sear and connector.
Cause:	<ol> <li>Bolt stop or bolt release binds.</li> <li>Bolt stop or bolt release broken.</li> <li>Bolt stop spring damaged.</li> </ol>	Correction:	<ol> <li>Trigger doesn't retract.</li> <li>Corners on sear or connector rounded.</li> <li>Adjust.</li> </ol>
Correction:	<ol> <li>Free up.</li> <li>Replace.</li> <li>Replace.</li> </ol>		<ol> <li>2. Fit new trigger assembly.</li> <li>3. Fit new trigger assembly;</li> <li>4. Fit new sear and safety cam or connector.</li> </ol>
FEEDING		BULGES OR	BLOWS CASES
Cause:	<ol> <li>Magazine follower binds.</li> <li>Weak or defective follower spring.</li> <li>Magazine spring caught under guard.</li> </ol>	Cause : Correction:	<ol> <li>Oversize chamber.</li> <li>Max. head space.</li> <li>Replace barrel assembly.</li> <li>Fit new bolt.</li> </ol>
Correction:	<ol> <li>Damaged chamfer on bolt head.</li> <li>Tabs on follower bent.</li> <li>Adjust side angle on magazine.</li> <li>Replace spring.</li> </ol>	SAFETY	2. The new bole.
	<ol> <li>Correct.</li> <li>Replace bolt, or stone smooth.</li> <li>Straighten or replace follower.</li> </ol>	Cause:	<ol> <li>Safe binds (safe works hard).</li> <li>Safety snap washer stretches out (safe works too freely).</li> </ol>
·		Correction:	<ol> <li>Safety damaged.</li> <li>Free up.</li> <li>Replace washer or reseat in safety pivot pin</li> </ol>

slot. 3. Replace safety. 

## ACCURACY - Group Size

- Cause: 1. Crown of barrel damaged.
  - 2. Barrel bore fouled.
  - 3. Enlarged bore,
  - 4. Improper bedding of barrel in stock.5. Loose sights.

Correction:

- Recrown.
   Lead or replace barrel.
- 3. Replace barrel.
- 4. Refloat barrel.
- 5. Tighten or replace.
- er righten er replaci

## POINT OF IMPACT

Cause:

- 1. Barrel not straight.
- 2. Improper or loose sights.

Correction;

- 1. Straighten or replace barrel.
- 2. Tighten or change sights.

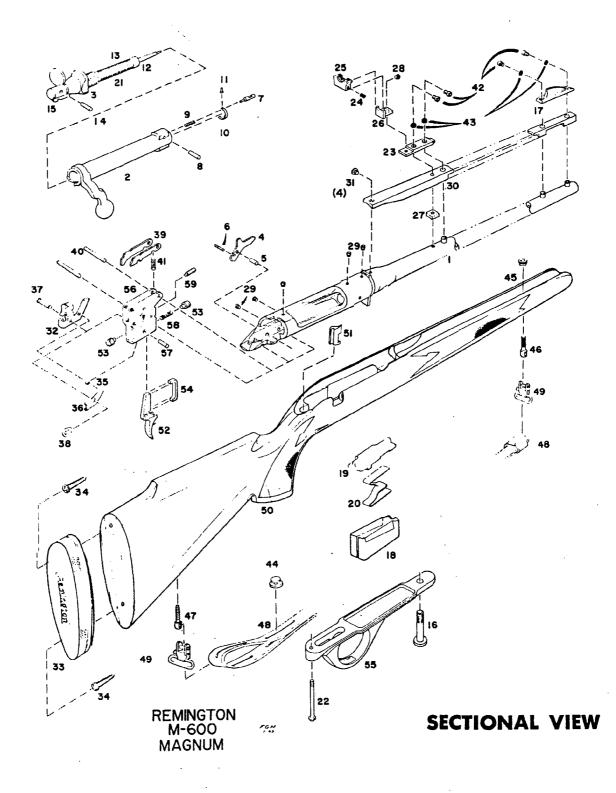
## REMINGTON FIELD SERVICE MANUAL

o. No.	NAME OF PART			NAME OF PART
26684	Barrel Assembly, 350 Rem. Mag. (includes Bar- rel, Barrel Bracket, Barrel Stud (6), Receiver)	32	26795	Safety Assembly (includes Safety and Safety Thumbpiece)
26686		33	21386	Recoil Pad (Magnum only)
26680		34	25410	Recoil Pad Screw (Magnum only)
	Barrel Bracket, Barrel Stud (6), Receiver)	35	26850	Safety Detent Ball
26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem.	36	15432	Safety Detent Spring
	Mag. (includes Bolt Body Assembly and Bolt	37	17043	Safety Pivot Pin
	Handle)	38	17044	Safety Detent Ball Safety Detent Ball Safety Detent Spring Safety Pivot Pin Safety Snap Washer
26705		39	15666	Seal Salely Call
	Assembly and Bolt Handle)	40	24476	Sear Pin
26702		41	17047	Sear Spring
	Rem. Mag. (includes Bolt Assembly, Ejector,	42	15416	
	Ejector Pin, Ejector Spring, Extractor, Extrac- tor Rivet, Firing Pin Assembly)	43	16968	
26700			26990	Sling Strap Assembly and Mountings, Complete
20/00	Assembly, Ejector, Ejector Pin, Ejector Spring,		1	Includes: 44 thru 49
	Extractor, Etractor Rivet, Firing Pin Assembly)	44	15376	Fastener
15409		45	15357	Front Swivel Nut
15412		46	15356	Front Swivel Screw
24484		47	15358	Rear Swivel Screw
15413		48	26625	Sling Strap Assembly, 7/8"
15741		49	26555	
25410	Butt Plate Screw (Model 600 only)	50	27651	
17017	Ejector			Mag. (includes Recoil Pad, Recoil Pad Screw
17676				(2), Stock, Swivel Screw, Rear; Swivel Screw,
17019			27450	Front; Front Swivel Nut, Reinforcing Screw)
15709			210.00	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), and Stock)
16254		51	15883	Tang Support (Magnum only)
27341		52	15435	Trigger
172.0	Mag.	53	17049	Trigger Adjusting Screw
27340 15410			26730	
26715				Sear Safety Cam, Sear Spring, Trigger, Trig-
20715	Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)			ger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop
17022	Firing Pin Cross Pin			Screw)
23321	Firing Pin Head	54	15436	Trigger Connector
15653		55	15437 15429	Trigger Guard Trigger Housing
27365		57	24477	Trigger Pin
	Front Sight Bead)	58	17978	Trigger Spring
15648		59	17053	Trigger Stop Screw
27260				
15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.			
17056				ADDITIONAL CALIBER PARTS
17891			1	
15411	Main Spring			(Not Shown in Sectional View)
17580			26682	Barrel Assembly, 35 Rem (Superseded)
26841	Rear Sight Assembly (includes Rear Sight Eleva-		26681	Barrel Assembly, 222 Rem.
	tion Screw, Rear Sight Base, Rear Sight Eye-		26683	Barrel Assembly, 6 MM Rem.
	piece, Rear Sight Leaf, Rear Sight Windage		26685	
	Screw)		26706	Bolt Assembly, 35 Rem. (Superseded)
15600		1	26775 26701	Bolt Assembly, 222 Rem. Bolt Final Assembly, 35 Rem. (Superseded)
15727			26770	Bolt Final Assembly, 222 Rem. (Superseded)
15733			15852	Fighter 200 Dom
15726			15850	
15418			27342	Extractor Rivet, 222 Rem.
15732			27366	
15778			27261	Magazine, 222 Rem.
17034			27262	Magazine, 35 Rem. (Superseded)
15651			16793	Magazine Follower, 222 Rem.
	Rem. Mag.	[	15742	Magazine Spacer, 222 Rem.
18186			17983	Magazine Spring, 222 Rem.
15488	Rib		15600	
15417			NOTE: 5	iee basic Parts List for parts not listed above.

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REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

## MODEL 600 MAGNUM

STOCK ASSEMBLY – is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

**NOTE:** Use all recommended epoxy handling precautions. To apply ---- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service – Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

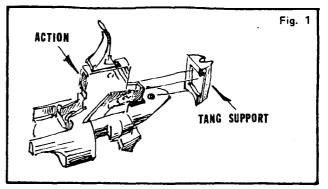
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT'

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



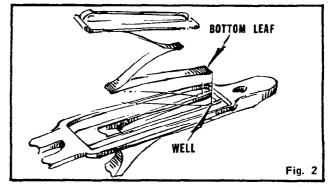
Reassemble stock assembly to action. Tighten firmly with guard screws.

### TRIGGER GUARD

**To Disassemble** – Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble – Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



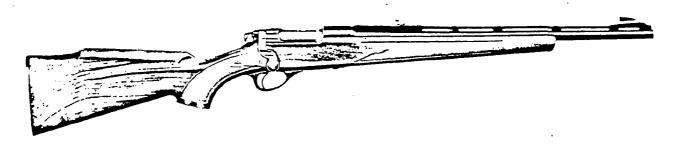
Turn both guard screws to tighten guard and stock securely to action.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ---- and insures full magnum cartridge in magazine.

**To Reassemble** – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

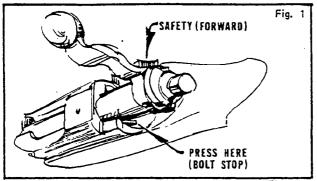
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## MODEL 600

## BOLT FINAL ASSEMBLY

To Disassemble – Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service – The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun) – Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; the turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

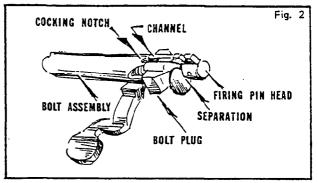
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble -- Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

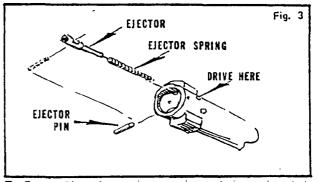
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

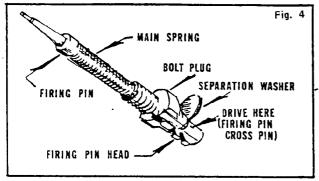
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service – Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet insde bolt rim; then – peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

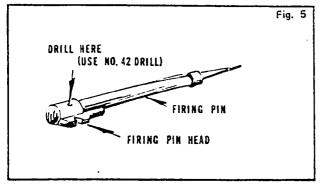
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service –All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassembly rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** – includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also dis-, assemble from beneath the rearmost rear sight hole.

To Reassemble – Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard, Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw(2). Barrel is free floating.

To Reassemble - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service – Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magainze support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER - is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY — in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

To Disassemble – Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Exploded View.

To Reassemble - Follow reverse order.

TRIGGER ASSEMBLY – is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

To Disassemble – Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver.

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To Service – Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

To Reassemble – Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY – COMPONENTS – See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY – is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of spring—loaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

To Disassemble – Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring.

To Service – Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.

To Reassemble – Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage flat end of sear spring upwards against sear and safety cam. Closed end of sear spring seats into housing.

#### TRIGGER & TRIGGER CONNECTOR

To Disassemble – Remove stock assembly, Remove magazine assembly. Tap out trigger pin, Pull out and disassemble loosened trigger and trigger connector.

Note: Care must be taken to prevent dislodging trigger spring.

To Service – Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.

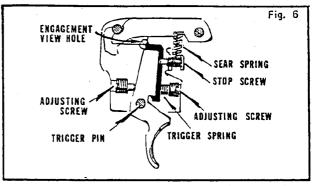
To Reassemble – Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

### TRIGGER HOUSING

To Disassemble – Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2) trigger stop screw.

To Reassemble – Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - (See Fig. 6). Remove stock assembly and trigger guard.



IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).

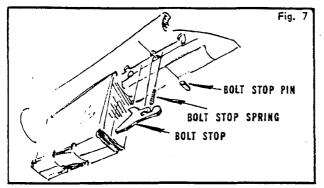
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

Pull of Trigger — is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

Travel of trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin will fall or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. (See Fig. 7). Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Reassemble – Follow reverse order. Make sure bolt stop spring locates properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

BARREL ASSEMBLY  $\rightarrow$  is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib, Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick – detachable (Q. D. ) type.

ASSEMBLE - SWIVEL SCREWS TO STOCK

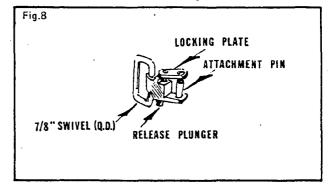
Rear Swivel Screw – Use No. 15 size drill(.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill. Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink, barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightend to stock with front swivel nut.

## ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 8).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable (Q, D, ) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

## CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

## COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector, As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplised by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

## SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety had two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS Cause and Correction

#### cause and correct

## FIRING

Cause:	1. Firing pin damaged.
	2. Firing pin binds.
	3. Firing pin protrusion faulty.
	4. Trigger assembly out of adjustment.
	5. Faulty ammunition.
Correction:	1. Replace.
	2. Free up or replace.
	3. Replace firing pin.
	4. Adjust.
	5. Replace ammunition.
	-

## UNLOCKING

Cause:	<ol> <li>See Extraction.</li> <li>Upset extraction cam on bolt handle.</li> <li>Burr at ejector hole in bolt.</li> <li>Blown or set back primer on shell.</li> </ol>
	<ol> <li>See Extraction.</li> <li>Smooth up bolt handle cam.</li> <li>Deburr.</li> <li>Ammunition may be at fault.</li> </ol>

## MODEL 600

EXTRACTION		LOADING		
Cause:	1. Fouled, rough, or enlarged chamber.	Cause:	1. Damaged receiver rails.	
	2. Extractor broken or damaged.		2. Sharp edge- rear end of chamber.	
	3. Not enough hook space on extractor."		3. Rough loading ramp in receiver.	
	4. Height of claw not correct.	Correction:	1. Polish or reshape.	
Correction:	1. Polish if fouled or rough. Replace barrel as-		2. Remove sharpness.	
	sembly if enlarged.		3. Polish ramp.	
	2. Fit new extractor and rivet.			
	3. Fit new extractor and rivet.	LOCKING		
	4. Fit new extractor and rivet.			
		Cause:	1. Shallow throat.	
BOLT BINDS			2. Min. head space.	
-	1. C and some pressule into helt made		3. Damaged chamber.	
Cause:	1. Guard screws protrude into bolt track.		4. Extractor interferes with shell rim.	
	2. Receiver plug screws protrude into bolt track		5. Ejector binds or fails to retract far enough	
	3. Bolt handle enterferes in stock.		<ol><li>Burr at ejector hole in bolt.</li></ol>	
	4. Damage at rear of bolt lugs.		<ol><li>Sharp corners in bolt lugs.</li></ol>	
Correction:	1. File end of screws.	Correction:	1. Ream.	
	2. File ends of screws.		2. Re-head.	
	3. Clear stock or fit new stock.		3. Re-head.	
	<ol><li>Stone to blend. Check head space.</li></ol>		4. Fit new extractor (grind relief in new ex	
			tractor behind claw).	
EJECTION			5. Free up or replace.	
		• ,	6. Deburr.	
Cause:	<ol> <li>Burr at ejector hole in bolt.</li> </ol>		7. Stone radius.	
	2. Ejector binds or fails to retract far enough.		-	
	3. Extractor binds.	COCKING (	See trigger Adjustment)	
Correction:	1. Deburr.			
	2. Free up or replace.	Cause:	1. Trigger adjusting screw at rear out of adjust	
	3 Adjust or fit new extractor (and rivet).		ment (improper horizontal engagement o	
			sear and connector.)	
BOLT PULLS OUT			2. Improper vertical engagement of sear and	
			connector.	
Cause:	1. Bolt stop or bolt release binds.		3. Trigger doesn't retract.	
Cause.	2. Bolt stop or bolt release broken.		4. Corners on sear or connector rounded	
	3. Bolt stop spring damaged.	Correction:	1. Adjust.	
Correction:	1. Free up.		2. Fit new trigger assembly.	
	2. Replace.		3. Fit new trigger assembly;	
	3. Replace.		4. Fit new sear and safety cam or connector.	
FEEDING		BULGES OF	R BLOWS CASES	
Cause:	1. Magazine follower binds.	Cause:	1. Oversize chamber.	
	2. Weak or defective follower spring.		2. Max. head space.	
	3. Magazine spring caught under guard.	Correction:	1. Replace barrel assembly.	
	4. Damaged chamfer on bolt head.		2. Fit new bolt.	
	5. Tabs on follower bent.			
Correction:	1. Adjust side angle on magazine.	SAFETY		
	2. Replace spring.			
	3. Correct.	Cause:	1. Safe binds (safe works hard).	
			<ol> <li>Safety snap washer stretches out (safe work</li> </ol>	
	4. Replace bolt, or stone smooth.		too freely).	
	5. Straighten or replace follower.		3. Safety damaged.	
		Correction:	1. Free up.	
			2. Replace washer or reseat in safety pivot pi	
			slot.	

slot. 3. Replace safety. •

## ACCURACY - Group Size

- Cause: 1. Crown of barrel damaged.
  - 2. Barrel bore fouled.
  - 3. Enlarged bore.
  - 4. Improper bedding of barrel in stock.
  - 5. Loose sights.

Correction: 1. Recrown.

- 2. Lead or replace barrel.
- 3. Replace barrel.
- 4. Refloat barrel.
- 5. Tighten or replace.

## POINT OF IMPACT

- 1. Barrel not straight.
- 2. Improper or loose sights.
- Correction;

Cause:

- 1. Straighten or replace barrel,
- 2. Tighten or change sights.

PARTS LIST

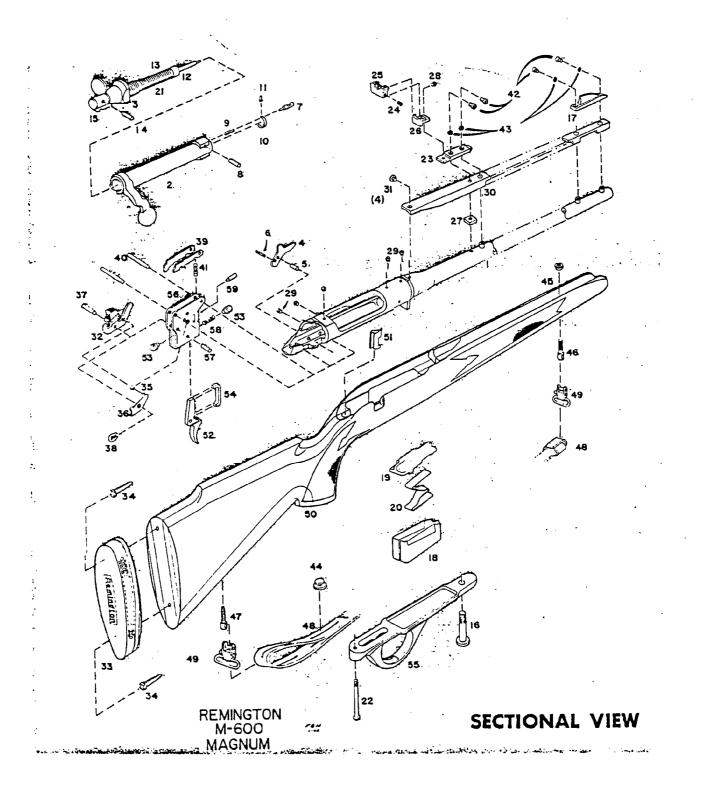
## MODEL 600

## REMINGTON FIELD SERVICE MANUAL

0.	Part No.	NAME OF PART	View Na.	Part No,	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Bar- rel, Barrel Bracket, Barrel Stud (6), Receiver)	32	26795	Safety Assembly (includes Safety and Safety Thumbpiece)
	26686	Barrel Assembly, 6.5 MM Rem. Mag.	33	21386	Recoil Pad (Magnum only)
	26680	Barrel Assembly, 308 Win. (includes Barrel,	34	25410	Recoil Pad Screw (Magnum only)
		Barrel Bracker, Barrel Stud (6), Receiver)	35	26850	Safety Detent Ball
2 26707	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem.	36	15432	Safety Detent Spring
Í.		Mag. (includes Bolt Body Assembly and Bolt	37	17043	Safety Pivot Pin
ł.		Handle)	38	17044	Safety Snap Washer :
	26705	Bolt Assembly, 308 Win. (includes Bolt Body	39	15666	Sear Safety Cam
		Assembly and Bolt Handle)	40	24476	Sear Pin
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM	41	17047	Sear Spring
		Rem. Mag. (includes Bolt Assembly, Ejector,	43	16968	Sight Washer
		Ejector Pin, Ejector Spring, Extractor, Extrac- tor Rivet, Firing Pin Assembly)			
	26700	Bolt Final Assembly, 308 Win. (includes Bolt	· ·	26990	Sling Strap Assembly and Mountings, Complete
	28700	Assembly, Ejector, Ejector Pin, Ejector Spring,			Includes: 44 thru 49
i.		Extractor, Etractor Rivet, Firing Pin Assembly)	44	15376	Fastener
	15409	Bolt Plug	45	15357	Front Swivel Nut
	15412	Bolt Plug Bolt Stop Bolt Stop Pin Bolt Stop Spring	46	15356	Front Swivel Screw
İ.	24484	Boit Stop Pin	47	15358	Rear Swivel Screw
•	15413	Bolt Stop Spring	48	26625	Rear Swivel Screw Sling Strap Assembly, 7/8" Swivel Assembly, Q.D. (each) Stock Assembly, 350 Rem. Mag. 6.5 MM Rem.
j.	15741	Bolt Stop Spring Butt Plate (Model 600 only) Butt Plate Screw (Model 600 only)	49	26555	Swivel Assembly, Q.D. (each)
]	25410	Butt Plate Screw (Model 600 only)	50	27651	crock Assembly, ose hern, magg, ore mill hern
ł.	17017	Ejector			Mag. (includes Recoil Pad, Recoil Pad Screw (2) Stack Surjust Screw
ļ	17676	Eector Pin		1	(2), Stock, Swivel Screw, Rear; Swivel Screw, Front: Front Swivel Nut, Reinforcing Screw)
÷.	17019	Ejector Spring		27650	Front; Front Swivel Nut, Reinforcing Screw) Stock Assembly (includes Butt Plate, Butt Plate
	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag		2/050	Screw (2), and Stock
	16254	Extractor	51	15883	Tang Support (Magnum only)
Ļ	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem.	52		Trigger
Í		Mag	53		Trigger Adjusting Screw
ł	27340	Extractor Rivet (except 222 Rem.)		26730	Trigger Assembly (includes Trigger Housing,
ļ	15410	Firing Pin Firing Rin Arrowbly Vincludes Bolt Plug Firing		}	Sear Safety Cam, Sear Spring, Trigger, Trig-
	26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)			ger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop
	17022	Firing Pin Cross Pin			Screw)
ì		Firing Pin Head	54	15436	Trigger Connector
	15053	Front Guard Screw	55	15437	Trigger Guard
		Front Sight Assembly (includes Front Sight and	56	15429	Trigger Housing
i		front Sight Bead)	57	24477	Trigger Pin Trigger Spring
3	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	59	17053	Trigger Spring Trigger Stop Screw
1	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	1 37	1,000	nigger sich seiem
	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM			
ļ	13071	Rem Mag.		ļ	ADDITIONAL CALIBER PARTS
. :	17056	Magazine Follower		1	
ļ		Magazine Spring Maio Socian		1	(Not Shown in Sectional View)
	17580	Main Spring Rear Guard Screw		26682	Barrel Assembly, 35 Rem (Superseded)
ļ	26841	Rear Sight Assembly lincludes Rear Sight Eleva-		26681	Barrel Assembly, 222 Rem.
208	20041	tion Screw, Rear Sight Base, Rear Sight Eye-	ł	26683	Barrel Assembly, 6 MM Rem.
		piece, Rear Sight Leaf, Rear Sight Windage	1	26685	Barrel Assembly, 243 Win.
		Screwi		26706	Bolt Assembly, 35 Rem. (Superseded)
1	15600	Rear Sight Base, 350 Rem. Mag.	1	26775	Bolt Assembly, 222 Rem.
İ	15727	Rear Sight Base		26701	Bolt Final Assembly, 35 Rem. (Superseded)
	15733	Rear Sight Elevation Screw		26770	Bolt Final Assembly, 222 Rem.
	15726	Rear Sight Eyepiece		15852	Ejector, 222 Rem.
	15728	Rear Sight Leaf		15850	Extractor, 222 Rem.
i	15418	Rear Sight Nut		27342	Extractor Rivet, 222 Rem.
1	15732	Rear Sight Windage Screw		27366	Front Sight Assembly, 6 MM Rem., 243 Win.
	15778	Rear Sight Wrench		27261	Magazine, 222 Rem.
2	17034	Receiver Plug Screw		27262	Magazine, 35 Rem. (Superseded)
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM	Í	16793	Magazine Follower, 222 Rem.
Ì		Rem. Mag.		15742	Magazine Spacer, 222 Rem.
. !	18186			17983	
	15488	Rib Rib Sama		15600	-
1	15417	Rib Screw		NOTE:	See basic Parts List for parts not listed above.
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l					

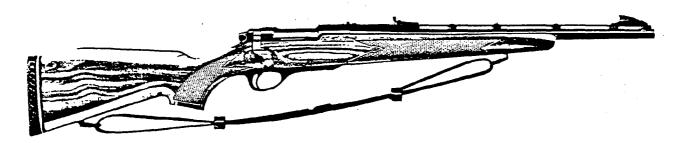
EXPLODED VIEW

REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly in structions from Standard Model 600, See Standard Model 600 for parts not listed.

#### MODEL 600 MAGNUM

1 .

STOCK ASSEMBLY  $\rightarrow$  is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service – Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replaceinent stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

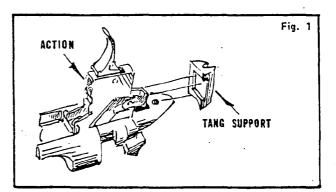
NOTE: Make certain tang support relocated property at rear of action before stock is reassembled. See TANG SUPPORT'

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



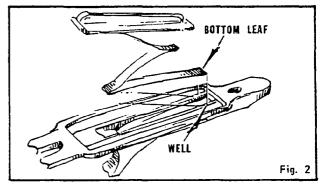
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble – Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



Turn both guard screws to tighten guard and stock securely to action.

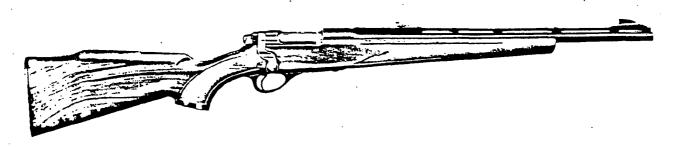
MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ——— and insures full magnum cartridge in magazine.

To Reassemble – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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#### Bolt Final Assembly ------Bolt Final Assembly, Components Firing Pin Assembly from Bolt Assembly Ejector - Ejector Spring Extractor - Extractor Rivet Firing Pin Assembly, Components Front Sight Assembly Rear Sight Assembly Rear Sight Assembly, Components Rib ..... Trigger Guard -----Stock Assembly -----Stock Assembly, Components Magazine Assembly -----Magazine Follower Magazine Spring .....

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

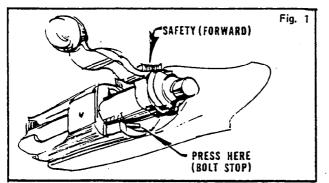
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#### MODEL 600

#### BOLT FINAL ASSEMBLY

To Disassemble – Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service – The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun) – Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; the turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

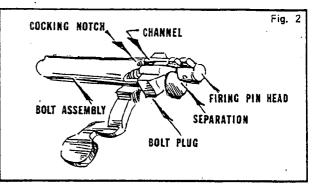
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

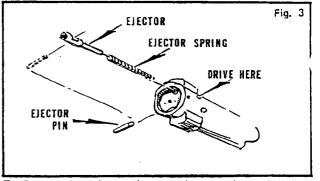
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into to position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

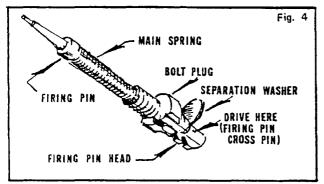
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened ex. tractor and disassemble from inside of bolt rim.

To Service – Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet insde bolt rim; then – peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

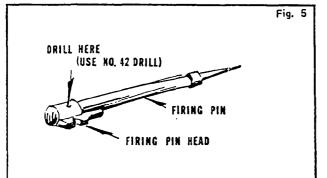
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service —All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY – Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassembly rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** – includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

RIB - is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble - Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble – Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard, Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble – Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

#### BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service - Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magainze support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER – is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY – in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

To Disassemble – Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Exploded View.

To Reassemble - Follow reverse order.

TRIGGER ASSEMBLY – is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

To Disassemble – Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver.

To Service – Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

To Reassemble — Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY - COMPONENTS - See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY — is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of spring—loaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

To Disassemble – Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and satety cam. Shake out underlying sear spring.

To Service – Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.

To Reassemble - Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage flat end of sear spring upwards against sear and safety cam. Closed end of sear spring seats into housing.

#### TRIGGER & TRIGGER CONNECTOR

To Disassemble – Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.

Note: Care must be taken to prevent dislodging trigger spring.

To Service – Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.

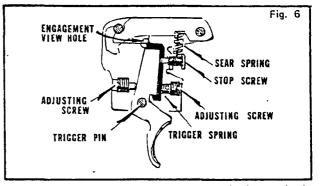
To Reassemble – Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

#### TRIGGER HOUSING

To Disassemble – Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2) trigger stop screw.

To Reassemble – Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - (See Fig. 6). Remove stock assembly and trigger guard.



IMPORTANT: No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).

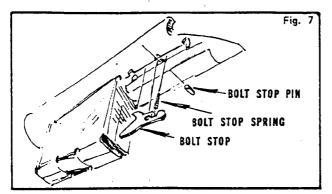
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

Pull of Trigger – is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

Travel of trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin will fall or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

#### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. (See Fig. 7). Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Reassemble - Follow reverse order. Make sure bolt stop spring locates properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

BARREL ASSEMBLY – is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service — Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick – detachable (Q. D. ) type.

ASSEMBLE - SWIVEL SCREWS TO STOCK

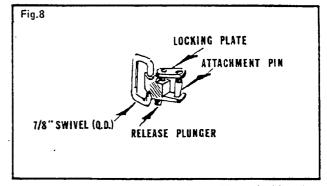
Rear Swivel Screw – Use No. 15 size drill(.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw – Use No. 13 drill. Front Swivel Nut – Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at 90° with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightend to stock with front swivel nut.

#### ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 8).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable ( $\Omega$ . D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

#### CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector, As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplised by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety had two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS

### **Cause and Correction**

#### FIRING

1. Firing pin damaged.
2. Firing pin binds.
3. Firing pin protrusion faulty.
4. Trigger assembly out of adjustment.
5. Faulty ammunition.
1. Replace.
2. Free up or replace.
3. Replace firing pin.
4. Adjust.
5. Replace ammunition.

#### UNLOCKING

- Cause:1. See Extraction.2. Upset extraction cam on bolt handle.3. Burr at ejector hole in bolt.4. Blown or set back primer on shell.Correction:1. See Extraction.
  - 2. Smooth up bolt handle cam.
    - 3. Deburr.
    - 4. Ammunition may be at fault.

## MODEL 600

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EXTRACTIC	N	LOADING	
Cause:	1. Fouled, rough, or enlarged chamber.	Cause:	1. Damaged receiver rails.
	<ol><li>Extractor broken or damaged.</li></ol>		<ol><li>Sharp edge— rear end of chamber.</li></ol>
	3. Not enough hook space on extractor.		3. Rough loading ramp in receiver.
	4. Height of claw not correct.	Correction:	1. Polish or reshape.
Correction:	1. Polish if fouled or rough. Replace barrel as-		2. Remove sharpness.
	sembly if enlarged.		3. Polish ramp.
	2. Fit new extractor and rivet.		
	3. Fit new extractor and rivet.	LOCKING	
	4. Fit new extractor and rivet.		
		Cause:	1. Shallow throat.
BOLT BINDS	<b>b</b>		2. Min. head space.
-	1. Current second second into helt track		3. Damaged chamber.
Cause:	1. Guard screws protrude into bolt track.		4. Extractor interferes with shell rim.
	2. Receiver plug screws protrude into bolt track		<ol> <li>5. Ejector binds or fails to retract far enough</li> </ol>
	3. Bolt handle enterferes in stock.		6. Burr at ejector hole in bolt.
	4. Damage at rear of bolt lugs.		7. Sharp corners in bolt lugs.
Correction:	1. File end of screws.	Correction:	1. Ream.
	2. File ends of screws.		2. Re-head.
	3. Clear stock or fit new stock.		3. Re-head.
	<ol><li>Stone to blend. Check head space.</li></ol>		4. Fit new extractor (grind relief in new ex
			tractor behind claw).
EJECTION			5. Free up or replace.
			6. Deburr.
Cause:	<ol> <li>Burr at ejector hole in bolt.</li> </ol>		7 Stone radius.
	2. Ejector binds or fails to retract far enough.		
	3. Extractor binds.	COCKING (	See trigger Adjustment)
Correction:	1. Deburr.		
	2. Free up or replace.	Cause:	1. Trigger adjusting screw at rear out of adjust
	3. Adjust or fit new extractor (and rivet).		ment (improper horizontal engagement o
	,		sear and connector.)
BOLT PULL	S OUT		2. Improper vertical engagement of sear and
0021 002			connector.
Cause:	1. Bolt stop or bolt release binds.		3. Trigger doesn't retract.
Cause.	2. Bolt stop or bolt release broken.		4. Corners on sear or connector rounded.
	3. Bolt stop spring damaged.	Correction:	1. Adjust.
Correction:	1. Free up.		2. Fit new trigger assembly.
Correction.	2. Replace.		3. Fit new trigger assembly;
	3. Replace.		4. Fit new sear and safety cam or connector.
FEEDING	•	BULGES OF	R BLOWS CASES
Cause:	1. Magazine follower binds.	Cause:	1. Oversize chamber.
	2. Weak or defective follower spring.		2. Max. head space.
	3. Magazine spring caught under guard.	Correction:	1. Replace barrel assembly.
	<ol><li>Damaged chamfer on bolt head,</li></ol>		2. Fit new bolt.
	5. Tabs on follower bent.		
Correction:	1. Adjust side angle on magazine.	SAFETY	
	2. Replace spring.		
	3. Correct.	Cause:	1. Safe binds (safe works hard).
	4. Replace bolt, or stone smooth.		2. Safety snap washer stretches out (safe work
	5. Straighten or replace follower.		too freely).
	e, et algitan en replace fonower,		3. Safety damaged.
		Correction:	1. Free up.
			2. Replace washer or reseat in safety pivot pi
			slot.
			2 Destance of the

3. Replace safety.

#### ACCURACY - Group Size

- Cause: 1. Crown of barrel damaged.
  - 2. Barrel bore fouled.
  - 3. Enlarged bore.
  - 4. Improper bedding of barrel in stock.

5. Loose sights.

Correction: 1. Recrown.

- 2. Lead or replace barrel.
- 3. Replace barrel.
- 4. Refloat barrel.
- 5. Tighten or replace.

#### POINT OF IMPACT

Cause:

1. Barrel not straight.

- 2. Improper or loose sights. Correction;
  - 1. Straighten or replace barrel.
  - 2. Tighten or change sights.

PARTS LIST

MODEL 600

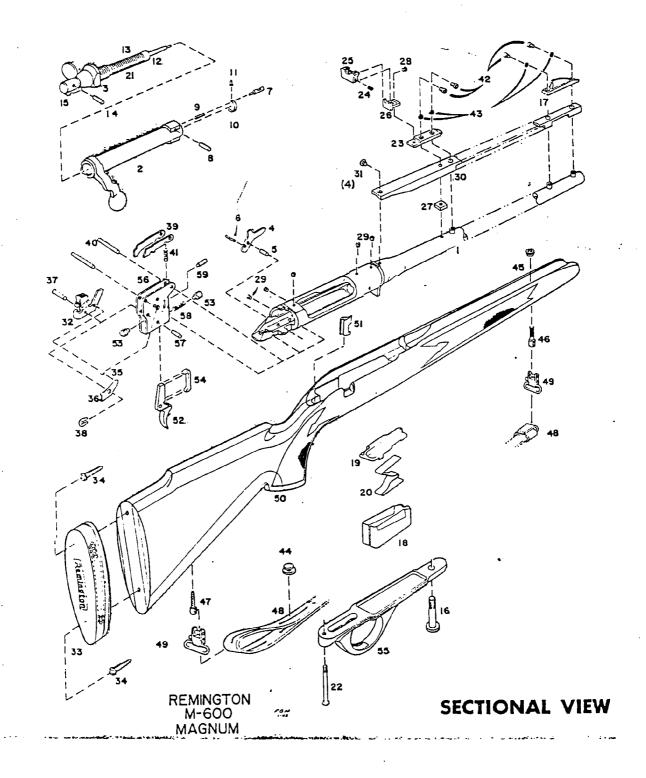
## REMINGTON FIELD SERVICE MANUAL

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No.	No.	NAME OF PART	No.	No.	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Bar- rel, Barrel Bracket, Barrel Stud (ó), Receiver)	32	26795	Safety Assembly (includes Safety and Safety Thumbpiece)
	26686	Barrel Assembly, 6.5 MM Rem. Mag.	33	21386	Recoil Pad (Magnum only)
i	26680	Barrel Assembly, 308 Win. (includes Barrel,	34	25410	Recoil Pad Screw (Magnum only)
1		Barrel Bracket, Barrel Stud (6), Receiver)	35	26850	Safety Detent Ball
1	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem.	36	15432	Safety Detent Spring Safety Pivot Pin
		Mag. (includes Bolt Body Assembly and Bolt	37	17043	Safety Pivot Pin
		Handle)	38	17044	Safety Snap Washer
	26705	Bolt Assembly, 308 Win. (includes Bolt Body	39	15666	Sear Safety Cam
		Assembly and Bolt Handle)	40	24476	Sear Pin
1	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM	41	17047	Sear Spring Sight Screw
Í		Rem. Mag. (includes Bolt Assembly, Ejector,	42	15416	Sight Screw
		Ejector Pin, Ejector Spring, Extractor, Extrac-	43	16968	Sight Washer
		tor Rivet, Firing Pin Assembly)		26990	Sling Strap Assembly and Mountings, Complete
E	26700				Includes: 44 thru 49
		Assembly, Ejector, Ejector Pin, Ejector Spring,	44	15376	Fastener
1		Extractor, Etractor River, Firing Pin Assembly)	45	15357	Frank Sectoral Net
1	15409	Bolt Plug Bolt Stop Pin Bolt Stop Spring	45	15356	Front Swivel Nut Front Swivel Screw
1	15412	Bolt Stop	40	15358	Front Swivel Screw
	24484	Bolt Stop Pin	47		
1	15413	Bolt Stop Spring		26625	Sling Strap Assembly, 7/8" Swivel Assembly, Q.D. (each)
	15741	Bolt Stop Spring Butt Plate (Model 600 only) Butt Plate Screw (Model 600 only)	49	26555	Shark Assembly, Q.D. (each)
	25410		50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem.
	17017	Elector			Mag. (includes Recoil Pad, Recoil Pad Screw
	17676	Eector Pin			(2), Stock, Swivel Screw, Rear; Swivel Screw,
	17019	Ejector Spring		27450	Front; Front Swivel Nut, Reinforcing Screw)
1	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag	1	27650	Stock Assembly (includes Butt Plate, Butt Plate
i	10254	Extractor	6.	1 6002	Screw (2), and Stock)
	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem.	51	15883	Tang Support (Magnum only)
		Mag.	52	15435	Trigger
ł	27340	Extractor Rivet (except 222 Rem.)	55		Trigger Adjusting Screw
	15410	Firing Pin		267.30	Trigger Assembly (includes Trigger Housing,
3		Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)			Sear Safety Cam, Sear Spring, Trigger, Trig- ger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop
	17022	Firing Pin Cross Pin	6	16424	Screw)
	23321	firing Pin Head	54	15436	Trigger Connector
	15653	Front Guard Screw	55	15437	Trigger Guard
7	27365	Front Sight Assembly (includes Front Sight and	56	15429	Trigger Housing
. 1		Front Sight Bead)	58	17978	Trigger Pin
3	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	59	17053	Trigger Spring Trigger Stop Screw
. 1	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	37	17033	Trigger Stop Screw
	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM			
		Rem. Mag.			
. 1	17056	Magazine follower			ADDITIONAL CALIBER PARTS
	17891	Magazine Spring			(Not Shown in Sectional View)
	15411	Main Spring		a	
	17580	Rear Guard Screw		26682	Barrel Assembly, 35 Rem (Superseded)
	26841	Rear Sight Assembly (includes Rear Sight Eleva-		26681	Barrel Assembly, 222 Rem.
í		tion Screw, Rear Sight Base, Rear Sight Eye		26683	Barrel Assembly, 6 MM Rem.
ł		piece, Rear Sight Leaf, Rear Sight Windage		26685	Barrel Assembly, 243 Win.
1	16400	Screw)	1	26706	Bolt Assembly, 35 Rem. (Superseded)
!	15600	Rear Sight Base, 350 Rem. Mag.		26775	Bolt Assembly, 222 Rem.
	15727	Rear Sight Base		26701	Bolt Final Assembly, 35 Rem. (Superseded)
	15733	Rear Sight Elevation Screw		26770	Bolt Final Assembly, 222 Rem.
	15726	Rear Sight Eyeptece		15852	Ejector, 222 Rem.
i	15728	Rear Sight Leaf	1	15850	Extractor, 222 Rem.
	15418				Extractor River, 222 Rem.
	15732	Rear Sight Windage Screw		27366	Front Sight Assembly, 6 MM Rem., 243 Win.
i	15778	Rear Sight Wrench		27261	Magazine, 222 Rem.
1	17034	Receiver Plug Screw		27262	Magazine, 35 Rem. (Superseded)
1	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM			Magazine Follower, 222 Rem.
	19194	Rem. Mag		15742	Magazine Spacer, 222 Rem.
į.	18186			17983	Magazine Spring, 222 Rem.
		Rib		15600	Rear Sight Base, 35 Rem. (Superseded)
;	15417	Rib Screw		NOTE: S	See basic Parts List for parts not listed above.
			1	1	
4					
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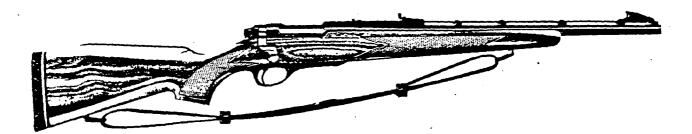
EXPLODED VIEW

REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

#### MODEL 600 MAGNUM

STOCK ASSEMBLY — is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service – Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

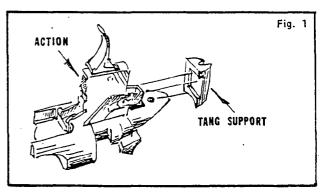
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT\*

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble - Remove stock assembly, Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



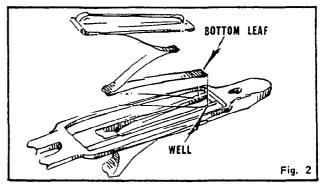
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble – Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



Turn both guard screws to tighten guard and stock securely to action.

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ---- and insures full magnum cartridge in magazine.

To Reassemble – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

MODEL 600 - FIELD SERVICE MANUAL

FROM 1973 MANUAL

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FROM 1973 FIELD MANUAL

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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Extractor – Extractor Rivet
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Magazine Assembly
Magazine Follower
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Magazine Spring

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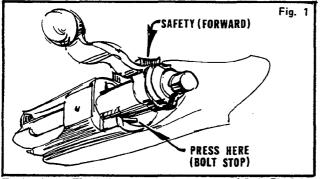
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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602 Page

#### BOLT FINAL ASSEMBLY

To Disassemble – Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service – The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun) – Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; the turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

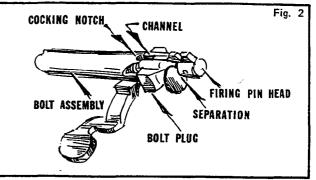
**BOLT FINAL ASSEMBLY – COMPONENTS – Include Bolt** Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly – which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

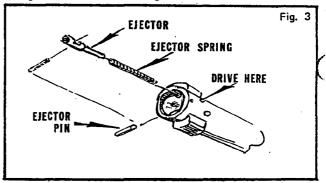
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into to position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

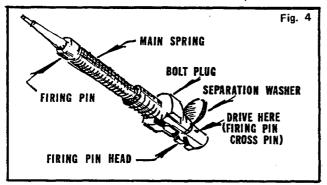
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service – Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet insde bolt rim; then – peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

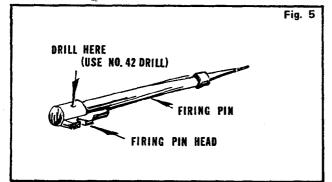
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service –All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY – Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassembly rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** — includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

#### REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

**RIB** – is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble – Follow reverse order. taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble -- Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

#### BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service – Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY — is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magainze support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble - Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER – is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY — in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

To Disassemble – Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Exploded View.

To Reassemble - Follow reverse order.

TRIGGER ASSEMBLY — is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

To Disassemble – Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver.

To Service – Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

To Reassemble – Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

**TRIGGER ASSEMBLY – COMPONENTS –** See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY — is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of spring—loaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

To Disassemble – Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring.

To Service – Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.

To Reassemble – Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage flat end of sear spring upwards against sear and safety cam. Closed end of sear spring seats into housing.

#### **TRIGGER & TRIGGER CONNECTOR**

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To Disassemble – Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.

Note: Care must be taken to prevent dislodging trigger spring.

To Service — Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.

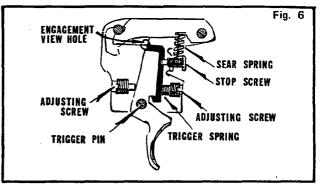
To Reassemble – Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

#### **TRIGGER HOUSING**

To Disassemble – Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2) trigger stop screw.

To Reassemble - Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - (See Fig. 6). Remove stock assembly and trigger guard.



**IMPORTANT:** No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).

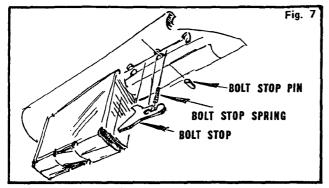
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

Pull of Trigger – is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

Travel of trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire " as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin will fall or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

#### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. (See Fig. 7). Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Reassemble – Follow reverse order. Make sure bolt stop spring locates properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

BARREL ASSEMBLY — is factory—listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble – Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick – detachable (Q. D. ) type.

#### ASSEMBLE - SWIVEL SCREWS TO STOCK

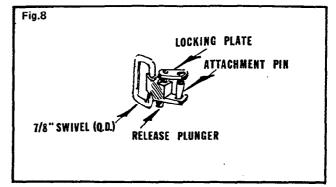
**Rear Swivel Screw** – Use No. 15 size drill(.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw – Use No. 13 drill. Front Swivel Nut – Use 3/8 inch drill. Locate screw hole approx. 3 inches from front end of stock.

Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightend to stock with front swivel nut.

#### ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 8).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable ( $\Omega$ . D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

#### CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from re-<sup>(</sup> coil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring—loaded ejector, As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver. allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplised by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety had two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS

#### **Cause and Correction**

#### FIRING

Cause:	<ol> <li>Firing pin damaged.</li> <li>Firing pin binds.</li> <li>Firing pin protrusion faulty.</li> <li>Trigger assembly out of adjustment.</li> <li>Faulty ammunition.</li> </ol>
Correction:	<ol> <li>Replace.</li> <li>Free up or replace.</li> <li>Replace firing pin.</li> <li>Adjust.</li> <li>Replace ammunition.</li> </ol>

#### UNLOCKING

- Cause: 1. See Extraction.
  - 2. Upset extraction cam on bolt handle.
  - 3. Burr at ejector hole in bolt.
  - 4. Blown or set back primer on shell.
- Correction: 1. See Extraction.
  - 2. Smooth up bolt handle cam.
  - 3. Deburr.
  - 4. Ammunition may be at fault.

## MODEL 600

EXTRACTIO	ON	LOADING	
Cause:	<ol> <li>Fouled, rough, or enlarged chamber.</li> <li>Extractor broken or damaged.</li> </ol>	Cause:	1. Damaged receiver rails. 2. Sharp edge- rear end of chamber.
	3. Not enough hook space on extractor.	<b>0</b>	3. Rough loading ramp in receiver.
Correction:	<ol> <li>Height of claw not correct.</li> <li>Polish if fouled or rough. Replace barrel as-</li> </ol>	Correction:	1. Polish or reshape. 2. Remove sharpness.
confection.	sembly if enlarged.		3. Polish ramp.
	2. Fit new extractor and rivet.		
	3. Fit new extractor and rivet.	LOCKING	
	4. Fit new extractor and rivet.		
	·	Cause:	1. Shallow throat.
BOLT BIND	S		2. Min. head space.
Cause:	1. Guard screws protrude into bolt track.		3. Damaged chamber.
Guase.	2. Receiver plug screws protrude into bolt track		4. Extractor interferes with shell rim.
	3. Bolt handle enterferes in stock.		5. Ejector binds or fails to retract far enough. 6. Burr at ejector hole in bolt.
	4. Damage at rear of bolt lugs.		7. Sharp corners in bolt lugs.
Correction:	1. File end of screws.	Correction:	1. Ream.
	2. File ends of screws.		2. Re-head.
	3. Clear stock or fit new stock.		3. Re-head.
	<ol><li>Stone to blend. Check head space.</li></ol>		4. Fit new extractor (grind relief in new ex-
ELECTION			tractor behind claw).
EJECTION			5. Free up or replace.
Cause:	1. Purr at algestar hale in halt		6. Deburr.
Cause:	<ol> <li>Burr at ejector hole in bolt.</li> <li>Ejector binds or fails to retract far enough.</li> </ol>		7. Stone radius.
	3. Extractor binds.	COCKING (	See trigger Adjustment)
Correction:	1. Deburr.	COCKING	see myger Aufustment
	2. Free up or replace.	Cause:	1. Trigger adjusting screw at rear out of adjust
	3. Adjust or fit new extractor (and rivet).		ment (improper horizontal engagement of
			sear and connector.)
BOLT PULI	LS OUT		<ol> <li>Improper vertical engagement of sear and connector.</li> </ol>
Cause:	1. Bolt stop or bolt release binds.		3. Trigger doesn't retract.
	2. Bolt stop or bolt release broken.		4. Corners on sear or connector rounded.
Correction:	3. Bolt stop spring damaged.	Correction:	1. Adjust.
Correction:	1. Free up. 2. Replace.		2. Fit new trigger assembly.
	3. Replace.		<ol> <li>Fit new trigger assembly;</li> <li>Fit new sear and safety cam or connector.</li> </ol>
	J. Acplace.		4. Fit new sear and safety cam or connector.
FEEDING		BULGES OF	BLOWS CASES
Cause:	1. Magazine follower binds.	Cause:	1. Oversize chamber.
	2. Weak or defective follower spring.		2. Max. head space.
	3. Magazine spring caught under guard.	Correction:	1. Replace barrel assembly.
	4. Damaged chamfer on bolt head.		2. Fit new bolt.
<b>C</b>	5. Tabs on follower bent.	0.4 55714	
Correction:	1. Adjust side angle on magazine.	SAFETY	
	2. Replace spring. 3. Correct.	Cause:	1 Safe hinds (safe works hard)
	4. Replace bolt, or stone smooth.	vause.	<ol> <li>Safe binds (safe works hard).</li> <li>Safety snap washer stretches out (safe works</li> </ol>
	5. Straighten or replace follower.		too freely).
			3. Safety damaged.
		Correction:	1. Free up.
			2. Replace washer or reseat in safety pivot pin
			clot

slot. 3. Replace safety.

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#### ACCURACY - Group Size

- Cause:
- 1. Crown of barrel damaged.
- 2. Barrel bore fouled.
- 3. Enlarged bore.
- 4. Improper bedding of barrel in stock.
- 5. Loose sights.

Correction: 1. Recrown.

- 2. Lead or replace barrel.
- 3. Replace barrel.
- 4. Refloat barrel.
- 5. Tighten or replace.

#### POINT OF IMPACT

- Cause:
- 1. Barrel not straight.
- Correction;

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- 2. Improper or loose sights.
- 1. Straighten or replace barrel.
- 2. Tighten or change sights.

PARTS LIST

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## REMINGTON FIELD SERVICE MANUAL

View No.	Part No.	NAME OF PART	Viev		NAME OF PART	
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Bar-	32	26795		
	26686	rel, Barrel Bracket, Barrel Stud (6), Receiver) Barrel Assembly, 6.5 MM Rem. Mag	33	21386	Thumbpiece) Recoil Pad (Magnum only)	
	26680	Barrel Assembly, 308 Win. (includes Barrel,	34	25410	Recoil Pad Screw (Magnum only)	
	20000	Barrel Bracket, Barrel Stud (6), Receiver)	35	26850	Safety Detent Ball	
2	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem.	36	15432	Safety Detent Spring	
	-	Mag. (includes Bolt Body Assembly and Bolt	37	17043	Safety Pivat Pin	
		Handle)	38	17044	Safety Snap Washer	
	26705	Bolt Assembly, 308 Win. (includes Bolt Body	39	15666	Sear Safety Cam	
	04700	Assembly and Bolt Handle)	40	24476	Sear Pin	
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Assembly, Ejector,	41	17047	Sear SpringSight Screw	
		Ejector Pin, Ejector Spring, Extractor, Extrac-	43	16968	Sight Washer	
1		tor Rivet, Firing Pin Assembly)	1 -0	26990	Sling Strap Assembly and Mountings, Complete	
	26700	Bolt Final Assembly, 308 Win. (includes Bolt.		20770		
		Assembly, Ejector, Ejector Pin, Ejector Spring,	1	1.007/	Includes: 44 thru 49	
		Extractor, Etractor Rivet, Firing Pin Assembly)	44	15376	Fastener	
3	15409	Bolt Plug	45	15357	Front Swivel Nut	
4	15412	Bolt Stop	47	15358	Rear Swivel Screw	
5	24484	Bolt Stop Pin	48	26625	Sling Strap Assembly, 7/8"	
۲,	15741	Bolt Stop Spring Butt Plate (Model 600 only)	49	26555	Swivel Assembly, Q.D. (each)	
	25410	Butt Plate Screw (Model 600 only)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem.	
7	17017	Ejector			Mag. (includes Recoil Pad, Recoil Pad Screw	
8	17676	Eector Pin			(2), Stock, Swivel Screw, Rear; Swivel Screw,	
9	17019	Ejector Spring	1	07/50	Front; Front Swivel Nut, Reinforcing Screw)	
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag		27650	Stock Assembly (includes Butt Plate, Butt Plate	
	16254	Extractor	51	15883	Screw (2), and Stock) Tang Support (Magnum, only)	
ΠĮ	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem.	52	15435	Trigger	
	27340	Mag Extractor Rivet (except 222 Rem.)	53	17049	Trigger Adjusting Screw	~
2	15410	Firing Pin		26730	Trigger Assembly (includes Trigger Housing,	- {
13	26715	Firing Pin Assembly (includes Bolt Plug, Firing			Sear Safety Cam, Sear Spring, Trigger, Trig-	Ń
		Pin, Firing Pin Cross Pin, Firing Pin Head,			ger Adjusting Screw. (2), Trigger Connector,	
		Main Spring)			Trigger Pin, Trigger Spring, Trigger Stop	
	17022	Firing Pin Cross Pin	54	15424	Screw)	
	23321	Firing Pin Head	55	15436	Trigger Connector Trigger Guard	
16 17	15653 27365	Front Guard Screw	56	15429	Trigger Housing	
<b>'</b>	27305	Front Sight Assembly (includes Front Sight and Front Sight Bead)	57	24477	Trigger Pin	
18	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	58	17978	Trigger Spring	
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	59	17053	Trigger Stop Screw	
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM				
		Rem. Mag.				
	17056	Magazine Follower			ADDITIONAL CALIBER PARTS	
	17891	Magazine Spring			(Not Shown in Sectional View)	
	15411 17580	Main Spring Rear Guard Screw	1	26682	Barrel Assembly, 35 Rem (Superseded)	
	26841	Rear Sight Assembly (includes Rear Sight Eleva-		26681	Barrel Assembly, 222 Rem.	
		tion Screw, Rear Sight Base, Rear Sight Eye-		26683	Barrel Assembly, 6 MM Rem.	
		piece, Rear Sight Leaf, Rear Sight Windage		26685	Barrel Assembly, 243 Win.	
		Screw)		26706	Bolt Assembly, 35 Rem. (Superseded)	
	15600	Rear Sight Base, 350 Rem. Mag.		26775	Bolt Assembly, 222 Rem.	
	15727	Rear Sight Base		26701	Bolt Final Assembly, 35 Rem. (Superseded)	
	15726	Rear Sight Elevation Screw		26770 15852	Bolt Final Assembly, 222 Rem.	
	15728	Rear Sight Eyepiece Rear Sight Leaf		15850	Ejector, 222 Rem Extractor, 222 Rem	
	15418	Rear Sight Nut		27342	Extractor Rivet, 222 Rem.	
	15732	Rear Sight Windage Screw		27366	Front Sight Assembly, 6 MM Rem., 243 Win.	
	15778	Rear Sight Wrench		27261	Magazine, 222 Rem.	
9	17034	Receiver Plug Screw		27262	Magazine, 35 Rem. (Superseded)	
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM		16793	Magazine Follower, 222 Rem.	
	19194	Rem. Mag.		15742	Magazine Spacer, 222 Rem.	
	18186 15488	Reinforcing Screw		17983 15600	Magazine Spring, 222 Rem.	
	15417	Rib Screw			Rear Sight Base, 35 Rem. (Superseded)	
·				NUIE: 3	See basic Parts List for parts not listed above.	
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REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.

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This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed. STOCK ASSEMBLY — is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply ---- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service — Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

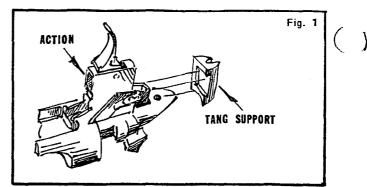
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT'

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



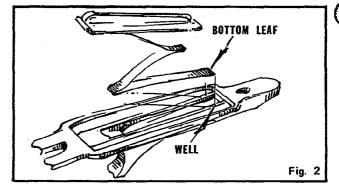
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble – Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



Turn both guard screws to tighten guard and stock securely to action.

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ---- and insures full magnum cartridge in magazine.

To Reassemble – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

## MODEL 6000 - FIELD SERVICE MANUAL

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MARCH - 1976

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## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

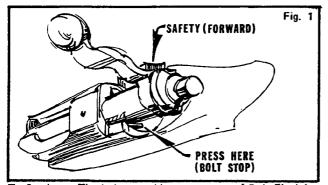
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#### BOLT FINAL ASSEMBLY

To Disassemble – Push safety assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward. (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service — The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun) – Push safety forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement; the turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

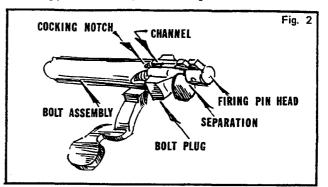
BOLT FINAL ASSEMBLY – COMPONENTS – Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly – which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

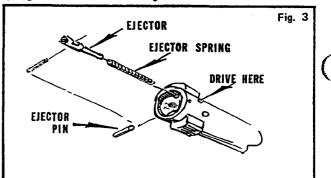
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

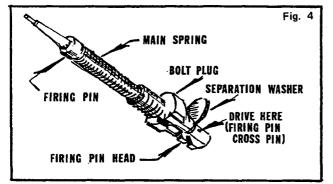
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service – Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet insde bolt rim; then – peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).

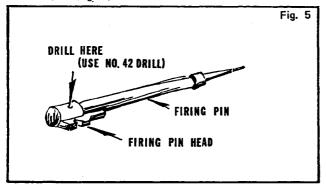


Precaution: Main spring is under tension.

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To Service —All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

**FRONT SIGHT ASSEMBLY** – Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassembly rear sight assembly from rib on barrel.

To Service — Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** – includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

#### REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

**RIB** – is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

**To Reassemble** – Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble - Follow reverse order. Tighten guard screws securely.

**STOCK ASSEMBLY - COMPONENTS** 

#### BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service – Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magainze support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER — is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

SAFETY ASSEMBLY — in rear, ON SAFE stop position, to (1) support safety cam against cocked firing pin head and prevent release, (2) to cam up and prevent closed bolt from rotating to open action. In safety a nylon detent ball, under tension, slips into either detent position in trigger assembly.

To Disassemble – Remove bolt final assembly. Remove trigger guard. Remove stock assembly. Slide off and disassemble safety snap washer. Lift off and disassemble safety detent spring. Pull out and disassemble safety pivot pin. Disassemble small nylon safety detent ball from hole position in safety assembly. Slide loosened safety assembly to rear and disassemble from trigger assembly. See Exploded View.

To Reassemble - Follow reverse order.

TRIGGER ASSEMBLY – is designed to house the fire control parts of the action. These parts include housing, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw, and sear pin (2).

To Disassemble – Remove bolt final assembly and trigger guard. Remove stock assembly. Tap out sear pin (2), left to right. Pull out and disassemble trigger assembly from receiver.

To Service – Trigger assembly may be replaced as a complete interchangeable assembly. See listing above. When ordered, slave pins (2) hold sear and safety cam assembly in housing. Remove slave pin (2) and use existing sear pin (2) to assemble trigger assembly to receiver. No adjustment required.

To Reassemble – Hold sear and safety cam assembly in housing to align sear pin holes to receiver. Insert sear pin (2). Make sure pins do not protrude into bolt stop slot in receiver. Seat pins only flush with this slot.

TRIGGER ASSEMBLY – COMPONENTS – See below for component listing (in sequence).

SEAR AND SAFETY CAM ASSEMBLY — is matched set of components. An engaging surface at rear shoulder of both is ground to bear equally against cocking notch in firing pin head. (1) The safety cam part when supported from beneath by safety engages firing pin head to hold head in cocked position. This ON SAFE support by safety cam prevents release of spring—loaded firing pin, hence no "firing" can occur. (2) The "matched" engaging surface on sear part also when supported from beneath by trigger connector cannot release the spring loaded firing pin for "firing" unless connector is pulled by trigger out of engagement with sear.

To Disassemble – Remove trigger assembly. See TRIGGER ASSEMBLY removal. Lift away and disassemble loosened sear and safety cam. Shake out underlying sear spring.

To Service – Interchangeable as "matched" assembly. However, re-adjustment of trigger connector engagement may be required.

To Reassemble – Follow reverse order. Make sure sear spring reassembles to function properly under sear and safety cam. Engage flat end of sear spring upwards against sear and safety cam. Closed end of sear spring seats into housing.

#### **TRIGGER & TRIGGER CONNECTOR**

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To Disassemble – Remove stock assembly. Remove magazine assembly. Tap out trigger pin. Pull out and disassemble loosened trigger and trigger connector.

Note: Care must be taken to prevent dislodging trigger spring.

To Service – Both trigger and trigger connector are interchangeable. No factory adjustment required. However, a check for trigger pull and weight may be required. See TRIGGER ADJUSTMENT.

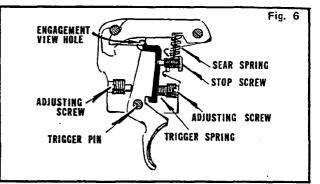
To Reassemble – Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble trigger pin and tap into housing.

#### TRIGGER HOUSING

To Disassemble – Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2) trigger stop screw.

To Reassemble – Follow reverse order. Restake adjusting screws to secure in location.

TRIGGER ADJUSTMENT - (See Fig. 6). Remove stock assembly and trigger guard.



**IMPORTANT:** No adjustment or removal of trigger adjusting screw at rear is recommended unless for replacement. This trigger adjusting screw at rear is adjusted at factory and provides correct amount of supporting trigger connector engagement beneath sear. This engagement of sear to top of trigger connector can be seen thru hole in housing (with safety forward in FIRE position).

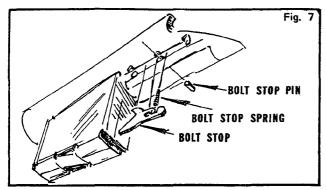
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

Pull of Trigger – is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

Travel of trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel; place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off stop screw counter clockwise until firing pin will fall or gun "fire". This method of adjustment will allow least amount of trigger overtravel.

#### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove stock assembly. Partially disassemble trigger assembly by tapping out sear pin only at front of assembly. Drop trigger assembly only enough to clear bolt stop pin hole in receiver. (See Fig. 7). Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Reassemble – Follow reverse order. Make sure bolt stop spring locates properly in bolt stop notch and seats correctly against receiver in bolt slot. Reassemble trigger assembly to receiver.

BARREL ASSEMBLY – is factory-listed to include barrel, barrel bracket, barrel stud (6), receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick – detachable (Q. D.) type.

ASSEMBLE - SWIVEL SCREWS TO STOCK

Rear Swivel Screw – Use No. 15 size drill(.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock. Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

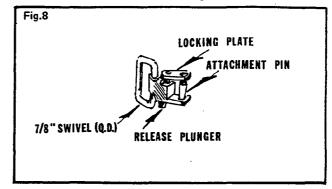
Front Swivel Screw – Use No. 13 drill. Front Swivel Nut – Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightend to stock with front swivel nut.

NOTE: After all reassembling and / or adjustments see safety performance check.

ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 8).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position.

Note: To disassemble strap from rifle, simply unsnap quick detachable ( $\Omega$ . D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

#### CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully, back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring—loaded ejector, As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver. allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

### LOCKING

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Locking cycle is accomplised by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

### SAFETY

The safety button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety had two intentional functions. When safety button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety button forward to FIRE position nullifies above conditions and will allow firing.

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurrence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS

### **Cause and Correction**

#### FIRING

Cause:	1. Firing pin damaged.
	2. Firing pin binds.
	3. Firing pin protrusion faulty.
	4. Trigger assembly out of adjustment.
	5. Faulty ammunition.
Correction:	1. Replace.
	2. Free up or replace.
	3. Replace firing pin.
	4. Adjust.

5. Replace ammunition.

#### UNLOCKING

Correction:

- Cause: 1. See Extraction.
  - 2. Upset extraction cam on bolt handle.
  - 3. Burr at ejector hole in bolt.
  - 4. Blown or set back primer on shell.
  - 1. See Extraction.
  - 2. Smooth up bolt handle cam.
  - 3. Deburr.
  - 4. Ammunition may be at fault.

## MODEL 600

EXTRACTIO	N	LOADING	
Cause:	<ol> <li>Fouled, rough, or enlarged chamber.</li> <li>Extractor broken or damaged.</li> <li>Not enough hook space on extractor.</li> <li>Hoight of algoright context.</li> </ol>	Cause: Correction:	<ol> <li>Damaged receiver rails.</li> <li>Sharp edge- rear end of chamber.</li> <li>Rough loading ramp in receiver.</li> <li>Polish or reshape.</li> </ol>
Correction:	<ol> <li>Height of claw not correct.</li> <li>Polish if fouled or rough. Replace barrel assembly if enlarged.</li> </ol>		2. Remove sharpness. 3. Polish ramp.
	<ol> <li>2. Fit new extractor and rivet.</li> <li>3. Fit new extractor and rivet.</li> <li>4. Fit new extractor and rivet.</li> </ol>	LOCKING	
BOLT BINDS		Cause:	1. Shallow throat. 2. Min. head space.
Cause:	1. Guard screws protrude into bolt track.		<ol> <li>Damaged chamber.</li> <li>Extractor interferes with shell rim.</li> </ol>
	2. Receiver plug screws protrude into bolt track		5. Ejector binds or fails to retract far enough.
	3. Bolt handle enterferes in stock.		6. Burr at ejector hole in bolt.
<b>.</b> .	4. Damage at rear of bolt lugs.		7. Sharp corners in bolt lugs.
Correction:	1. File end of screws.	Correction:	1. Ream.
	<ol> <li>File ends of screws.</li> <li>Clear stock or fit new stock.</li> </ol>		2. Re-head.
	4. Stone to blend. Check head space.		3. Re-head.
EJECTION			<ol> <li>Fit new extractor (grind relief in new ex- tractor behind claw).</li> </ol>
			5. Free up or replace. 6. Deburr.
Cause:	1. Burr at ejector hole in bolt.		7. Stone radius.
	2. Ejector binds or fails to retract far enough.		
	3. Extractor binds.	COCKING (S	See trigger Adjustment)
Correction:	1. Deburr.		,
	<ol> <li>Free up or replace.</li> <li>Adjust or fit new extractor (and rivet).</li> </ol>	Cause:	1. Trigger adjusting screw at rear out of adjust- ment (improper horizontal engagement of sear and connector.)
BOLT PULL	S OUT		<ol> <li>Improper vertical engagement of sear and connector.</li> </ol>
Cause:	1. Bolt stop or bolt release binds.		3. Trigger doesn't retract.
	2. Bolt stop or bolt release broken.		4. Corners on sear or connector rounded.
	3. Bolt stop spring damaged.	Correction:	1. Adjust.
Correction:	1. Free up.		2. Fit new trigger assembly.
	2. Replace.		3. Fit new trigger assembly;
	3. Replace.		4. Fit new sear and safety cam or connector.
FEEDING		BULGES OR	BLOWS CASES
Cause:	1. Magazine follower binds.	Cause:	1. Oversize chamber.
	2. Weak or defective follower spring.		2. Max. head space.
	3. Magazine spring caught under guard.	Correction:	1. Replace barrel assembly.
	4. Damaged chamfer on bolt head.		2. Fit new bolt.
<b>Comment</b>	5. Tabs on follower bent.	0.0	
Correction:	<ol> <li>Adjust side angle on magazine.</li> <li>Replace spring.</li> </ol>	SAFETY	
	3. Correct.	Cause:	1. Safe binds (safe works hard).
	4. Replace bolt, or stone smooth.	JU 490 ,	<ol> <li>Safe binds (safe works hard).</li> <li>Safety snap washer stretches out (safe works</li> </ol>
	5. Straighten or replace follower.		too freely).
			3. Safety damaged.
		Correction:	1. Free up,
			2. Replace washer or reseat in safety pivot pin

slot. 3. Replace safety.

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### ACCURACY - Group Size

Cause:

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- 1. Crown of barrel damaged.
- 2. Barrel bore fouled.
- 3. Enlarged bore.
- 4. Improper bedding of barrel in stock.
- 5. Loose sights. Correction: 1. Recrown.
  - 2. Lead or replace barrel.
  - 3. Replace barrel.
  - 4. Refloat barrel.
  - 5. Tighten or replace.

### POINT OF IMPACT

- Cause:
- Barrel not straight.
   Improper or loose sights.
- Correction; 1
  - 1. Straighten or replace barrel.
  - 2. Tighten or change sights.

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## REMINGTON FIELD SERVICE MANUAL

	26684				
		Barrel Assembly, 350 Rem. Mag. (includes Bar- rel, Barrel Bracket, Barrel Stud (6), Receiver)	32	26795	Safety Assembly (includes Safety and Safety Thumbpiece)
	26686	Barrel Assembly, 6.5 MM Rem. Mag.	33	21386	Recoil Pad (Magnum only)
,	26680	Barrel Assembly, 308 Win. (includes Barrel,	34	25410	Recoil Pad Screw (Magnum only)
		Barrel Bracket, Barrel Stud (6), Receiver)	35	26850	Safety Detent Ball
	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem.	36	15432	Safety Detent Spring
		Mag. (includes Bolt Body Assembly and Bolt	37	17043	Safety Pivot Pin
		Handle)	38	17044	Safety Snap Washer
	26705	Bolt Assembly, 308 Win. (includes Bolt Body	39	15666	Sear Safety Cam
	0/700	Assembly and Bolt Handle)	40	24476	Sear Pin
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM	41	15416	Sear Spring
1		Rem. Mag. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extrac-	42	16968	Sight Screw Sight Washer
		tor Rivet, Firing Pin Assembly)	1	1	
	26700	Bolt Final Assembly, 308 Win. (includes Bolt		26990	Sling Strap Assembly and Mountings, Complete
		Assembly, Ejector, Ejector Pin, Ejector Spring,		}	Includes: 44 thru 49
		Extractor, Etractor Rivet, Firing Pin Assembly)	44	15376	Fastener
	15409	Bolt Plug	45	15357	Front Swivel Nut
	15412	Bolt Stop	46	15356	Front Swivel Screw
	24484	Bolt Stop Pin	47	15358	Rear Swivel Screw
	15413	Bolt Stop Spring	48	26625	Sling Strap Assembly, 7/8"
	15741	Butt Plate (Model 600 only)	49	26555	Swivel Assembly, Q.D. (each)
	25410	Butt Plate Screw (Model 600 only)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem.
	17017	Ejector		}	Mag. (includes Recoil Pad, Recoil Pad Screw
	17676	Eector Pin			(2), Stock, Swivel Screw, Rear; Swivel Screw,
	17019	Ejector Spring		27450	Front; Front Swivel Nut, Reinforcing Screw)
	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag	1	27650	Stock Assembly (includes Butt Plate, Butt Plate
	16254	Extractor	51	15883	Screw (2), and Stock)
L	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem.	52	15435	Tang Support (Magnum only) Trigger
ł	27210	Mag	53	17049	Trigger Adjusting Screw
	27340 15410	Extractor Rivet (except 222 Rem.)		26730	Trigger Assembly (includes Trigger Housing,
	26715	Firing Pin			Sear Safety Cam, Sear Spring, Trigger, Trig-
ľ	20/15	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head,			ger Adjusting Screw (2), Trigger Connector,
		Main Spring)			Trigger Pin, Trigger Spring, Trigger Stop
	17022	Firing Pin Cross Pin	54	15436	Screw)
	23321	Firing Pin Head	55	15430	Trigger Connector
	15653	Front Guard Screw	56	15429	Trigger Guard Trigger Housing
	27365	Front Sight Assembly (includes Front Sight and	57	24477	Trigger Pin
	15648	Front Sight Bead)	58	17978	Trigger Spring
	27260	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag. Magazine, 308 Win., 6MM Rem., 243 Win	59	17053	Trigger Stop Screw
	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM			
		Rem. Mag.			
	17056	Magazine Follower			ADDITIONAL CALIBER PARTS
	17891	Magazine Spring			
	15411	Main Spring			(Not Shown in Sectional View)
	17580	Rear Guard Screw	1	26682	Barrel Assembly, 35 Rem (Superseded)
1	26841	Rear Sight Assembly (includes Rear Sight Eleva-		26681	Barrel Assembly, 222 Rem.
		tion Screw, Rear Sight Base, Rear Sight Eye-		26683	Barrel Assembly, 6 MM Rem.
		piece, Rear Sight Leaf, Rear Sight Windage		26685	Barrel Assembly, 243 Win.
1		Screw)		26706	Bolt Assembly, 35 Rem. (Superseded)
	15600	Rear Sight Base, 350 Rem. Mag.		26775	Bolt Assembly, 222 Rem.
	15727	Rear Sight Base		26701	Bolt Final Assembly, 35 Rem. (Superseded)
	15733	Rear Sight Elevation Screw		26770	Bolt Final Assembly, 222 Rem.
	15726	Rear Sight Eyepiece		15852	Ejector, 222 Rem.
	15728	Rear Sight Leaf		15850	Extractor, 222 Rem,
	15418	Rear Sight Nut		27342	Extractor Rivet, 222 Rem.
	15732	Rear Sight Windage Screw		27366	Front Sight Assembly, 6 MM Rem., 243 Win.
	15778 17034	Rear Sight Wrench		27261	Magazine, 222 Rem.
	15651	Receiver Plug Screw		27262	Magazine, 35 Rem. (Superseded)
	12021	Reinforcing Screw, 350 Rem. Mag., 6.5 MM		16793	Magazine Follower, 222 Rem.
Ł	18186	Rem. Mag.		17983	Magazine Spacer, 222 Rem.
	15488	Reinforcing Screw		15600	Magazine Spring, 222 Rem Rear Sight Base, 35 Rem. (Superseded)
	15417	Rib Screw	1		
				NOTE: S	see basic Parts List for parts not listed above.

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EXPLODED VIEW

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## REMINGTON FIELD SERVICE MANUAL



## **MODELS** 725-721-722-700-600

#### SAFETY PERFORMANCE CHECK

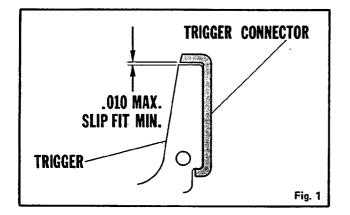
After reassembly, the following checks for proper function of the safety should be made.

Close bolt. Put safety ON SAFE. Lift bolt handle. (Bolt handle should not raise). Pull trigger (firing pin should not fall). Action of trigger pull should be smooth (no bind, drag, click or catch). Release trigger (trigger should return to former position). Put safety ON FIRE position (firing pin should not fall). Pull trigger (firing pin should fall). Repeat test at least three (3) times.

Safety should function on two (2) positive stop positions (ON SAFE – FIRE). If positions are not positive, check parts. Inspect detent holes, retainer, retainer pin, detent, detent spring and related parts for possible cause. Replace any worn or damaged parts and lubricate with a dry lubricant. Reassemble and check. If stop positions are not positive replace complete trigger housing assembly.

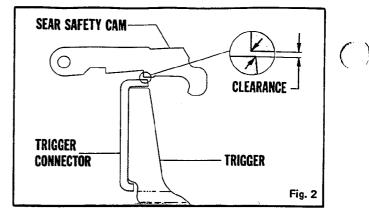
**NOTE:** Lubrication should not be used as a remedy for trigger housing assembly problems. The cause should be positively located and corrected.

When repairing trigger housing assembly wash parts thoroughly with a petroleum solvent. An accumulation of gun oil or dried oil can build a film that may cause malfunctions. Relubricate with a dry lubricant and reassemble. Check clearance between trigger and trigger connector .010 MAX. slip fit (MIN.) with feeler gage (see Fig. 1). Check trigger connector for straightness and cracks at trigger stop screw hole. Make sure there is no bind or catch in trigger, sear safety cam or safety lever about pivots.

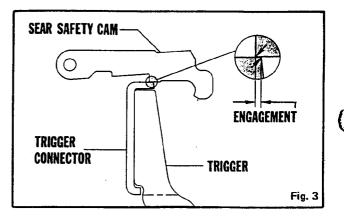


When replacing trigger housing assembly, take care not to bend or spring the housing. Sear safety cam should pivot freely. To check, remove bolt, move safety to OFF SAFE, pull trigger and press down on rear of sear safety cam and release.

For proper safety function there must be clearance between trigger connector and sear safety cam. To check close bolt and put safety ON SAFE. Visually inspect through hole in side of trigger housing (see Fig. 2). If there is no clearance, replace safety assembly, or trigger housing assembly. Corners must be sharp. (Arrows).



Sear safety cam and trigger connector engagement of .015'' - .020'' on field rifles and .010'' - .015'' on target rifles is critical (see Fig. 3). Replace any worn or damaged parts. To adjust, close bolt and place safety OFF SAFE. Turn trigger engagement screw clockwise until rifle fires. Turn screw counterclockwise ¼ turn (90°) and check engagement. (see note A). Corners must be sharp. (Arrows).



To adjust trigger stop screw, close bolt and put safety OFF SAFE. Turn trigger stop screw clockwise until it touches trigger. Pull and hold trigger rearward. Turn trigger stop screw counter clockwise until rifle fires. Turn an additional 1/8 turn for clearance. (see note A).

Trigger pull adjustment on any field rifle should never be adjusted below three (3) pounds. (see note A).

Trigger pull adjustment on any target rifle should never be adjusted below two (2) pounds. (see note A).

NOTE A: After any adjustments to trigger housing assembly screws, repeat all safety checks. Check for "follow down." See malfunctions. Restake or reseal screws with DuPont Duco cement.

When replacing stock assembly, check for clearance between following parts: Safety Lever – Stock; Trigger – Trigger Guard; Trigger – Stock.

## MODELS 725-721-722-700-600

#### MALFUNCTIONS

- "Follow Down." After reassembling rifle, check for "follow down" condition. (Firing pin moves to uncocked position as bolt is closed). Put safety OFF SAFE. Close bolt smartly. Firing pin should remain cocked (dry fire to check). "Follow down" may be caused by improper sear safety cam - trigger connector engagement or by trigger being held back by interference between trigger and stock, trigger and trigger guard, and / or trigger housing. "Follow down" can also be caused by sear safety cam binding, by missing parts and / or broken connector. (see note B).
- 2. "Firing Pin Falls." If firing pin falls when rifle is jarred or when bolt handle is lifted check following:

Firing pin head binds in guide slot in receiver. Firing pin head and slot should align. To check, remove firing pin assembly from bolt. Reassemble bolt to receiver. Small cocking notch on rear edge of bolt should align with slot in receiver.

Guide slot in receiver should be free of burrs. Remove trigger housing and clean any burrs from slot.

This malfunction may also be caused by improper sear safety cam — trigger connector engagement. Adjust engagement as previously described. (see note B).

3. "Firing Pin Fails to Fall." If firing pin fails to fall when trigger is pulled or trigger has to be pulled more than once. See firing pin falls for possible cause and corrections. (see note B).

NOTE B: Correct malfunction 100% or return rifle to factory.

For smooth operation, a good quality gun grease should be applied to threads on bolt plug, firing pin head cocking carn at rear of bolt and on locking lug engagement area.

## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.

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This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed. STOCK ASSEMBLY — is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply ---- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service – Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

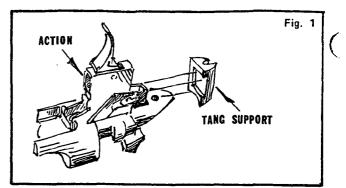
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT'

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT — is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



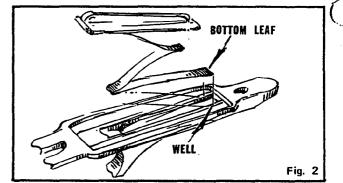
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble - Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



Turn both guard screws to tighten guard and stock securely to action.

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ——— and insures full magnum cartridge in magazine.

To Reassemble – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights,



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division

Ilion, New York 13357

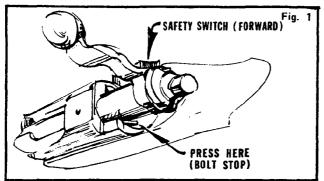
All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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#### BOLT FINAL ASSEMBLY

To Disassemble-Push safety switch assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service — The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun)- Push safety switch forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety switch. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement, then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

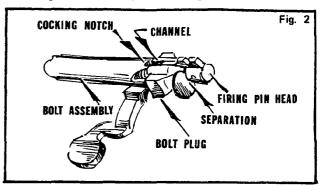
BOLT FINAL ASSEMBLY – COMPONENTS – Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly – which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

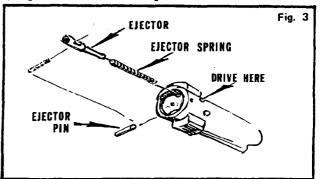
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

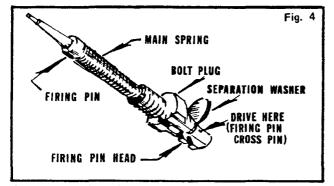
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service – Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

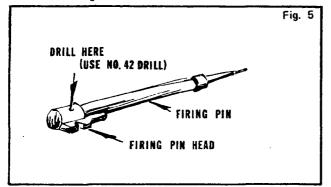
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service –All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** — includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

**To Service** — All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

#### REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble — Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

**RIB** – is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble - Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble – Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger quard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble – Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

### BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service – Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

**MAGAZINE ASSEMBLY** – is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER -- is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

**BARREL ASSEMBLY** – is factory-listed to include barrel, barrel bracket, barrel stud (6) receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble- Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick - detachable (Q.D.) type.

### ASSEMBLE - SWIVEL SCREWS TO STOCK

Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock, Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

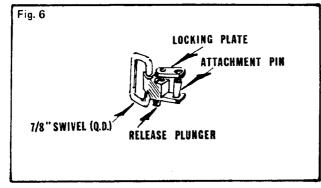
### Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightened to stock with front swivel nut.

### ASSEMBLE - SWIVEL ASSEMBLY (2) O.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 6).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE – STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position. Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

## **CYCLE OF OPERATION**

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are not free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY SWITCH

The safety switch button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety switch had two intentional functions. When safety switch button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety switch in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety switch button forward to FIRE position nullifies above conditions and will allow firing. Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS

**Cause and Correction** 

FIRING

Cause:	1. Firing pin damaged.
	2. Firing pin binds.
	3. Firing pin protrusion faulty.
	4. Trigger assembly out of adjustment.
	5. Faulty ammunition.
Correction:	1. Replace.
	2. Free up or replace.
	3. Replace firing pin.
	4. Return the firearm to the factory.

5. Replace ammunition.

### UNLOCKING

Cause:	1.	See	Extr	acti	on.			
	~						1. 1	

- 2. Upset extraction cam on bolt handle.
- 3. Burr at ejector hole in bolt.
- 4. Blown or set back primer on shell.
- Correction: 1. See Extraction.
  - 2. Smooth up bolt handle cam.
  - 3. Deburr.
  - 4. Ammunition may be at fault.

#### EXTRACTION

- Cause: 1. Fouled, rough, or enlarged chamber.
  - 2. Extractor broken or damaged.
  - 3. Not enough hook space on extractor.

1. Polish if fouled or rough. Replace barrel as-

4. Height of claw not correct.

Correction:

- sembly if enlarged. 2. Fit new extractor and rivet.
  - 3. Fit new extractor and rivet.
  - . Fit new extractor and rivet.
  - 4. Fit new extractor and rivet.

BOLT BINDS	3	Correction:	1. Ream. 2. Re—head.
Cause:	<ol> <li>Guard screws protrude into bolt track.</li> <li>Receiver plug screws protrude into bolt track.</li> <li>Bolt handle interferes with stock.</li> <li>Damage at rear of bolt lugs.</li> </ol>		<ol> <li>Re-head.</li> <li>Fit new extractor (grind relief in new extractor behind claw).</li> <li>Free up or replace.</li> <li>Deburr.</li> </ol>
Correction:	<ol> <li>File end of screws.</li> <li>File end of screws.</li> <li>Clear stock or fit new stock.</li> <li>Stone to blend. Check head space.</li> </ol>	COCKING	7. Stone radius.
EJECTION		Cause:	<ol> <li>Trigger out of adjustment.</li> <li>Improper vertical engagement of sear and</li> </ol>
Cause:	<ol> <li>Burr at ejector hole in bolt.</li> <li>Ejector binds or fails to retract far enough.</li> </ol>		connector. 3. Trigger doesn't retract. 4. Corners on sear or connector rounded.
Correction:	<ol> <li>2. Epoter binds of table to restate the one-game</li> <li>3. Extractor binds.</li> <li>1. Deburr.</li> <li>2. Free up or replace.</li> <li>3. Adjust or fit new extractor (and rivet).</li> </ol>	Correction:	<ol> <li>Return the firearm to the factory.</li> </ol>
BOLT PULLS	SOUT	BULGES OR	BLOWS CASES
Cause:	<ol> <li>Bolt stop or bolt release binds.</li> <li>Bolt stop or bolt release broken.</li> </ol>	Cause:	<ol> <li>Oversize chamber.</li> <li>Max. head space.</li> </ol>
Correction:	<ol> <li>Bolt stop spring damaged.</li> <li>Free up.</li> <li>Return the firearm to the factory.</li> </ol>	Correction:	<ol> <li>Replace barrel assembly.</li> <li>Fit new bolt.</li> </ol>
	3. Return the firearm to the factory.	SAFETY SW	итсн
FEEDING		Cause:	<ol> <li>Safety switch binds (safety switch works hard).</li> </ol>
Cause: Correction:	<ol> <li>Magazine follower binds.</li> <li>Weak or defective follower spring.</li> <li>Magazine spring caught under guard.</li> <li>Damaged chamfer on bolt head.</li> <li>Tabs on follower bent.</li> <li>Adjust side angle on magazine.</li> </ol>	Correction:	<ol> <li>Safety switch snap washer stretches out (safety switch works too freely).</li> <li>Safety switch damaged.</li> <li>Return the firearm to the factory.</li> <li>Return the firearm to the factory.</li> <li>Return the firearm to the factory.</li> </ol>
	<ol> <li>Replace spring.</li> <li>Correct.</li> <li>Replace bolt, or stone smooth.</li> </ol>	ACCURACY	- Group Size
LOADING	5. Straighten or replace follower.	Cause:	<ol> <li>Crown of barrel damaged.</li> <li>Barrel bore fouled.</li> <li>Enlarged bore.</li> </ol>
Cause:	<ol> <li>Damaged receiver rails.</li> <li>Sharp edge — rear end of chamber.</li> </ol>	Correction:	<ol> <li>Improper bedding of barrel in stock.</li> <li>Loose sights.</li> <li>Recrown.</li> </ol>
Correction:	<ol> <li>Rough loading ramp in receiver.</li> <li>Polish or reshape.</li> <li>Remove sharpness.</li> <li>Polish ramp.</li> </ol>		<ol> <li>Lead or replace barrel.</li> <li>Replace barrel.</li> <li>Refloat barrel.</li> <li>Tighten or replace.</li> </ol>
LOCKING		POINT OF I	МРАСТ
Cause:	<ol> <li>Shallow throat.</li> <li>Min. head space.</li> <li>Damaged chamber.</li> <li>Extractor interferes with shell rim.</li> <li>Ejector binds or fails to retract far enough.</li> <li>Burr at ejector hole in bolt.</li> <li>Sharp corners in bolt lugs.</li> </ol>	Cause: Correction:	<ol> <li>Barrel not straight.</li> <li>Improper or loose sights.</li> <li>Straighten or replace barrel.</li> <li>Tighten or change sights.</li> </ol>

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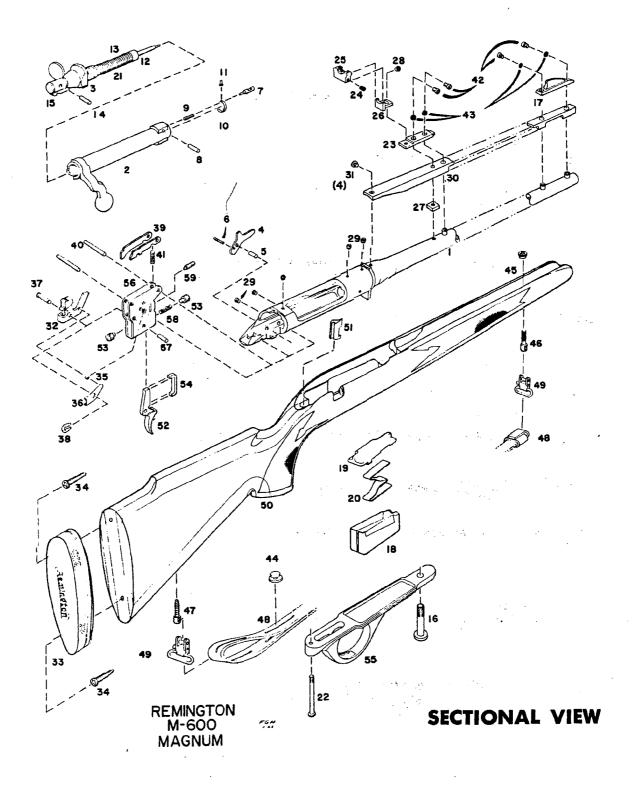
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## REMINGTON FIELD SERVICE MANUAL

View No.	Part No.	NAME OF PART		View No.	Part No.	NAME OF	PART
1		Barrel Assembly, 350 Rem. Mag.		41	17047	Sear Spring	(Restricted)
		Barrel Assembly, 6.5 MM Rem. Mag.		42	15416	Sight Screw	
		Barrel Assembly, 308 Win.		43	16968	Sight Washer	
2		Bolt Assembly, 350 Rem. Mag., 6.5 MM R	ern. Niag.		26990	Sling Strap Assembly and N	Aountings, Complete
		Bolt Assembly, 308 Win.	_			Includes: 44 thru 49	
		Bolt Final Assembly, 350 Rem. Mag., 6.5 N	1M Rem.	44	15376	Fastener	
		Mag.		45	15357	Front Swivel Nut	
		Bolt Final Assembly, 308 Win.		46	15356	Front Swivel Screw	
3	15409	Bolt Plug		47	15358	Rear Swivel Screw	
4	15412	Bolt Stop	(Restricted)	48	26625	Sling Strap Assembly, 7/8"	
5	24484	Bolt Stop Pin	(Restricted)	49	26555	Swivel Assembly, Q.D. (eac	.h)
6	15413	Bolt Stop Spring	(Restricted)	50	27651	Stock Assembly, 350 Rem.	Mag., 6.5 MM Rem.
	15741	Butt Plate (Model 600 only)				Mag.	
	25410	Butt Plate Screw (Model 600 only)			27650	Stock Assembly	
7	17017	Ejector		51	15883	Tang Support (Magnum onl	
8	17676	Ejector Pin	ļ	52	15435	Trigger	(Restricted)
9	17019	Ejector Spring		53	17049	Trigger Screw, Front	(Restricted)
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. M	lag.		26730	Trigger Assembly	(Restricted)
	16254	Extractor		54	15436	Trigger Connector	(Restricted)
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM R	em.	55	15437	Trigger Guard	
		Mag.		56	15429	Trigger Housing	(Restricted)
	27340	Extractor Rivet (except 222 Rem.)		57	24477	Trigger Pin	(Restricted)
12	15410	Firing Pin		58	17978	Trigger Spring	(Restricted)
13	26715	Firing Pin Assembly		59	17053	Trigger Stop Screw	(Restricted)
14	17022	Firing Pin Cross Pin					
15	23321	Firing Pin Head					
16	15653	Front Guard Screw				ADDITIONAL CALIBE	DARTS
17	27365	Front Sight Assembly				ADDITIONAL CALIBE	IN FANTS
18	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Ma	ig.			(Not Shown in Sectiona	
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	.			(NOT SHOWN IN SECTORE	
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM	<i>n</i>			Barrel Assembly, 35 Rem. (	(Supersected)
		Rem. Mag.	1			Barrel Assembly, 222 Rem.	
	17056	Magazine Follower				Barrel Assembly, 6MM Rem	
20	17891	Magazine Spring				Barrel Assembly, 243 Win.	
21	15411	Main Spring	ļ			Bolt Assembly, 35 Rem. (S	uperseded)
22	17580	Rear Guard Screw				Bolt Assembly, 222 Rem.	
22	26841	Rear Sight Assembly Rear Sight Base, 350 Rem. Mag.	1			Bolt Final Assembly, 35 Re	em. (Superseded)
23	15600 15727	Rear Sight Base				Bolt Final Assembly, 222 F	
24	15727	Rear Sight Elevation Screw			15852	Ejector, 222 Rem.	
24 25	15726	Rear Sight Eyepiece			15850	Extractor, 222 Rem.	
26	15728	Rear Sight Leaf			27342	Extractor Rivet, 222 Rem.	
27	15418	Rear Sight Nut			27366	Front Sight Assembly, 6 Mi	M Rem., 243 Win.
28	15732	Rear Sight Windage Screw			27261	Magazine, 222 Rem.	
20	15732	Rear Sight Wrench			27262	Magazine, 35 Rem. (Supers	eded)
29	17034	Receiver Plug Screw			16793	Magazine Follower, 222 Re	em.
29	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM	•		15742	Magazine Spacer, 222 Rem	1
	15051	Rem. Mag.			17983	Magazine Spring, 222 Rem.	•
	18186	Reinforcing Screw			15600	Rear Sight Base, 35 Rem. (	Superseded)
30	15488	Rib					
31	15417	Rib Screw			NOTE:	See Basic Parts List for part	ts not listed above.
32	26795	Safety Switch Assembly	(Restricted)				
.33	21386	Recoil Pad (Magnum only)	1.10001101001				
.33 34	25410	Recoil Pad Screw (Magnum only)					
35	26850	Safety Switch Detent Ball	(Restricted)				
36	15432	Safety Switch Detent Spring	(Restricted)				
30	17043	Safety Switch Pivot Pin	(Restricted)				
38	17043	Safety Switch Snap Washer	(Restricted)				
.39	15666	Sear Safety Cam	(Restricted)				
40	24476	Sear Pin	(Restricted)				
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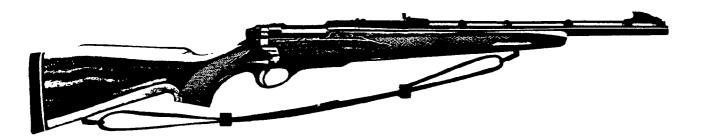
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REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder – RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

### MODEL 600 MAGNUM

**STOCK ASSEMBLY** – is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service – Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

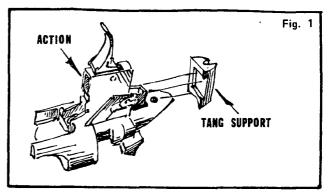
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT'

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



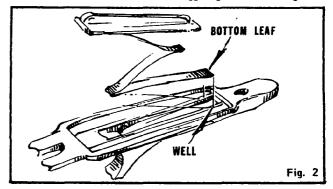
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

**To Disassemble** – Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble – Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



Turn both guard screws to tighten guard and stock securely to action.

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ---- and insures full magnum cartridge in magazine.

**To Reassemble** – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied – ADL (standard) and BDL. Included in the BDL grade is the Model 700 VARMINT – an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries on service and parts to **REMINGTON ARMS COMPANY, INC. Arms Service Division** llion, New York 13357

All other inquiries are to be addressed to **REMINGTON ARMS COMPANY, INC.** Bridgeport, Connecticut 06602

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### BOLT FINAL ASSEMBLY

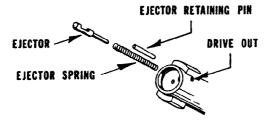
To Disassemble —With safety switch forward on FIRE position lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

To Service – Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety switch forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

**BOLT FINAL ASSEMBLY** – COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR – EJECTOR PIN – EJECTOR SPRING (in bolt assembly)



To Disassemble – With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. (See Fig. 1).

To Reassemble – Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

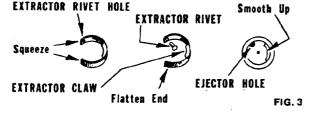
Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR - EXTRACTOR RIVET (in bolt assembly)

To Disassemble – Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.



To Service — Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble – Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See Fig. 3). Straighteh tail of extractor. (See Fig. 3). Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

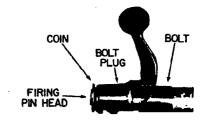
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

#### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. (See Fig. 4). Unscrew and remove firing pin assembly from bolt assembly.

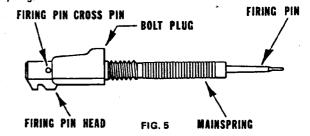


**To Service** – Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

FIG. 4

FIRING PIN ASSEMBLY - COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



To Disassemble - (with firing pin assembly removed from bolt).

t

**Caution:** Main spring is under compression. Disassembly of this unit is **not recommended** unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service — All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble – Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

#### FRONT SIGHT HOOD (BDL Grade only)

To Disassemble – Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service – Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### FRONT SIGHT

**To Disassemble** – Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble - Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

#### **TRIGGER GUARD (ADL Grade)**

To Disassemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow reverse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble – Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

**TRIGGER GUARD ASSEMBLY** – **COMPONENTS** (BDL Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. **To Disassemble** – Drive out floor plate pivot pin and remove floor plate from trigger guard.

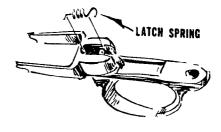
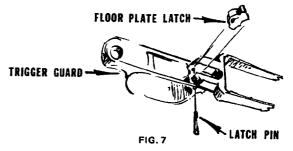


FIG. 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin - left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble – Follow reverse order. Floor plate should swing freely and latch properly.

## MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble – Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

#### STOCK ASSEMBLY

To Disassemble- Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble- Follow reverse order. Tighten screws securely.

**STOCK ASSEMBLY – COMPONENTS** (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. **To Disassemble –** Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement, if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble- Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

STOCK ASSEMBLY - COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore-end tip, fore-end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble- See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble – Follow reverse order.

BARREL ASSEMBLY - Includes barrel, barrel brackets, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE: Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q.D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is  $7/8^{\prime\prime}$  wide. Swivel assemblies are (Q.D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle – assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust trap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

## **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action — completing the cycle. Each operation is described in sequence below:

#### FIRING

With action closed and locked and safety switch in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

#### EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8'' with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt.may now be moved to rear — completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY SWITCH

The safety switch, located at right rear of receiver is operated by a push and pull action on the safety switch button. This two-position safety switch has two internal functions. When safety switch is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety switch in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety switch forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

## MALFUNCTIONS

## **Cause and Correction**

#### **Over-Ride**

Cause:

- 1. Magazine Follower binds.
  - 2. Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.

Correction: 1. Adjust side angle on Magazine Box.

- 2. Change Spring.
- 3. Correct.
- 4. Straighten or replace Follower.

### Stems Chamber

- Cause: 1. Sharp or rough Receiver Rails.
  - 2. Sharp edge rear end of Chamber.
    - 3. Rough Ramp in Receiver.
    - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - 2. Remove sharpness.
    - 3. Polish Ramp.
    - 4. Adjust.

#### **Bolt Closes Hard Over Shells**

- Cause: 1. Bolt interferes with shell rim.
  - 2. Extractor interferes with shell rim.
  - 3. Ejector binds or fails to retract far enough.
  - 4. Burr at Ejector Hole on Bolt.
  - 5. Sharp corners on Bolt Lugs.
  - 6. Extractor Rivet loose.

### Correction: 1. Remove interference or change Bolt.

- 2. Fit new Extractor (grind relief in new Extractor behind Claw).
- 3. Free up or replace.
- 4. Deburr.
- 5. File radius.
- 6. Tighten or replace Rivet.

#### Fails to Extract

- Cause: 1. Tight, rough or oversize Chamber.
  - 2. Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
  - 4. Height of Claw not correct.
  - 5. Extractor stuck back.
- Correction: 1. Ream if tight or rough.
  - Change Barrel Assembly if oversize.
  - 2. Fit new Extractor.
    - 3. Fit new Extractor.
    - 4. Fit new Extractor.
    - 5. Replace Extractor.

#### **Fails To Eject**

- Cause: 1. Burr at Ejector Hole in Bolt.
  - 2. Ejector binds or fails to retract far enough.
  - 3. Extractor Rivet loose.
  - 4. Extractor drops shell.
- Correction: 1. Deburr.
  - 2. Free up or replace.
  - 3. Re-stake or replace.
  - 4. Replace Extractor.

## Misfires Cause:

- 1. Short Firing Pin (damaged).
  - 2. Firing Pin binds.
  - 3. Short Firing Pin protrusion.
  - 4. Firing Control out of adjustment.
  - 5. Faulty ammunition.

#### Correction: 1. Replace.

- 2. Free up or replace.
- 3. Change Firing Pin or Bolt.
- 4. Return the firearm to the factory.
- 5. Replace ammunition.

- **Follows Down**
- Cause: 1. Trigger out of adjustment.
  - 2. Improper vertical engagement of Sear and Connector.
    - 3. Trigger doesn't retract.
    - 4. Corners on Sear or Connector rounded.
    - 5. Trigger binds on Trigger Guard.
    - 6. Not enough tension on Weight Screw (light pull).
- Correction: 1. Return the firearm to the factory.
  - 2. Return the firearm to the factory.
  - 3. Return the firearm to the factory.
  - 4. Return the firearm to the factory.
  - 5. File Trigger Guard eliminate interference.
  - 6. Return the firearm to the factory.

#### **Bolt Opens Hard**

- Cause: 1. See Fails to Extract.
  - 2. Upset Extraction Cam on Bolt Handle.
  - 3. Burr at Ejector Hole in Bolt.
  - 4. Blown or set back Primer on shell.
- Correction: 1. See Fails to Extract.
  - 2. Smooth up.
  - 3. Deburr.
  - 4. Ream Chamber if throat is shallow (ammunition may be at fault).

#### **Bolt Pulls Out**

- Cause: 1. Bolt Stop or Bolt Release binds. 2. Bolt Stop or Bolt Release broken.
- Correction: 1. Return the firearm to the factory. 2. Return the firearm to the factory.

#### Safety Switch Works Too Hard or Too Freely

- 1. Safety switch binds (works hard). Cause: 2. Safety switch Snap Washer stretched out (Safety Switch works too freely.)
- Correction: 1. Return the firearm to the factory. 2. Return the firearm to the factory.

#### **Bulges or Blows Cases**

- Cause: 1. Oversize Chamber. 2. Maximum head space.
- Correction: 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

#### **Bolt Binds**

- 1. Guard Screws protrude into Bolt track. Cause:
  - 2. Scope Screws protrude into Bolt track.
    - 3. Bolt Handle interference on Stock.
    - 4. Step at rear of Bolt Lugs.

#### Correction: 1. File ends of Screws.

- 2. File ends of Screws.
  - 3. Correct Stock or fit new Stock.
  - 4. File to blend.

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## REMINGTON FIELD SERVICE MANUAL

PARTS LIST

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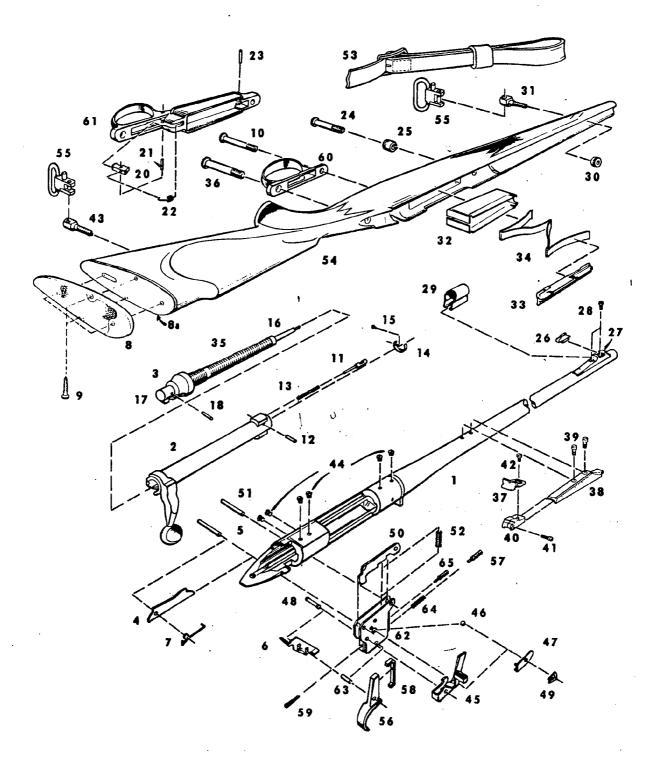
View No.	Part No.	NAME OF PART		View No.	Part No.	NAME OF PART	
NOTE	: Basic 3	0-06 Caliber listed below. See Sectiona	View for proper	35	17029	Main Spring	
	identity	y of parts. See added page for other cal	iber part listings.	36	26355	Rear Guard Screw	
				37	20355 32510	Rear Sight Aperture	
1		Barret Assembly		38	91595		
2		Bolt Assembly		39	28505	Rear Sight Base Rear Sight Base Screw (2)	
		Bolt Final Assembly		40	20305 90905	Rear Sight Slide	
3	17012	Bolt Plug		41	90906	Elevation Screw	
4	17013	Bolt Stop	(Restricted)	42	90904	Windage Screw	
5	24475	Bolt Stop Pin	(Restricted)	43	15358	Rear Swivel Screw, BDL Grade	
6	15478	Bolt Stop Release	(Restricted)	44	17034	Receiver Plug Screw	
7	15224	Bolt Stop Spring	(Restricted)	45	26585	Safety Switch Assembly	(Restricted)
8	90953	Butt Plate		46	23222	Safety Switch Detent Ball	(Restricted)
8a	90954	Butt Plate Spacer, BDL		47	15368	Safety Switch Detent Spring	(Restricted)
9	25380	Butt Plate Screw		48	17043	Safety Switch Pivot Pin	(Restricted)
10	15287	Center Guard Screw, ADL Grade		49	17044	Safety Switch Snap Washer	(Restricted)
11	17017	Ejector		50	15666	Sear Safety Cam	(Restricted)
12	17676	Ejector Pin		51	24476	Sear Pin	(Restricted)
13	17019	Ejector Spring		52	17047	Sear Spring	(Restricted)
14	91816	Extractor		53	30855	Sling Strap Assembly, BDL Grade	,
	15376	Fastener, Sling Strap			26990	Sling Strap Assembly and Mountings	Complete
16	22020	Firing Pin		54	33366	Stock Assembly, ADL Grade	
17	22040	Firing Pin Assembly		_	33371	Stock Assembly, BDL Grade	
18	17022	Firing Pin Cross Pin		1	18186	Stock Reinforcing Screw (not shown	)
2 <b>0</b>	15291	Floor Plate Latch, BDL Grade			16970	Stock Reinforcing Screw Dowel (not	
21	16451	Floor Plate Latch Pin, BDL Grade		55	26555	Swivel Assembly, BDL Grade (Q.D.)	
22	16452	Floor Plate Latch Spring, BDL Grade		56	15280	Trigger	(Restricted)
23	16453	Floor Plate Plvot Pin, BDL Grade		57	17053	Trigger Adjusting Screw	(Restricted)
24	22035	Front Guard Screw		-	26345	Trigger Assembly	(Restricted)
25	15161	Front Guard Screw Bushing, ADL G	ade	58	19461	Trigger Connector	(Restricted)
26	15373	Front Sight		59	91128	Trigger Engagement Screw	(Restricted)
	15719	Front Sight (Low)		60	15281	Trigger Guard	
27	28510	Front Sight Ramp		61	26376	Trigger Guard, BDL Grade	
	15635	Front Sight Ramp, BDL Grade			26371	Trigger Guard Assembly, BDL Grade	•
28	28505	Front Sight Ramp Screw		62	26655	Trigger Housing Assembly	(Restricted)
29	15363	Front Sight Hood, BDL Grade		63	24477	Trigger Pin	(Restricted)
30	15357	Front Swivel Nut, BDL Grade		64	15400	Trigger Spring	(Restricted)
31	15358	Front Swivel Screw, BDL Grade		65	15481	Trigger Stop Screw	(Restricted)
	90957	Grip Cap, BDL Grade (not shown)					
	25380	Grip Cap Screw					
	90958	Grip Cap Spacer, BDL Grade (not sh	own)				
32	15284	Magazine, ADL Grade				,	
	16430	Magazine, BDL Grade (not shown)					
33	90952	Magazine Follower					
	91017	Magazine Follower, BDL Grade					
	15940	Magazine Tab Screw, ADL Grade					
34	17028	Magazine Spring		1			
	15677	Magazine Spring, BDL Grade					

5

SECTIONAL VIEW

## REMINGTON FIELD SERVICE MANUAL

MODEL 700



6

### ADDITIONAL CALIBERS Not Shown in Sectional View) CLUDES VARMINT MODEL

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## REMINGTON FIELD SERVICE MANUAL

Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

10.	NAME OF PART	Part No.	NAME OF PART
		33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm
91837	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.		Rem. 22-250 Rem., BDL Grade, 17 Rem.
91906	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223
22021	Firing Pin,222 Rem., 234-308 Win., 6mm Rem. Mag., 22-		Rem.,243 Win., 6mm Rem., 22-250 Rem.
	250 Rem., 223 Rem., 17 Rem.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 &
	Win., 6mm Rem., 22-250 Rem. 223 Rem.		308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.,
	Win., 6mm Rem., 22-250 Rem., 17 Rem.		223 Rem., 243 Win., 6mm Rem., 22-250 Rem.
2 <b>2037</b>	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308		
	Win., 6mm Rem., 22-250 Rem., 17 Rem.		CALIBERS: 375 H & H MAGNUM, 458 WIN. MAGNUM
16204	Front Scope Base, Varmint	27265	Barrel Assembly, 375 H & H Mag.
14659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	27266	Barrel Assembly, 458 Win. Mag.
28511	Front Sight Ramp, ADL Grade	15709	Extractor
15992	Front Sight Ramp, BDL Grade	16771	Front Sight, 375 H & H Mag.
15282	Magazine, ADL Grade, 222 Rem.	23805	Front Sight, 458 Win. Mag.
16716	Magazine, BDL Grade, 222 Rem., 223 Rem., 17 Rem.	27270	Stock Assembly, 375 H & H Mag., 458 Win. Mag. (in-
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem.	1 2/2/0	cludes same as standard Magnum except Stock Bolt (2)
	22-250 Rem.		Nut (2), Cover (4) used)
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem.		
	22-250 Rem.		DISCONTINUED or SERVICE PARTS
14756	Magazine, BDL Grade	26270	Barrel Assembly, 280 Rem.
)0951	Magazine Follower, 222 Rem., 223 & 17 Rem.	20467	Extractor, 222 Cal.
<del>)</del> 0982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250	17639	Ejector, 222 Cal.
	Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag. 264
15742	Magazine Spacer, 222 Rem.		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Wln., ADL
15286	Magazine Spacer, 222 Rem., BDL Grade		Grade
1528 <b>6</b>	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222
11133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		Rem., 222 Rem. Mag., 243 Win., BDL Grade
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win.,
15698	Magazine Spring, 22-250 Rem.	1	ADL Grade
15699	Magazine Spring, 22-250 Rem., 6mm Rem. 243 Win.,	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264
	BDL Grade		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win.,	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem.,
	17 Rem.		264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
18843	Rear Scope Base, Varmint	28200	Rear Sight Assembly, Complete (includes Rear Sight
0949	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag.		Assembly, Rear Sight Base, Rear Sight Base Screw (2),
'5 <b>410</b>	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2)
188 <b>42</b>	Scope Base Screw, Rear Varmint	15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag.
6204	Scope Base Screw, Front Varmint	15850	Extractor, 222-223 Rem., 17 Rem.
3380	Stock Assembly, 7mm Rem. Mag., ADL Grade	27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.
3365	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm	27341	Extractor Rivet, 222-223 Rem., 17 Rem.
	Rem., 22-250 Rem., ADL Grade	2/342	Exception minuty 222 220 minuty 17 minute
:3385	Stock Assembly, 7mm Rem. Mag., 264 & 300 Win. Mag.,		
	BDL Grade		

Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

## **MALFUNCTIONS**

## **CAUSE and CORRECTION**

## (Con't. from Page 4)

8

Doesn't Group

### Cause:

- 1. Crown of Barrel damaged. 2. Leading of Bore.
- Oversize Bore.
   Improper bedding of Barrel in Stock.
- 5. Loose Sights.

#### Correction:

- 1. Recrown. 2. Lead or change Barrel.
- 3. Change Barrel.
- 4. Correct bedding.
- 5. Tighten or replace.

### Point of Impact Not Correct

- Cause:
- 1. Barrel not straight.
- 2. Horns, breaks, etc. in Bore.
- 3. Improper or loose Sights.
- Correction:
- 1. Straighten.
- Correct if possible.
   Tighten or change Sights.

### Rev. 382

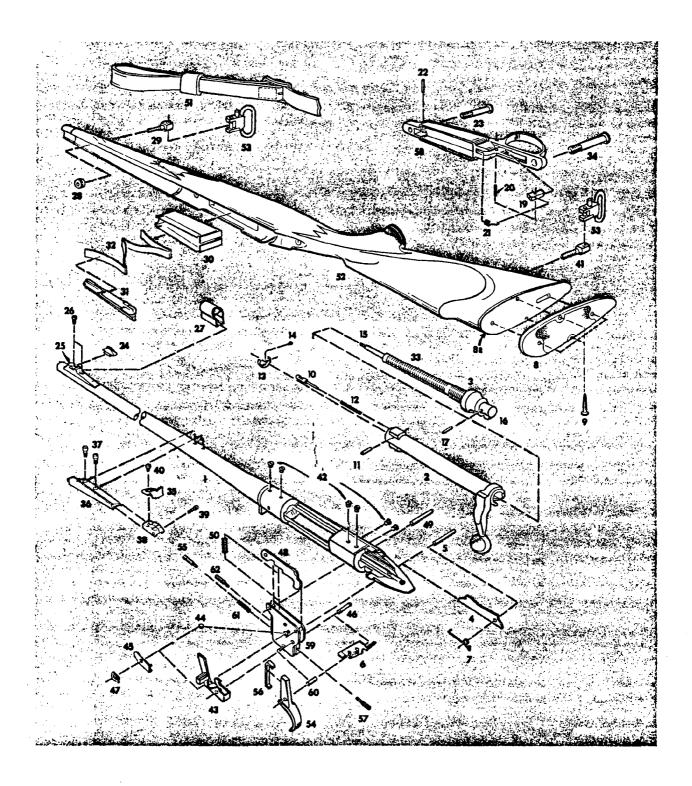
## 10DEL 700 .EFT HAND MODEL

w Part . No.	NAME OF PART		View No.	Part No.	NAME OF PAR	T.
DTE:	Basic 30-06 caliber listed below. F	or other caliber parts	46	17043	Safety Switch Plvot Pin	(Restricted)
	and numbers, see additional calibe	rs list.	47	17044	Safety Switch Snap Washer	(Restricted)
			48	15666	Sear Safety Cam	(Restricted)
	Barrel Assembly		49	24476	Sear Pin	(Restricted)
	Bolt Assembly		50	17047	Sear Spring	(Restricted)
	Bolt Final Assembly		51	30855	Sling Strap Assembly	
17012	Bolt Plug			26990	Sling Strap Assembly and Mounting	s Complete
17013	Bolt Stop	(Restricted)	52	33391	Stock Assembly	
24475	Bolt Stop Pin	(Restricted)		18186	Stock Reinforcing Screw	
90555	Bolt Stop Release	(Restricted)		16970	Stock Reinforcing Screw Dowel	
90554	Bolt Stop Spring	(Restricted)	53	26555	Swivel Assembly (Q.D.)	
90953	Butt Plate		54	15280	Trigger	(Restricted)
90954	Butt Plate Spacer		55	17053	Trigger Adjusting Screw	(Restricted)
25380	Butt Plate Screw			32895	Trigger Assembly	(Restricted)
17017	Ejector		56	19461	Trigger Connector	(Restricted)
17676	Ejector Pin		57	91128	Trigger Engagement Screw	(Restricted)
17019	Ejector Spring		58	26376	Trigger Guard	
91816	Extractor			26371	Trigger Guard Assembly	
27340	Extractor Rivet		59	32905	Trigger Housing Assembly	(Restricted)
15376	Fastener, Sling Strap		60	24477	Trigger Pin	(Restricted)
22020	Firing Pin		61	15400	Trigger Spring	(Restricted)
22040	Firing Pin Assembly		62	15481	Trigger Stop Screw	(Restricted)
17022	Firing Pin Cross Pin					
15291	Floor Plate Latch					
16451	Floor Plate Latch Pin				ADDITIONAL CALIBERS	
16452	Floor Plate Latch Spring		1		ADDITIONAL CALIBERS	
16453	Floor Plate Pivot Pin		1		NOTE: Parts not listed, same as 30-	06 Caliber
22035	Front Guard Screw					UO GANDOL.
15373	Front Sight				Barrel Assembly, 7mm Rem. Mag.	
15719	Front Sight (Low)				Barrel Assembly, 270 Win.	
15635	Front Sight Ramp		1.		Bolt Assembly, 7mm Rem. Mag.	
28505	Front Sight Ramp Screw			91837	Extractor, 7mm Rem. Mag.	
15363	Front Sight Hood			27341	Extractor Rivet, 7mm Rem. Mag.	
15357	Front Swivel Nut			14659	Front Sight, 7mm Rem. Mag.	
15358	Front Swivel Screw			90949	Recoil Pad, 7mm Rem. Mag.	
90957	Grip Cap			25410		
90958	Grip Cap Spacer			33395	Recoil Pad Screw, 7mm Rem. Mag.	
25380	Grip Cap Spacer Screw			33333	Stock Assembly, 7mm Rem. Mag.	
16430	Magazine		1			
91017	Magazine Follower					
15677	Magazine Spring					
17029	Main Spring		1			
26355	Rear Guard Screw		1			
32510	Rear Sight Aperture				•	
91595	Rear Sight Base		1			
28505	Rear Sight Screw		1			
28505 90905	Rear Sight Slide		1			
90906	Elevation Screw					
90904	Windage Screw					
15358	Rear Swivel Screw					
17034	Receiver Plug Screw					
32900	Safety Switch Assembly	(Restricted)	1			
23222	Safety Switch Detent Ball	(Restricted)				
		(Restricted)	1			



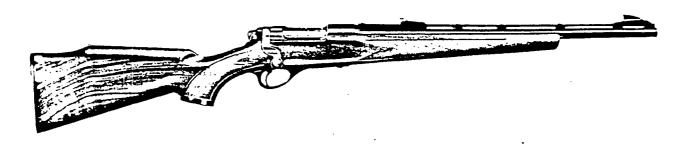
## REMINGTON FIELD SERVICE MANUAL

MODEL 700 LEFT HAND MODEL



# REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight - bead ramp front and adjustable rear - are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

### INDEX

#### Page

#### 1 Bolt Final Assembly, Components ..... 1 Firing Pin Assembly from Bolt Assembly . . . . . . . 1 Ejector – Ejector Spring. 1 Extractor – Extractor Rivet ..... 1 2 Firing Pin Assembly, Components 2 2 Rear Sight Assembly ..... 2 3 3 Stock Assembly 3

#### 3 3 Magazine Follower. 3 Magazine Spring ..... 3 3 Trigger Housing Assembly.... 3 Barrel Assembly 3 Sling Strap Assembly and Mountings Complete . . . . . . 4 Cycle of Operation ..... 4 7 Exploded View.... 8

Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. **Arms Service Division** llion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

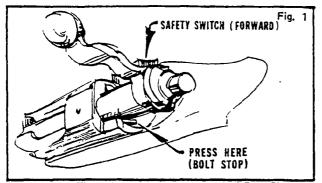
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### MODEL 600

#### BOLT FINAL ASSEMBLY

To Disassemble-Push safety switch assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service – The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun)— Push safety switch forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety switch. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement, then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

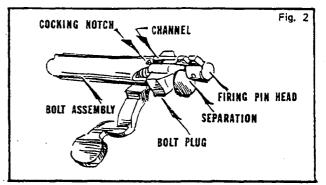
BOLT FINAL ASSEMBLY – COMPONENTS – Include Bolt Assemoly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly – which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

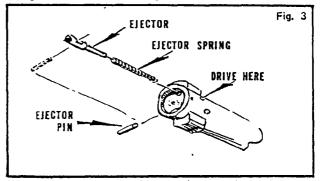
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into to position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

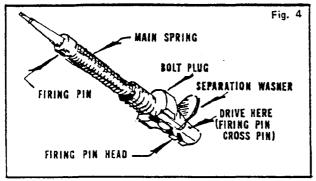
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service – Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

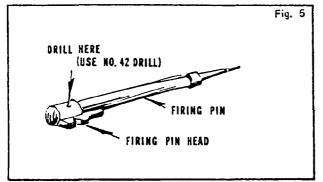
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service —All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY - Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** – includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service — All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See . RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

### REAR SIGHT ASSEMBLY COMPONENTS

REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

### MODEL 600

To Reassemble - Follow reverse order.

**RIB** — is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble – Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger quard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2), reinforcing screw(2). Barrel is free floating.

To Reassemble - Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service - Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER – is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

BARREL ASSEMBLY -- is factory-listed to include barrel, barrel bracket, barrel stud (6) receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service — Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble - Follow reverse order.

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SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick - detachable (Q.D.) type.

#### ASSEMBLE - SWIVEL SCREWS TO STOCK

Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock, Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

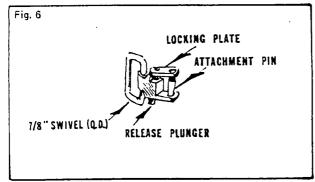
Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightened to stock with front swivel nut.

#### ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 6).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position. Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

## CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are not free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

## MODEL 600

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver.(2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY SWITCH

The safety switch button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety switch had two intentional functions. When safety switch button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety switch in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety switch button forward to FIRE position nullifies above conditions and will allow firing. Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

## MALFUNCTIONS Cause and Correction

#### FIRING

Cause:	<ol> <li>Firing pin damaged.</li> <li>Firing pin binds.</li> <li>Firing pin protrusion faulty.</li> </ol>
	<ol> <li>Trigger assembly out of adjustment.</li> <li>Faulty ammunition.</li> </ol>
Correction:	1. Replace.
	2. Free up or replace.
	3. Replace firing pin.
	4. Return the firearm to the factory.

5. Replace ammunition.

#### UNLOCKING

Cause:	1.	See Extraction.	
	2.	Upset extraction cam on bolt handl	e

- 3. Burr at ejector hole in bolt.
- Blown or set back primer on shell.
- Correction: 1. See Extraction.
  - 2. Smooth up boit handle cam.
  - 3. Deburr.
  - 4. Ammunition may be at fault.

#### EXTRACTION

- Cause: 1. Fouled, rough, or enlarged chamber.
  - 2. Extractor broken or damaged.
  - 3. Not enough hook space on extractor.
  - Height of claw not correct.
- Correction: 1. Polish if fouled or rough. Replace barrel assembly if enlarged.
  - 2. Fit new extractor and rivet.
  - 3. Fit new extractor and rivet.
  - 4. Fit new extractor and rivet.

BOLT BINDS	5	Correction:	1. Ream. 2. Re—head.
Cause:	1. Guard screws protrude into bolt track.	•	3. Re-head.
	2. Receiver plug screws protrude into bolt		4. Fit new extractor (grind relief in new ex-
	track.		tractor behind claw).
	3. Bolt handle interferes with stock.		5. Free up or replace.
			6. Deburr.
<b>.</b> .	4. Damage at rear of bolt lugs.		
Correction:	1. File end of screws.		7. Stone radius.
	2. File end of screws.		
	3. Clear stock or fit new stock.	COCKING	
	4. Stone to blend. Check head space.		
		Cause:	1. Trigger out of adjustment.
EJECTION			2. Improper vertical engagement of sear and
	· ·		connector.
Cause:	<ol> <li>Burr at ejector hole in bolt.</li> </ol>		3. Trigger doesn't retract.
	2. Ejector binds or fails to retract far enough.		<ol><li>Corners on sear or connector rounded.</li></ol>
	3. Extractor binds.	Correction:	<ol> <li>Return the firearm to the factory.</li> </ol>
Correction:	1. Deburr.	•	2. Return the firearm to the factory.
	2. Free up or replace.		3. Return the firearm to the factory.
	3. Adjust or fit new extractor (and rivet).		4. Return the firearm to the factory.
BOLT PULLS	SOUT	BULGES OR	BLOWS CASES
Cause:	1. Bolt stop or bolt release binds.	Cause:	1. Oversize chamber.
	2. Bolt stop or bolt release broken.	۰.	2. Max. head space.
	3. Bolt stop spring damaged.	Correction:	1. Replace barrel assembly.
Correction:	1. Free up.	Goncotion.	2. Fit new bolt.
•••••	2. Return the firearm to the factory.		
	3. Return the firearm to the factory.		ITCH.
	5. Heldin the meanin to the factory.	SAFETY SW	пся
FEEDING		Cause:	1. Safety switch binds (safety switch work
Cause:	1. Magazine follower binds.		hard).
Çabit.	2. Weak or defective follower spring.		2. Safety switch snap washer stretches ou
	· •		(safety switch works too freely).
	3. Magazine spring caught under guard.		3. Safety switch damaged.
	4. Damaged chamfer on bolt head.	Correction:	<ol> <li>Return the firearm to the factory.</li> </ol>
	5. Tabs on follower bent.	•	<ol><li>Return the firearm to the factory.</li></ol>
Correction:	<ol> <li>Adjust side angle on magazine.</li> </ol>		3. Return the firearm to the factory.
	2. Replace spring.		
	3. Correct.	ACCURACY	– Group Size
	<ol><li>Replace bolt, or stone smooth.</li></ol>		
	5. Straighten or replace follower.	Cause:	1. Crown of barrel damaged.
		Quese.	2. Barrel bore fouled.
LOADING	•		3. Enlarged bore.
			4. Improper bedding of barrel in stock.
Cause:	1. Damaged receiver rails.		· · · –
	2. Sharp edge – rear end of chamber.	<b>a</b>	5. Loose sights.
	<ol> <li>Sharp edge — rear end of chamber.</li> <li>Rough loading ramp in receiver.</li> </ol>	Correction:	1. Recrown.
Correction:	1. Polish or reshape.		2. Lead or replace barrel.
conection:	· · · · · ·		3. Replace barrel.
	2. Remove sharpness.		4. Refloat barrel.
	3. Polish ramp.		5. Tighten or replace.
LOCKING		POINT OF I	MPACT
Cause:	1. Shallow throat.	Cause:	1. Barrel not straight.
	2. Min. head space.	Jause.	2. Improper or loose sights.
	3. Damaged chamber.	<b>C</b>	
	4. Extractor interferes with shell rim.	Correction:	1. Straighten or replace barrel.
			2. Tighten or change sights.
	5. Ejector binds or fails to retract far enough.		
	6. Burr at ejector hole in bolt.		
	7. Sharp corners in bolt lugs.		

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Rev. 382

MODEL 600

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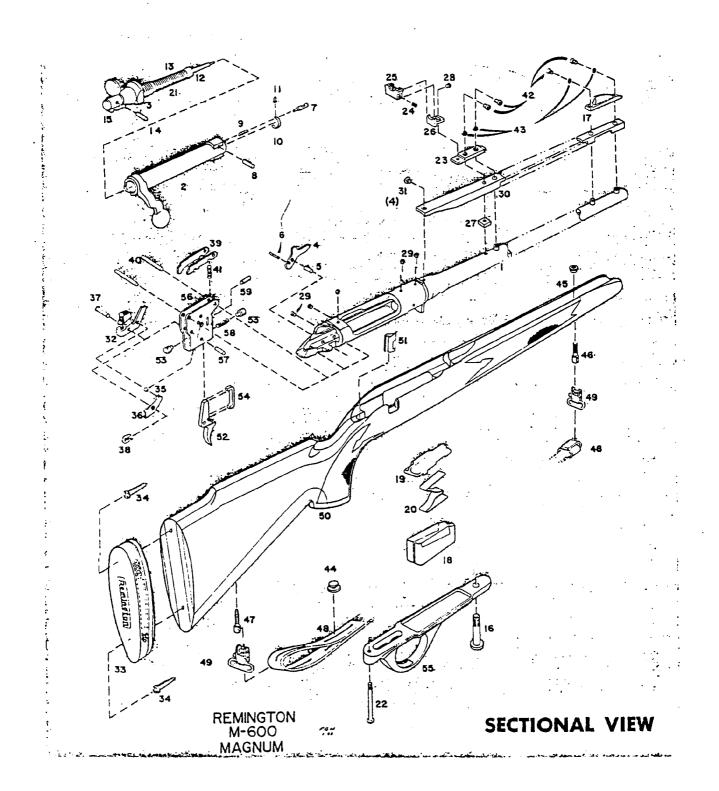
# REMINGTON FIELD SERVICE MANUAL

View No.	No. NAME OF PART			View No.	Part No.	NAME OF PART	
1		Barrel Assembly, 350 Rem. Mag.		41	17047	 Sear Spring	(Restricted)
		Barrel Assembly, 6.5 MM Rem. Mag.		42	15416	Sight Screw	
		Barrei Assembly, 308 Win.		43 .	16968	Sight Washer	
2		Bolt Assembly, 350 Rem. Mag., 6.5 MM Rei	m. Mag.		26990	Sling Strap Assembly and Mountings, (	Complete .
•		Bolt Assembly, 308 Win.				Includes: 44 thru 49	
		Bolt Final Assembly, 350 Rem. Mag., 6.5 MI	MRem	44	15376	Fastener	
				45	15357	Front Swivel Nut	
		Mag. Bola Final Assembly, 208 Win	1	46	15356	- Front Swivel Screw	
•	15409	Bolt Final Assembly, 308 Win.		47	15358	Rear Swivel Screw	
3		Bolt Plug		48	26625	Sling Strap Assembly, 7/8"	
4	15412	Bolt Stop		49	26555	Swivel Assembly, Q.D. (each)	
5	24484	Bolt Stop Pin			27651		ALL Dom
6	15413	Bolt Stop Spring	(Restricted)	50	27051	Stock Assembly, 350 Rem. Mag., 6.5 M	vitat Pretit.
	15741	Butt Plate (Model 600 only)	1		27650	Mag.	
_	25410	Butt Plate Screw (Model 600 only)		51		Stock Assembly	
7	17017	Ejector			15883	Tang Support (Magnum only)	( <b>D</b> )
8	17676	Ejector Pin		52	15435	Trigger	(Restricted)
9	17019	Ejector Spring		53	17049	Trigger Screw, Front	Restricted
0	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Ma	ag.		26730	Trigger Assembly	(Restricted
	16254	Extractor		54	15436	Trigger Connector	(Restricted)
1	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Re		55	15437	Trigger Guard	
		Mag.		56	15429	Trigger Housing	(Restricted)
	27340	Extractor Rivet (except 222 Rem.)	1	57	24477	Trigger Pin	(Restricted
2	15410	Firing Pin		58	17978	Trigger Spring	(Restricted
3	26715	Firing Pin Assembly		59	17053	Trigger Stop Screw	(Restricted
4	17022	Firing Pin Cross Pin					
5	23321	Firing Pin Head					
6	15653	Front Guard Screw					
7	27365	Front Sight Assembly				ADDITIONAL CALIBER PARTS	
8	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Mag	a.				
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	<i>.</i>			(Not Shown in Sectional View)	
9	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM	•				
		Rem. Mag.				Barrel Assembly, 35 Rem. (Supersede	d)
	17056	Magazine Follower				Barrel Assembly, 222 Rem.	
20	17891	Magazine Spring	1			Barrel Assembly, 6MM Rem.	
21	15411	Main Spring				Barrel Assembly, 243 Win.	
22	17580	Rear Guard Screw				Bolt Assembly, 35 Rem. (Superseded)	)
~~	26841	Rear Sight Assembly				Bolt Assembly, 222 Rem.	
	15600	Rear Sight Base, 350 Rem. Mag.				Bolt Final Assembly, 35 Rem. (Super-	seded)
23	15800	Rear Sight Base				Bolt Final Assembly, 222 Rem.	
		÷	1		15852	Ejector, 222 Rem.	
24	15733	Rear Sight Elevation Screw			15850	Extractor, 222 Rem.	
25	15726	Rear Sight Eveniece			27342	Extractor Rivet, 222 Rem.	
26	15728	Rear Sight Leaf			27366	Front Sight Assembly, 6 MM Rem., 24	43 Win
27	15418	Rear Sight Nut			27261	Magazine, 222 Rem.	
28	15732	Rear Sight Windage Screw			27261	-	
	15778	Rear Sight Wrench				Magazine, 35 Rem. (Superseded)	
29	17034	Receiver Plug Screw			16793	Magazine Follower, 222 Rem.	
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM	1		15742	Magazine Spacer, 222 Rem.	
		Rem, Mag.			17983	Magazine Spring, 222 Rem.	
	18186	Reinforcing Screw			15600	Rear Sight Base, 35 Rem. (Superseded	3)
30	15488	Rib					
31	15417	Rib Screw			NOTE:	See Basic Parts List for parts not liste	d above.
32	26795	Safety Switch Assembly	(Restricted)				
13	21386	Recoil Pad (Magnum only)	1				
34	25410	Recoil Pad Screw (Magnum only)					
5	26850	Safety Switch Detent Ball	(Restricted)				
36	15432	Safety Switch Detent Spring	(Restricted)				
37	17043	Safety Switch Pivot Pin	(Restricted)				
38	17044	Safety Switch Snap Washer	(Restricted)				
39	15666	Sear Safety Cam	(Restricted)				
	24476	Sear Pin	(Restricted)				
10			Thisartierom.				

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EXPLODED VIEW

REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

### MODEL 600 MAGNUM

STOCK ASSEMBLY — is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service – Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

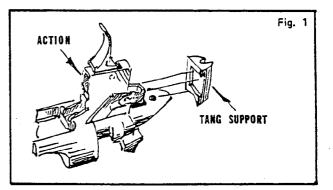
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT'

NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble – Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).



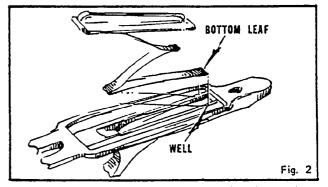
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

To Disassemble - Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble – Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



Turn both guard screws to tighten guard and stock securely to action.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ---- and insures full magnum cartridge in magazine.

To Reassemble – Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

# MODEL 600 - FIELD SERVICE MANUAL

# MARCH - 1982

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## ع-82 REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight – bead ramp front and adjustable rear – are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

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F	'age	

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Bolt Final Assembly, Components 1
Firing Pin Assembly from Bolt Assembly 1
Ejector – Ejector Spring
Extractor – Extractor Rivet 1
Firing Pin Assembly, Components 2
Front Sight Assembly
Rear Sight Assembly 2
Rear Sight Assembly, Components
Rib 3
Trigger Guard
Stock Assembly

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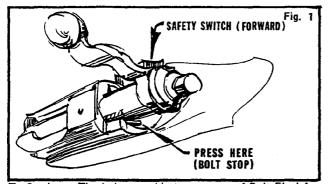
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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

#### BOLT FINAL ASSEMBLY

To Disassemble—Push safety switch assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service — The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun)— Push safety switch forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety switch. Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement, then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

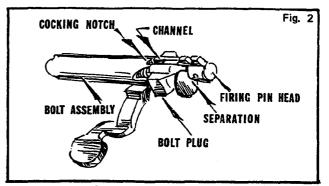
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grip and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

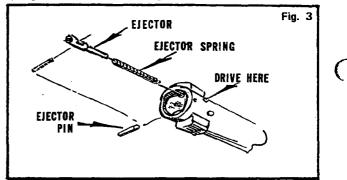
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble – Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



**EJECTOR - EJECTOR SPRING (in Bolt Assembly)** 

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To **Beassemble** – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

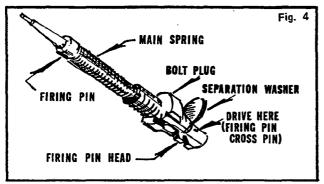
To Disassemble - Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet - from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble – Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY – COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

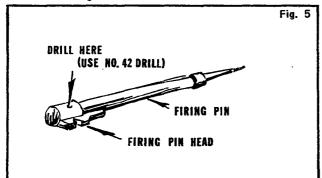
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service —All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



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To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY – Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.

To Service – Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** — includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

#### REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble – A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

**RIB** — is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble -- Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble - Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble – Follow reverse order. Tighten guard screws securely.

**STOCK ASSEMBLY -- COMPONENTS** 

#### BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service – Replacement butt plate may be fitted to stock. Some sanding to match outline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY - is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER — is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

BARREL ASSEMBLY – is factory-listed to include barrel, barrel bracket, barrel stud (6) receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble- Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8" wide. Swivel assemblies are quick - detachable (Q.D.) type.

#### ASSEMBLE - SWIVEL SCREWS TO STOCK

Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock, Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

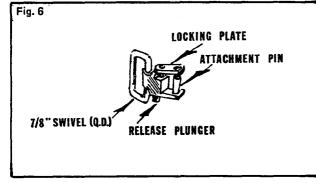
#### Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightened to stock with front swivel nut.

#### ASSEMBLE -- SWIVEL ASSEMBLY (2) O.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 6).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position. Note: To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

## CYCLE OF OPERATION

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are not free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver.(2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY SWITCH

The safety switch button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety switch had two intentional functions. When safety switch button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety switch in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety switch button forward to FIRE position nullifies above conditions and will allow firing.

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

# MALFUNCTIONS

**Cause and Correction** 

FIRING

Cause:	1. Firing pin damaged.
	2. Firing pin binds.
	3. Firing pin protrusion faulty.
	4. Trigger assembly out of adjustment.
	5. Faulty ammunition.
Correction:	1. Replace.
	2. Free up or replace.
	3. Replace firing pin.
	4. Return the firearm to the factory.
	5. Replace ammunition.

#### UNLOCKING

Cause:	1. See Extraction.
	2. Upset extraction cam on bolt handle.
	3. Burr at ejector hole in bolt.
	4. Blown or set back primer on shell.
Correction:	1. See Extraction.
	2. Smooth up bolt handle cam.
	3. Deburr.
	4. Ammunition may be at fault.

#### EXTRACTION

Cause: 1.	•	Fouled,	rough,	or	enlarged	chamber.
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- 2. Extractor broken or damaged.
- 3. Not enough hook space on extractor. 4. Height of claw not correct.
- Correction: 1. Polish if fouled or rough. Replace barrel assembly if enlarged.
  - 2. Fit new extractor and rivet.
  - 3. Fit new extractor and rivet.
  - 4. Fit new extractor and rivet.

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BOLT BIND	S	Correction:	1. Ream.
_			2. Re—head.
Cause:	1. Guard screws protrude into bolt track.		3. Re-head.
	2. Receiver plug screws protrude into bolt		<ol> <li>Fit new extractor (grind relief in new ex- tractor behind claw).</li> </ol>
	track.		5. Free up or replace.
	3. Bolt handle interferes with stock.		6. Deburr.
Correction:	<ol> <li>Damage at rear of bolt lugs.</li> <li>File end of screws.</li> </ol>		7. Stone radius.
Correction:	2. File end of screws.		7. Stone radius.
		COCKING	
	<ol> <li>Clear stock or fit new stock.</li> <li>Stone to blend. Check head space.</li> </ol>	COCKING	
	4. Stone to blend, check head space.	Cause:	1. Trigger out of adjustment.
EJECTION		oddie.	2. Improper vertical engagement of sear and
EJECTION			connector.
Cause:	1. Burr at ejector hole in bolt.		3. Trigger doesn't retract.
Gauge.	2. Ejector binds or fails to retract far enough.		4. Corners on sear or connector rounded.
	3. Extractor binds.	Correction:	1. Return the firearm to the factory.
Correction:	1. Deburr.		2. Return the firearm to the factory.
001100000	2. Free up or replace.		3. Return the firearm to the factory.
	3. Adjust or fit new extractor (and rivet).		4. Return the firearm to the factory.
BOLT PULL	SOUT	BULGES OR	BLOWS CASES
Cause:	1. Bolt stop or bolt release binds.	Cause:	1. Oversize chamber.
	2. Bolt stop or bolt release broken.		2. Max. head space.
	3. Bolt stop spring damaged.	Correction:	1. Replace barrel assembly.
Correction:	1. Free up.		2. Fit new bolt.
	<ol><li>Return the firearm to the factory.</li></ol>		
	3. Return the firearm to the factory.	SAFETY SW	ЛТСН
			•
FEEDING		Cause:	1. Safety switch binds (safety switch works
Cause:	1. Magazine follower binds.		hard).
ouuse.	2. Weak or defective follower spring.		2. Safety switch snap washer stretches out
	3. Magazine spring caught under guard.		(safety switch works too freely).
	4. Damaged chamfer on bolt head.	0	3. Safety switch damaged.
	5. Tabs on follower bent.	Correction:	1. Return the firearm to the factory.
Correction:	1. Adjust side angle on magazine.		2. Return the firearm to the factory.
	2. Replace spring.		3. Return the firearm to the factory.
	3. Correct.		(
	4. Replace bolt, or stone smooth.	ACCORACT	' – Group Size
	5. Straighten or replace follower.	Cause:	1. Crown of barrel damaged.
		Gause.	2. Barrel bore fouled.
LOADING			3. Enlarged bore.
			4. Improper bedding of barrel in stock.
Cause:	1. Damaged receiver rails.		5. Loose sights.
	2. Sharp edge - rear end of chamber.	Correction:	1. Recrown.
	3. Rough loading ramp in receiver.	correction.	
Correction:	1. Polish or reshape.		2. Lead or replace barrel. 3. Replace barrel.
	2. Remove sharpness.		4. Refloat barrel.
	3. Polish ramp.		5. Tighten or replace.
			5. righten of replace.
LOCKING		POINT OF I	MPACT
Cause:	1. Shallow throat.	Cause:	1. Barrel not straight.
	2. Min. head space.		2. Improper or loose sights.
	3. Damaged chamber.	Correction:	1. Straighten or replace barrel.
	4. Extractor interferes with shell rim.	40.100110111	2. Tighten or change sights.
	5. Ejector binds or fails to retract far enough.		E. Content of origingo argitta.
	6. Burr at ejector hole in bolt.		
	7. Sharp corners in bolt lugs.		

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MODEL 600

PARTS LIST

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# REMINGTON FIELD SERVICE MANUAL

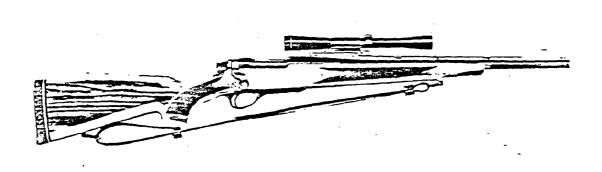
lew No.	Part No.	NAME OF PART		View No.	Part No.	NAME OF PART		
1		Barrel Assembly, 350 Rem. Mag.		41	17047	Sear Spring	(Restricted)	
		Barrel Assembly, 6.5 MM Rem. Mag.		42	15416	Sight Screw		
		Barrel Assembly, 308 Win.		43	16968	Sight Washer		
2		Bolt Assembly, 350 Rem. Mag., 6.5 MM Re	em. Mag.		26990	Sling Strap Assembly and Mountings,	Complete	
		Bolt Assembly, 308 Win.	•			Includes: 44 thru 49	• • • •	
		Boit Final Assembly, 350 Rem. Mag., 6.5 M	M Rem.	44	15376	Fastener		
		Mag.		45	15357	Front Swivel Nut		
		Bolt Final Assembly, 308 Win.		46	15356	Front Swivel Screw		
3	15409	Bolt Plug		47	15358	Rear Swivel Screw		
4	15412	Bolt Stop	(Restricted)	48	26625	Sling Strap Assembly, 7/8"		
5	24484	Bolt Stop Pin	(Restricted)	49	26555	Swivel Assembly, Q.D. (each)		
5	15413	Bolt Stop Spring	(Restricted)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5	MM Rem.	
	15741	Butt Plate (Model 600 only)	• • • • • • • •			Mag.		
	25410	Butt Plate Screw (Model 600 only)			27650	Stock Assembly		
7	17017	Ejector		51	15883	Tang Support (Magnum only)		
3	17676	Ejector Pin		52	15435	Trigger	(Restricted)	
)	17019	Ejector Spring		53	17049	Trigger Screw, Front	(Restricted)	
5	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. M	aq.		26730	Trigger Assembly	(Restricted)	
	16254	Extractor	-a.	54	15436	Trigger Connector	(Restricted)	
	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM R	em.	55	15437	Trigger Guard		
	21071	Mag.		56	15429	Trigger Housing	(Restricted)	
	27340	Extractor Rivet (except 222 Rem.)		57	24477	Trigger Pin	(Restricted)	
2	15410	Firing Pin		58	17978	Trigger Spring	(Restricted)	
3	26715	Firing Pin Assembly		-59	17053	Trigger Stop Screw	(Restricted)	
i.	17022	Firing Pin Cross Pin					(Heathered)	
5	23321	Firing Pin Head						
;	15653	Front Guard Screw				•		
,	27365	Front Sight Assembly				ADDITIONAL CALIBER PARTS		
\$	15648	Magazine 350 Rem. Mag., 6,5 MM Rem. Ma	~					
•	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	9·	1		(Not Shown in Sectional View)		
•	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM						
	13007	Rem. Mag.				Barrel Assembly, 35 Rem. (Supersede	d)	
	17056	Magazine Follower				Barrel Assembly, 222 Rem.		
)	17891	Magazine Spring				Barrel Assembly, 6MM Rem.		
Ì	15411	Main Spring		1		Barrel Assembly, 243 Win.		
2	17580	Rear Guard Screw		1		Boit Assembly, 35 Rem. (Superseded)	1	
•	26841	Rear Sight Assembly				Bolt Assembly, 222 Rem.		
}	15600	Rear Sight Base, 350 Rem. Mag.				Bolt Final Assembly, 35 Rem. (Super	sected)	
	15727	Rear Sight Base		1		Bolt Final Assembly, 222 Rem.		
Ļ	15733	Rear Sight Elevation Screw			15852	Ejector, 222 Rem.		
	15726	Rear Sight Eyepiece			15850	Extractor, 222 Rem.		
3	15728	Rear Sight Leaf			27342	Extractor Rivet, 222 Rem.		•
,	15418	*			27366	Front Sight Assembly, 6 MM Rem., 2	43 W/m	
3		Rear Sight Nut		1	27261	Magazine, 222 Rem.	43 1411.	
,	15732	Rear Sight Windage Screw		1	27262	Magazine, 222 Rem. Magazine, 35 Rem. (Superseded)		
)	15778	Rear Sight Wrench		1	16793	Magazine, 55 Nem. (Superseded) Magazine Follower, 222 Rem,		
,	17034	Receiver Plug Screw		1	15742			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM		1	17983	Magazine Spacer, 222 Rem. Magazine Spring, 222 Rem.		
	10106	Rem. Mag.		1	15600	Magazine Spring, 222 Rem. Bear Sight Bare, 35 Rem. (Supercoder	4	
	18186	Reinforcing Screw		I	10000	Rear Sight Base, 35 Rem. (Superseded	.,	
)	15488	Rib Bib Server			NOTE:	See Paris Parts List for must an it	4	
	15417	Rib Screw	(Dentation 1)	1	NUTE:	See Basic Parts List for parts not listed	au0ve.	
	26795	Safety Switch Assembly	(Restricted)	1				
	21386	Recoil Pad (Magnum only)						
	25410	Recoil Pad Screw (Magnum only)	(Describer 1)					
	26850	Safety Switch Detent Ball	(Restricted)					
	15432	Safety Switch Detent Spring	(Restricted)	1				
	17043	Safety Switch Pivot Pin	(Restricted)	1				
	17044	Safety Switch Snap Washer	(Restricted)					
)	15666	Sear Safety Cam	(Restricted)					
	24476	Sear Pin	(Restricted)	ļ				
				1		••		

# REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This bolt action repeater has the same strong action features as Standard Model 600. The barrel is turned extra heavy to keep magnum loads on target. The action, however, is custom-bedded in firm-setting epoxy at barrel bracket slot in stock. A "Delrin" tang support at rear gives added bearing in stock for the magnum action.

**(**\* 2.

(5)

This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

The Monte Carlo stock is laminated for the Magnum Model 600 ---- two color select wood laminates are carefully bonded, sealed, and shaped to give strength and rigidity. Custom checkering is applied to grip and forearm of stock and protected overall with the durable and lustrous Du Pont RK-W wood finish.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum. MODEL 600 Magnum Introduction

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## REMINGTON FIELD SERVICE MANUAL

Remington has introduced a raised barrel bracket on the Magnum Model 600 Carbine. Long eye relief telescope mounts must be assembled snugly against this bracket. Rear sight may be removed to locate long relief mount bases in forward position. Standard eye relief mounts may also be assembled against bracket and to receiver by removing receiver plug screws.

See MAGNUM Instruction Folder - RD 3653 for care and operation information. This folder also contains part prices, service and shipping instructions.

This SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

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MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

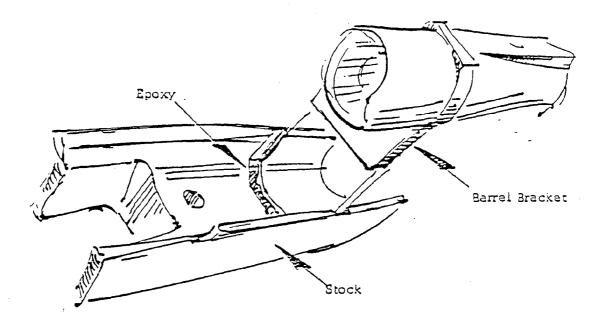
## JFF:T 665 Ilion Res.Div.

MODEL 600 Magnum Assembly Page 1

## REMINGTON FIELD SERVICE MANUAL

STOCK ASSEMBLY - is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

<u>To Disassemble</u> - Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock. See Sketch.



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. شور د NOTE: "Delrin" tang support may separate from action at rear.

- <u>To Service</u> Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.
  - NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

MODEL 500 Magnum Assembly Page 2

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### REMINGTON FIELD SERVICE MANUAL

### STOCK ASSEMBLY - Continued

- <u>To Service</u> Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.
  - NOTE: Barrel should assemble free-floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position. Consistent accuracy is thus attained ---- shot after shot.
  - NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT.
  - NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

- <u>To Disassemble</u> Remove stock assembly. Remove loosened tang support from rear of action.
- <u>To Service</u> Replacement tang supports are interchangeable with no adjustment required.

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MODEL 500 Magnum Assembly Page 3

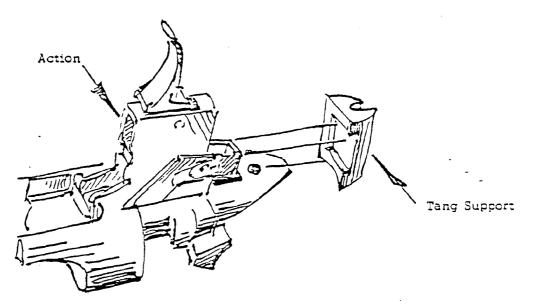
## REMINGTON FIELD SERVICE MANUAL

### TANG SUPPORT - Continued

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<u>To Reassemble</u> - Tang support must be positioned at rear of action before action is replaced in stock. See sketch.



Reassemble stock assembly to action. Tighten firmly with guard screws.

TRIGGER GUARD - is designed of lightweight Du Pont "Delrin" material with expanded rib section at bottom. This insures full magazine capacity for Magnum Carbine.

<u>To Disassemble</u> - Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

<u>To Service</u> - Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard <u>without expanded rib</u> section on Standard Model 600. MCDEL 500 Magnum Assembly Page 4

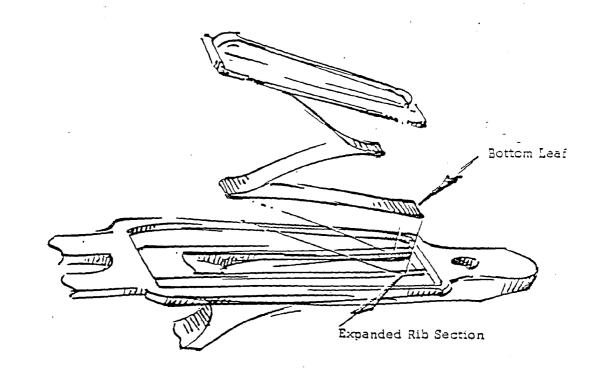
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## REMINGTON FIELD SERVICE MANUAL

TRIGGER GUARD - Continued

<u>To Reassemble</u> - Make certain bottom leaf of magazine spring locates centrally into expanded rib section of trigger guard. See sketch.



Turn both guard screws to tighten guard and stock securely to action.

MCDEL 600 Magnum Assembly Page 5

R2524244

## REMINGTON FIELD SERVICE MANUAL

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom leaf of magazine spring against trigger guard ---- and insures full Magnum cartridge capacity in magazine.

<u>To Reassemble</u> - Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

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REMINGTON FIELD SERVICE MANUAL

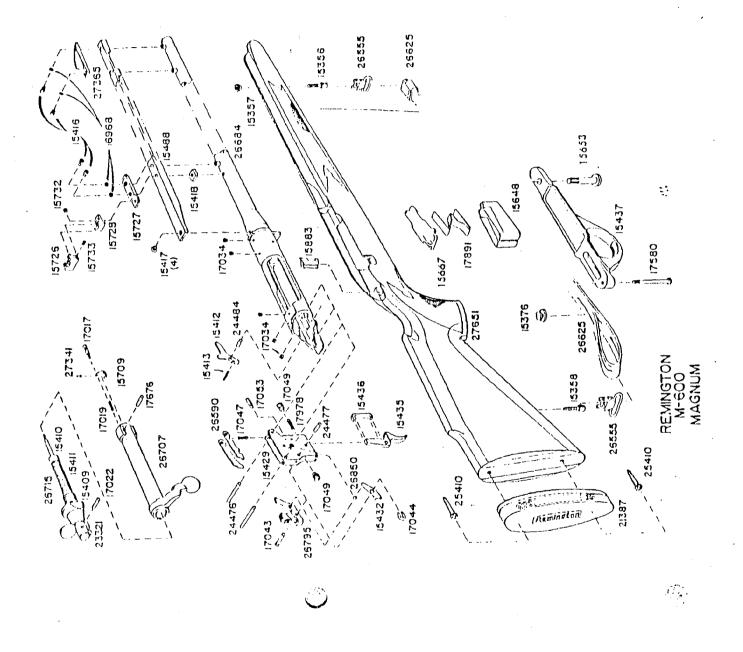
MCDEL 500 Magnum

Sectional View

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## REMINGTON FIELD SERVICE MANUAL

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The Remington MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 has been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



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The Monte Carlo stock is laminated for the Magnum Model 600 ---- two color select wood laminates are carefully bonded, sealed, and shaped to give strength and rigidity. Custom checkering is applied to grip and forearm of stock and protected overall with the durable and lustrous Du Pont RK-W wood finish.

A recoil pad and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum. MODEL 600 Magnum Introduction

## REMINGTON FIELD SERVICE MANUAL

Remington has introduced a raised barrel bracket on the Magnum Model 600 Carbine. Long eye relief telescope mounts must be assembled snugly against this bracket. Rear sight may be removed to locate long relief mount bases in forward position. Standard eye relief mounts may also be assembled against bracket and to receiver by removing receiver plug screws.

See MAGNUM Instruction Folder - RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

This SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

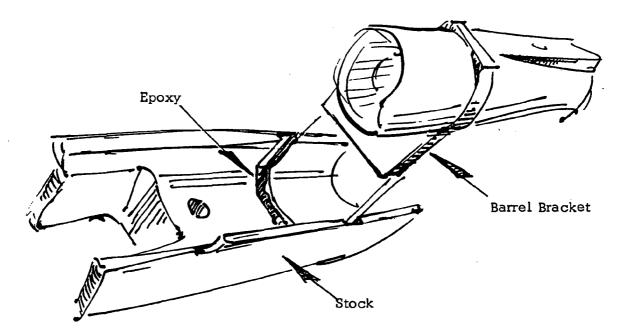
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## REMINGTON FIELD SERVICE MANUAL

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STOCK ASSEMBLY - is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

<u>To Disassemble</u> - Unscrew and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock. See Sketch.



NOTE: "Delrin" tang support may separate from action at rear.

- <u>To Service</u> Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.
  - NOTE: Use all recommended epoxy handling precautions. To apply --- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

MODEL 600 Magnum Assembly

Page 2

## REMINGTON FIELD SERVICE MANUAL

### STOCK ASSEMBLY - Continued

- <u>To Service</u> Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.
  - NOTE: Barrel should assemble free-floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position. Consistent accuracy is thus attained ---- shot after shot.
  - NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See TANG SUPPORT.
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TANG SUPPORT - is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

- <u>To Disassemble</u> Remove stock assembly. Remove loosened tang support from rear of action.
- <u>To Service</u> Replacement tang supports are interchangeable with no adjustment required.

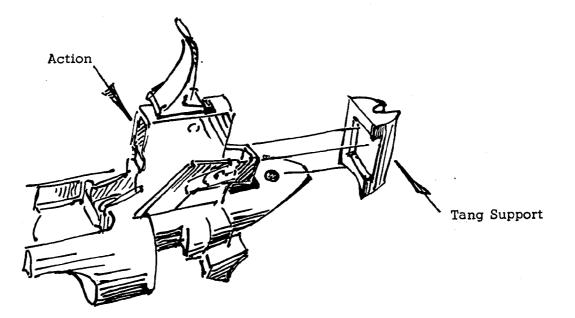
MODEL 600 Magnum Assembly Page 3

## REMINGTON FIELD SERVICE MANUAL

### TANG SUPPORT - Continued

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<u>To Reassemble</u> - Tang support must be positioned at rear of action before action is replaced in stock. See sketch.



Reassemble stock assembly to action. Tighten firmly with guard screws.

TRIGGER GUARD - is designed of lightweight Du Pont "Delrin" material with expanded rib section at bottom. This insures full magazine capacity for Magnum Carbine.

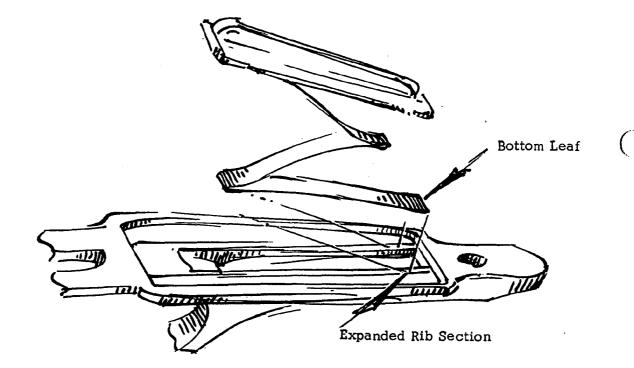
- <u>To Disassemble</u> Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.
- <u>To Service</u> Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard <u>without expanded rib</u> section on Standard Model 600.

MODEL 600 Magnum Assembly Page 4

## REMINGTON FIELD SERVICE MANUAL

TRIGGER GUARD - Continued

<u>To Reassemble</u> - Make certain bottom leaf of magazine spring locates centrally into expanded rib section of trigger guard. See sketch.



Turn both guard screws to tighten guard and stock securely to action.

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## REMINGTON FIELD SERVICE MANUAL

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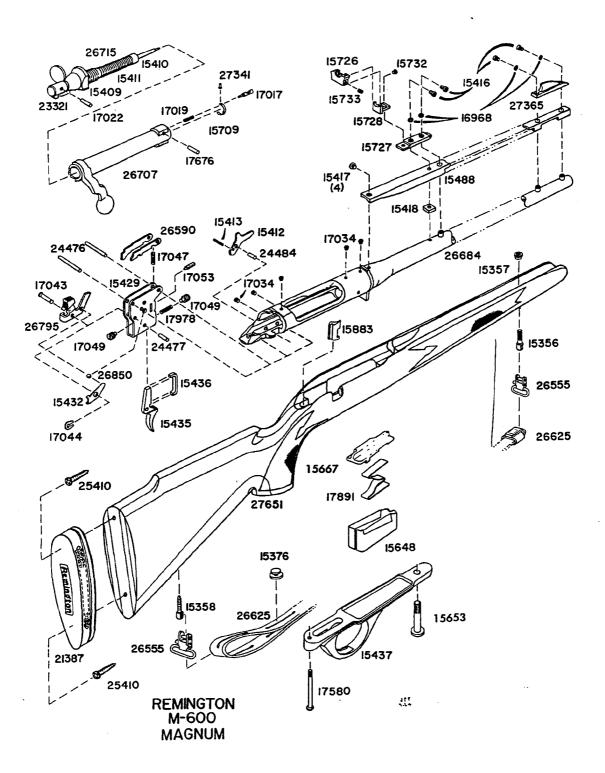
MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom leaf of magazine spring against trigger guard ---- and insures full Magnum cartridge capacity in magazine.

<u>To Reassemble</u> - Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver. MODEL 600 Magnum Sectional View

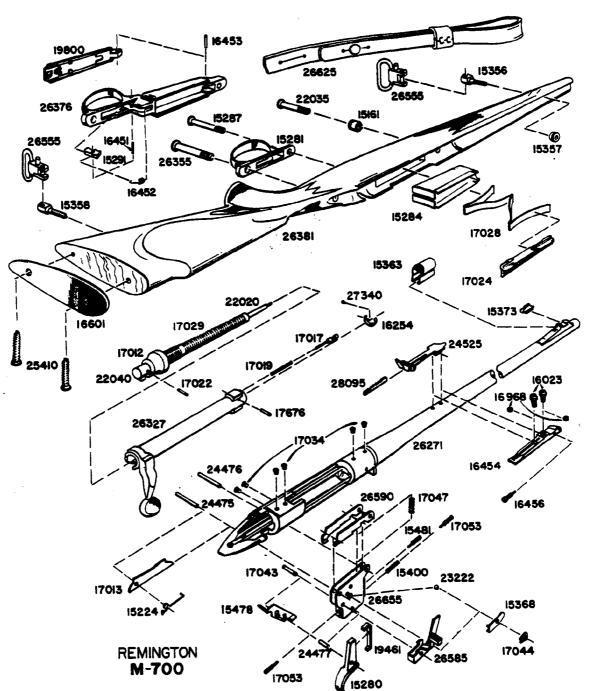
Page 6

## REMINGTON FIELD SERVICE MANUAL



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MODEL 700 Sectional View Page 6



REMINGTON FIELD SERVICE MANUAL

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MODEL 600

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 600 is a light weight, compact length carbine. This bolt action repeater is produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sight — bead ramp front and adjustable rear — are mounted on a ventilated rib barrel. The receiver is drilled and tapped for telescope or receiver sights.



The Instruction Folder/Parts Lists, Form RD 5473, packaged with each gun gives operating instructions, care and maintenance for the Remington Model 600. A breakdown of part prices, service, and shipping instructions is included.

INDEX			
	Page		Page
Bolt Final Assembly.         Bolt Final Assembly, Components         Firing Pin Assembly from Bolt Assembly         Ejector - Ejector Spring.         Extractor - Extractor Rivet         Firing Pin Assembly, Components         Front Sight Assembly.         Rear Sight Assembly, Components         Rear Sight Assembly, Components         Rib.	1 1 1 2 2 2 2 3	Stock Assembly, Components Magazine Assembly Magazine Follower. Magazine Spring Magazine Spacer Trigger Housing Assembly Barrel Assembly Sling Strap Assembly and Mountings Complete Cycle of Operation Malfunctions	3 . 3 . 3 . 3 . 3 . 3 . 4 . 4 . 5-6
Trigger Guard	3	Parts List	

Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

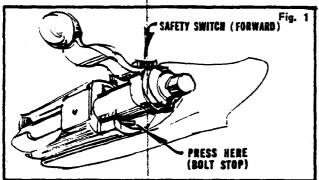
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All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

## MODEL 600

#### BOLT FINAL ASSEMBLY

To Disassemble—Push safety switch assembly forward to FIRE position. Lift bolt handle to unlock and open action. Pull bolt rearward until bolt stop halts bolt. Insert small tool against bolt stop and press downward (See Fig. 1). This will release bolt. Withdraw bolt final assembly from gun.



To Service — The bolt assembly component of Bolt Final Assembly is serially numbered to match the serial number on the gun. Selective assembly at factory is required for replacement. However, the firing, cocking, extractor, and ejector parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble (To Gun)— Push safety switch forward to FIRE position. Insert bolt to gun with lugs positioned horizontally ahead of safety switch Push bolt forward, by upraised handle, until bolt stop snaps into place to lock bolt in gun.

Note: Bolt must remain "cocked" to put into gun. If bolt becomes uncocked, firing pin head will be forward and show as nearly flush to bolt plug at rear. TO COCK BOLT, hold firing pin head firmly to prevent movement, then turn bolt with handle. Bolt will cam on cocking surface (beneath handle) against firing pin head. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and ready for re-entry to gun.

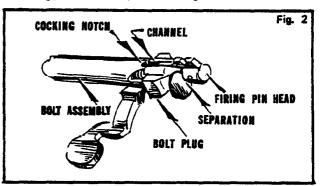
BOLT FINAL ASSEMBLY + COMPONENTS - Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from gun. Hold firing pin head in secure grie and pull away remainder of assembly until separation is visible at rear of bolt plug. Insert thin washer (or coin) in separation (See Fig. 2) Then turn bolt plug to unscrew firing pin assembly from bolt assembly.

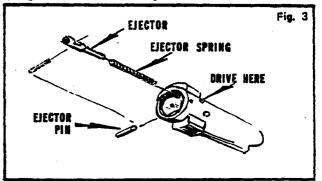
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble — Hold washer (or coin) separation between firing pin head and bolt plug. Insert firing pin assembly into bolt assembly. Turn bolt plug to screw firing pin assembly into position. Position final turn of plug until channel in bottom of plug matches small cocking notch on rear rim of bolt. See sketch below. Then remove separation washer (or coin) to allow firing pin head to snap into cocking notch.



EJECTOR - EJECTOR SPRING (in Bolt Assembly)

To Disassemble – Remove bolt final assembly from gun. Drive out ejector pin. Pull out and disassemble ejector and ejector spring from bolt face. (See Fig. 3).



To Reassemble – Insert ejector spring and ejector into bolt face. Push in ejector and hold against ejector spring tension. Line up ejector pin slot in ejector to pin hole in bolt. Drive in ejector pin.

Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

#### EXTRACTOR - EXTRACTOR RIVET (in Bolt Assembly)

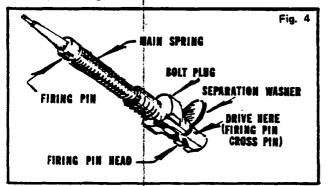
To Disassemble – Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet – from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cart-ridge case to check extractor tension.

To Reassemble — Position extractor within rim in bolt face. Line up with rivet hole in bolt. Insert replacement extractor rivet into extractor to protrude from outside of bolt. Support head of rivet inside bolt rim; then peen over protruding, end of rivet to tighten extractor in bolt. Reassemble ejector to bolt.

FIRING PIN ASSEMBLY - COMPONENTS include: Firing pin, Main Spring, Bolt Plug, Firing Pin Head, Firing Pin Cross Pin (In Firing Pin Assembly).

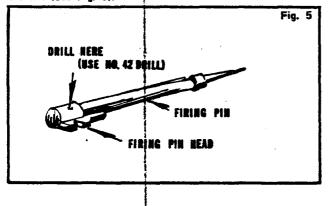
To Disassemble – Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (See Fig. 4).



Precaution: Main spring is under tension.

To Service —All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093..).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstruction. Seat shank of firing pin firmly into firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank . (See Fig. 5).



To Reassemble – Reassemble all parts of FIRING PIN AS-SEMBLY. Hold bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

FRONT SIGHT ASSEMBLY – Includes Front Sight, Front Sight Bead.

To Disassemble – Unscrew Sight screw (2). A thin white nylon sight washer (2) is seated under sight screw head. Lift and disassemble rear sight assembly from rib on barrel.

To Service - Interchangeable as replacement, However, bright metal bead is factory welded to front sight. Replace as an assembly.

To Reassemble – Reposition front sight assembly upon rib. Align sight holes to matching holes in barrel studs. Screw in sight screws (2) to secure front sight assembly to barrel.

**REAR SIGHT ASSEMBLY** – includes Elevation Screw, Rear Sight Base, Rear Sight Eyepiece, Rear Sight Leaf, Windage screw.

To Disassemble – Unscrew sight screw (2) in rear sight base. A thin white nylon sight washer (2) is seated under sight screw head. Lift disassemble rear sight assembly from rib on barrel.

To Service – All parts of rear sight assembly are interchangeable. No factory fitting required.

Note: A rear sight nut is seated under rib to tighten rear sight screw to rib. Rib must be removed to service this nut. See RIB Disassembly.

To Reassemble – Relocate rear sight assembly to rib on barrel. Screw in sight screw to tighten front of base to barrel stud. Tighten sight screw at rear of sight base into rear sight nut which underlies rib.

#### REAR SIGHT ASSEMBLY COMPONENTS

#### REAR SIGHT EYEPIECE ELEVATION SCREW

To Disassemble — A small rear sight wrench is supplied with each gun. This wrench fits into small socket head of elevation screw to turn elevation screw. Unscrew to loosen eyepiece. Slide rear sight eyepiece up and disassemble from rear sight leaf. Use wrench also for windage screw.

REAR SIGHT BASE REAR SIGHT LEAF WINDAGE SCREW

To Disassemble – Unscrew and remove windage screw. Lift and disassemble rear sight leaf from rear sight base.

Note: Rear sight base for 35 Rem. Caliber is slightly higher than base used for other calibers.

To Reassemble - Follow reverse order.

**RIB** — is designed of Du Pont "Zytel" to provide a light weight, matted sight line and for location of sights.

To Disassemble – Remove front and rear sights. Unscrew and remove rib screw (4). Lift and disassemble rib from barrel.

Note: When rib is removed, a small rear sight nut will also disassemble from beneath the rearmost rear sight hole.

To Reassemble - Follow reverse order, taking care that rear sight nut is placed beneath rib in proper position.

#### TRIGGER GUARD

To Disassemble – Unscrew front guard screw, rear guard screw. Lift away and disassemble trigger guard.

Note: Stock assembly can also be disassembled when trigger guard is removed.

To Reassemble – Follow reverse order. Make certain both front and rear guard screws are tightened evenly and securely to receiver.

#### STOCK ASSEMBLY

To Disassemble – Unscrew both front and rear trigger guard screws. Remove trigger guard. Lift away and disassemble stock assembly from barrel and action.

To Service – Interchangeable as replacement. No adjustment required. Replacement includes stock, butt plate, butt plate screw (2)., reinforcing screw(2). Barrel is free floating.

To Reassemble – Follow reverse order. Tighten guard screws securely.

STOCK ASSEMBLY - COMPONENTS

BUTT PLATE BUTT PLATE SCREW (2)

To Disassemble – Unscrew and remove butt plate screw (2). Disassemble butt plate from stock.

To Service - Replacement butt plate may be fitted to stock. Some sanding to match qutline of stock may be required.

To Reassemble - Follow reverse order.

MAGAZINE ASSEMBLY  $\rightarrow$  is "fixed" box design for top loading operation only.

To Disassemble – Unscrew guard screws and remove trigger guard. Remove loosened stock assembly. Unscrew magazine support screw (1). Loosen and disassemble magazine assembly.

:

Note: Magazine follower and magazine spring will disassemble when magazine assembly is removed. Magazine spacer, used for 222 Rem. Caliber, will also disassemble.

To Reassemble – Follow reverse order. Make sure magazine follower and spring are held tightly enclosed as magazine is reassembled. Locate magazine fully into magazine cavity from bottom of receiver. Magazine support at front magazine should seat against bottom of receiver. Insert support screw and turn to tighten magazine assembly in position.

#### MAGAZINE FOLLOWER MAGAZINE SPRING

To Disassemble – Remove trigger guard. Remove stock. Remove magazine assembly. Magazine follower and magazine spring will disassemble freely from magazine assembly. Lift rear of magazine spring and slide back to disassemble from magazine follower.

To Reassemble – Follow reverse order. Make certain magazine assembly (with enclosed follower and spring) is snapped fully into magazine cavity in receiver from below. Tighten magazine securely with magazine support screws.

MAGAZINE SPACER — is designed for load spacing use with smaller .222 Rem. caliber cartridge.

To Disassemble – Remove trigger guard. Remove stock assembly. Remove magazine assembly, magazine follower, magazine spring. Disassemble magazine spacer from magazine assembly.

To Reassemble – Follow reverse order. Make sure magazine Follower and spring function properly with assembled spacer.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

BARREL ASSEMBLY - is factory-listed to include barrel, barrel bracket, barrel stud (6) receiver. Special factory processes join the components of this assembly.

To Disassemble – Remove sights and rib. Remove bolt final assembly. Remove trigger guard and stock assembly. Remove magazine and trigger assemblies. Remove bolt stop and spring. Unscrew and remove receiver plug screws (5).

To Service – Selective assembly at factory as replacement. Special gauges and fixture and factory processing is required for proper operation with bolt final assembly. Replace as an assembly.

To Reassemble- Follow reverse order.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETE (Part No. 26990) — include front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, rear keeper, front keeper, fastener, Strap is 7/8'' wide. Swivel assemblies are quick - detachable (Q.D.) type.

#### ASSEMBLE - SWIVEL SCREWS TO STOCK

Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom of stock, Countersink this drilled hole with No. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

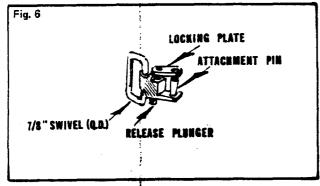
## Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut - Use 3/8 inch drill.

Locate screw hole approx. 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tightened to stock with front swivel nut.

#### ASSEMBLE - SWIVEL ASSEMBLY (2) Q.D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 6).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### ASSEMBLE - STRAP TO ASSEMBLED SWIVELS

Remove front keeper (band) if on strap. Insert tongue of strap thru rear swivel. Then loop strap back and thru attached rear keeper. Draw strap thru keeper until tight loop is made against rear swivel. Slide front keeper on free end of strap. The insert strap thru front swivel and double strap back thru attached front keeper. Assemble brass fastener thru matching slots in strap to join strap in desired position. **Note:** To disassemble strap from rifle, simply unsnap quick detachable (Q.D.) swivels from swivel screws in stock. Remove strap and attached swivels from stock.

## **CYCLE OF OPERATION**

Model 600 Carbine is a light weight, high power, bolt action, fixed magazine repeater chambered for a number of center fire calibers. The vent rib barrel makes it a natural sighter, plus receiver being drilled and tapped ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by spring-loaded firing pin and main spring drives firing pin forward to strike primer.

### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operation cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor.

During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are not free of locking shoulder in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

With the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagementy are made by this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver.(2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired, by release of trigger.

#### SAFETY SWITCH

The safety switch button, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety switch had two intentional functions. When safety switch button is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam, that locks cam against Firing pin head preventing firing. Second function of safety switch in this SAFE position brings an arm into slot in bolt preventing bolt being opened. Pushing safety switch button forward to FIRE position nullifies above conditions and will allow firing

Listed below are possible "cause" and "correction" of malfunctions. Each grouping will correspond basically to movement of bolt as related to the Cycle of Operations.

Quite often, during the occurence of a malfunction, evidence of cause may be found in a careful study of cartridge itself. Take a look at the brass case or bullet end of unfired cartridge. Frequently damage will mark cartridge or bullet in some telltale manner during bolt operation.

Excessive wear or damage to gun parts may also point up cause of gun failure. Inspect appearance of components after "dry" cycling action a few times (without ammunition).

# MALFUNCTIONS

**Cause and Correction** 

FIRING

Cause:	1. Firing pin damaged.	
	2. Firing pin binds.	
	3. Firing pin protrusion faulty.	
	4. Trigger assembly out of adjustment.	
	5. Faulty ammunition.	
Correction:	1. Replace.	
	2. Free up or replace.	
	3. Replace firing pin.	
	4. Return the firearm to the factory.	
	5. Replace ammunition.	
UNLOCKING		

Cause:	1. See Extraction.
	2. Upset extraction carn on bolt handle.
	3. Burr at ejector hole in bolt.
	4. Blown or set back primer on shell.
Correction:	1. See Extraction.
	2. Smooth up bolt handle cam.
	3. Deburr.
•	4. Ammunition may be at fault.

Ca

use:	1.	Fouled,	rough	, or

- 2. Extractor broken or damaged.
- 3. Not enough hook space on extractor.

enlarged chamber.

- 4. Height of claw not correct. 1. Polish if fouled or rough. Replace barrel as-
- Correction:
  - sembly if enlarged. 2. Fit new extractor and rivet.
  - 3. Fit new extractor and rivet.
  - 4. Fit new extractor and rivet.

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BOLT BINDS	5	Correction:	1. Ream. 2. Re—head.
Cause:	1. Guard screws protrude into bolt track.		3. Re-head.
Gause.	2. Receiver plug screws protrude into boit track.		4. Fit new extractor (grind relief in new ex-
	track.		tractor behind claw).
	3. Bolt handle interferes with stock.		5. Free up or replace.
	4. Damage at rear of bolt lugs.		6. Deburr.
Correction:	1. File end of screws.		7. Stone radius.
Correction:	2. File end of screws.		7. Stone radius.
	3. Clear stock or fit new stock.	COCKING	
		COCKING	
	4. Stone to blend. Check head space.	C	• Triana and failure and
		Cause:	1. Trigger out of adjustment.
EJECTION			2. Improper vertical engagement of sear and
_			connector.
Cause:	V Burr at ejector hole in bolt.		3. Trigger doesn't retract.
	2. Ejector binds or fails to retract far enough.	- ·	4. Corners on sear or connector rounded.
	/3. Extractor binds.	Correction:	1. Return the firearm to the factory.
Correction:	1. Deburr.		2. Return the firearm to the factory.
	2. Free up or replace.		3. Return the firearm to the factory.
	<ol><li>Adjust on fit new extractor (and rivet).</li></ol>		<ol><li>Return the firearm to the factory.</li></ol>
	:		
BOLT PULLS	s out	BULGES OR	BLOWS CASES
Cause:	1. Boit stop or bolt release binds.	Cause:	1. Oversize chamber.
	2. Bolt stop or bolt release broken.	Guddu.	2. Max. head space.
	3. Bolt stop spring damaged.	Correction:	1. Replace barrel assembly.
Correction:	1. Free up.	CONSCION.	, ,
CONFECTION	2. Return the firearm to the factory.		2. Fit new bolt.
	3. Return the firearm to the factory.		
	5. Return the frearm to the factory.	SAFETY SW	
FEEDING		Cause:	1. Safety switch binds (safety switch works
		Cause.	hard).
Cause:	1. Magazine follower binds.		2. Safety switch snap washer stretches out
	2. Weak or defective follower spring.		
	3. Magazine spring caught under guard.		(safety switch works too freely).
	4. Damaged chamfer on bolt head.	0	3. Safety switch damaged.
	5. Tabs on follower bent.	Correction:	1. Return the firearm to the factory.
Correction:	1. Adjust side angle on magazine.		2. Return the firearm to the factory.
Gon ection.			3. Return the firearm to the factory.
	2. Replace spring.		
	3. Correct.	ACCURACY	′ — Group Size
	4. Replace bolt, or stone smooth.		
	5. Straighten or replace follower.	Cause:	1. Crown of barrel damaged.
			2. Barrel bore fouled.
LOADING	:		3. Enlarged bore.
			4. Improper bedding of barrel in stock.
Cause:	1. Damaged.receiver rails.		5. Loose sights.
	<ol><li>Sharp edge – rear end of chamber.</li></ol>	Correction:	1. Recrown.
	3. Rough loading ramp in receiver.		2. Lead or replace barrel.
Correction:	1. Polish or reshape.		3. Replace barrel.
	2. Remove sharpness.		4. Refloat barrel.
	3. Polish ramp.		5. Tighten or replace.
			o. righten er feplater
LOCKING		POINT OF I	MPACT
-			
Cause:	1. Shallow throat.	Cause:	1. Barrel not straight.
	2. Min. head space.		2. Improper or loose sights.
	3. Damaged chamber.	Correction:	1. Straighten or replace barrel.
	4. Extractor interferes with shell rim.		2. Tighten or change sights.
	5. Ejector binds or fails to retract far enough.		
	6. Burr at ejector hole in bolt.	•	
	7. Sharp corners in bolt lugs.		

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No	No.	NAME OF PART	View Ne.	Part No.	NAME OF PART	
1		Barrel Assembly, 350 Rem. Mag.	41	17047	Sear Spring	(Restricted)
		Barrel Assembly, 6.5 MM Rem. Mag.	42	15416	Sight Screw	
		Barrel Assembly, 308 Win.	43	16968	Sight Washer	
2		Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.	1	26990	Sling Strap Assembly and Mounting	s, Complete
		Bolt Assembly, 308 Win.			Includes: 44 thru 49	
		Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem.	44	15376	Fastener	
		Mag.	45	15357	Front Swivel Nut	
		Bolt Final Assembly, 308 Win.	46	15356	Front Swivel Screw	
3	15409	Bolt Plug	47	15358	Rear Swivel Screw	
L.	15412	Bolt Stop (Restricted)	48	26625	Sling Strap Assembly, 7/8"	
,	24484	Bait Stop Pin (Restricted)	49	26555	Swivel Assembly, Q.D. (each)	
	15413	Bolt Stop Spring (Restricted)	50	27651	Stock Assembly, 350 Rem. Mag., 6	.5 MM Rem.
	15741	Butt Plate (Model 600 only)			Mag.	
	25410	Butt Plate Screw (Model 600 only)		27650	Stock Assembly	
	17017	Ejector	51	15883	Tang Support (Magnum only)	( <b>—</b> ) , , , ,
	17676	Ejector Pin	52	15435	Trigger	(Restricted)
	17019	Ejector Spring	53	17049	Trigger Screw, Front	(Restricted)
	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	[	26730	Trigger Assembly	(Restricted)
	16254	Extractor	54	15436	Trigger Connector	(Restricted)
	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem.	55	15437	Trigger Guard	( <b>m</b>
		Mag.	56	15429	Trigger Housing	(Restricted)
	27340	Extractor Rivet (except 222 Rem.)	57	24477	Trigger Pin	(Restricted)
	15410	Firing Pin	58	17978	Trigger Spring	(Restricted)
	26715	Firing Pin Assembly	59	17053	Trigger Stop Screw	(Restricted)
	17022	Firing Pin Cross Pin				
	23321	Firing Pin Head				
	15653	Front Guard Screw	r -		ADDITIONAL CALIBER PAR	72
	27365	Front Sight Assembly			ADDITIONAL CALIBER PAR	13
	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Mag.			(Net Chause in Sectional View)	
	27260	Magazine, 308 Win,, 6MM Rem., 243 Win.			(Not Shown in Sectional View)	
9	15667	Magazine Follower; 350 Rem. Mag., 6.5 MM			Barral Assembly, 25 Barra (Cuparto	and a set b
		Rem. Mag.	r		Barrel Assembly, 35 Rem. (Superse	
	17056	Magazine Follower			Barrel Assembly, 222 Rem.	
	17891	Magazine Spring			Barrei Assembly, 6MM Rem.	
	15411	Main Spring	l l		Barrel Assembly, 243 Win.	الدم
	17580	Rear Guard Screw			Boit Assembly, 35 Rem. (Supersed	eu)
	26841	Rear Sight Assembly			Bolt Assembly, 222 Rem. Bolt Final Assembly, 35 Rem. (Sup	normal of l
1	15600	Rear Sight Base, 350 Rem. Mag.			Bolt Final Assembly, 222 Rem.	
	15727	Rear Sight Base		15852		
	15733	Rear Sight Elevation Screw		15850	Ejector, 222 Rem. Extractor, 222 Rem.	
	15726	Rear Sight Eyepiece			-	
	15728	Rear Sight Leaf		27342 27366	Extractor Rivet, 222 Rem.	243 Win
	15418	Rear Sight Nut		27366	Front Sight Assembly, 6 MM Rem.	
3	15732	Rear Sight Windage Screw		27261	Magazine, 222 Rem. Magazine, 35 Rem. (Superceded)	
	15778	Rear Sight Wrench		16793	Magazine, 35 Rem. (Superseded) Magazine Follower, 222 Rem.	
	17034	Receiver Plug Screw		15742	-	
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM		17983	Magazine Spacer, 222 Rem. Magazine Spring, 222 Rem.	
		Rem. Mag.		15600	Rear Sight Base, 35 Rem. (Superse	(her)
	18186	Reinforcing Screw		10000	Hear Signt Dase, 35 Henr. (Superse	0007
	15488	Rib		NOTE:	See Basic Parts List for parts not li	eterl above
	15417	Rib Screw		NUTE:	Generation and the second second the	
	26795	Safety Switch Assembly (Restricted)				
	21386	Recail Pad (Magnum only)				
	25410	Recoil Pad Screw (Magnum only)				
	26850	Safety Switch Detent Ball (Restricted)				
i	15432	Safety Switch Detant Spring (Restricted)				
	17043	Safety Switch Pivot Pin (Restricted)				
3	17044	Safety Switch Snap Washer (Restricted)	4			
Э	15666 24476	Sear Safety Cam (Restricted) Sear Pin (Restricted)	1			
)		Sear FID (Mestricted)	1			
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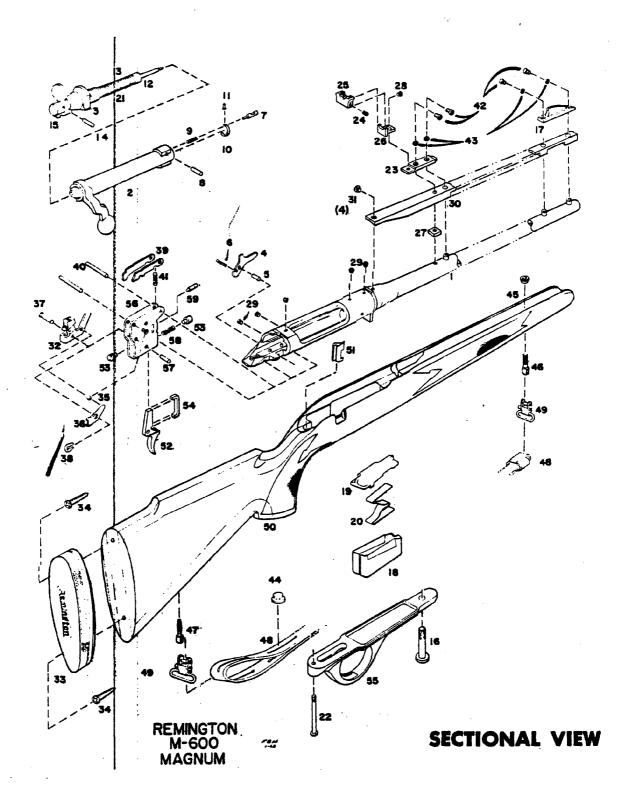
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REMINGTON FIELD SERVICE MANUAL



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The Reminuton MAGNUM Model 600 Carbine is chambered to shoot MAGNUM big game cartridges. This MAGNUM Model 600 bas been introduced in the 350 Remington Magnum caliber with two (2) bullet sizes ---- 200 and 250 grain weights.



This top-loading carbine has a capacity of four (4) Magnum cartridges, counting three (3) in fixed box magazine and one in barrel chamber.

A recoil pack and carrying strap with quick detachable swivels is standard equipment on the Model 600 Magnum.

See MAGNUM Instruction Folder – RD 5653 for care and operation information. This folder also contains part prices, service and shipping instructions.

The SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

### MODEL 600 MAGNUM

STOCK ASSEMBLY — is custom bedded with epoxy adhesive to match each individual action and barrel. Assembly includes stock, recoil pad, recoil pad screw (2), reinforcing screw (2), front swivel nut, swivel screw, front; swivel screw, rear.

To Disassemble – Unscrewi and remove trigger guard. Lift away and disassemble stock assembly from action and barrel. Note fully cured epoxy in barrel bracket slot of stock.

NOTE: "Delrin" tang support may separate from action at rear.

To Service – Stock assemblies are interchangeable as replacement. However, replacement stock requires a new epoxy bedding to match action and barrel. Use a good proprietary or commercial grade of bedding epoxy.

NOTE: Use all recommended epoxy handling precautions. To apply ---- squeeze fluid epoxy mix into barrel bracket slot in replacement stock. Fill slot to approximately half capacity.

To Service — Apply lubricant lightly to barrel bracket section of action. Then assemble action and barrel to replacement stock. Allow barrel bracket to bed firmly into epoxy fill. Reassemble trigger guard and trigger guard screws to stock. Tighten action and barrel securely in stock with guard screws.

NOTE: Barrel should assemble free – floating into replacement stock. Allow required time for epoxy to cure full strength. Any subsequent disassembly and reassembly then can easily be made. A slight taper design to barrel bracket allows bracket to slide easily in or out of epoxy bedding. During shooting this insures a constant bedding position.

NOTE: Make certain tang support relocated properly at rear of action before stock is reaspembled. See TANG SUPPORT'

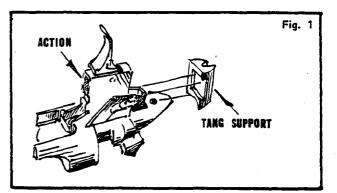
NOTE: Stock assembly for both Standard (and Magnum) Models no longer are cut to allow clearance for old style magazine assembly and screw. Therefore, any replacement for early design stocks requires clearance cutting forward of magazine position.

TANG SUPPORT -- is designed of "Delrin" material to provide added support or bearing for action at rear of stock.

To Disassemble – Remove stock assembly. Remove loosened tang support from rear of action.

To Reassemble # Tang support must be positioned at rear of action before action is replaced in stock. (See Fig. 1).

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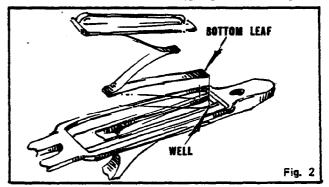
Reassemble stock assembly to action. Tighten firmly with guard screws.

#### TRIGGER GUARD

**To Disassemble** — Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

To Service – Front guard screw is of slightly longer length than same part of short length for Standard Model 600. Short length screw is used for trigger guard on Standard Model 600.

To Reassemble — Make certain bottom leaf of magazine spring locates centrally into well in trigger guard. (See Fig. 2).



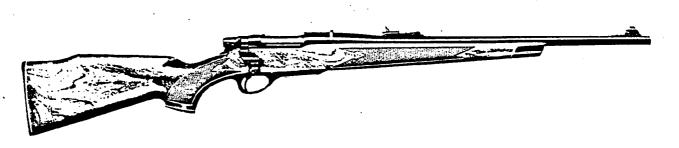
Turn both guard screws to tighten guard and stock securely to action.

MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only. Do not use for Standard Model 600.

NOTE: Short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom of magazine spring against trigger guard ——— and insures full magnum cartridge in magazine.

To Reassemble — Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

The Remington Models 660 and 660 Magnum are lightweight, compact length, carbines. These carbines are bolt action repeaters and are produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights—"fixed" front and adjustable rear — are mounted on the barrel. The receiver is drilled and tapped for telescope or receiver sights.



The basic operation of the bolt and repeating action of these carbines is similar to that of Models 600 and 600 Magnum. Therefore, the assembly and servicing instructions for 660 and 660 Magnum will list only those parts of unlike design and operation.

The instruction folder/parts list, Form RD 5733, packaged with each carbine gives operating instructions, care and maintenance for these models. A breakdown of part prices, service and shipping instructions is included.

Precaution: Make sure no live cartridges remain in rifle before cleaning, servicing or shipping.

Bolt Final Assembly – Components Firing Pin Assembly from Bolt Assembly Firing Pin Assembly – Components Front Sight Front Sight Ramp Rear Sight Assembly Rear Sight Step

## INDEX

#### Page

1	Rear Sight Base
1	Trigger Assembly
1	Sling Strap Assembly and Mountings Complete
1	Sling Strap
1	Cycle of Operation
1	Parts List
1	Exploded View

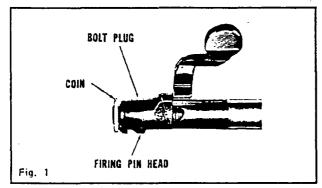
Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602 Page

BOLT FINAL ASSEMBLY - COMPONENTS: includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet and firing pin assembly which includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted in slot near back edge of firing pin head. (See Fig. 1). Hold Bolt handle and turn bolt plug until entire firing pin assembly can be unscrewed and removed from bolt assembly.



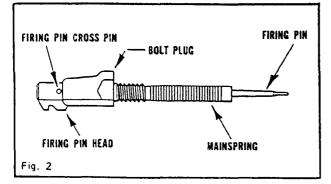
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

FIRING PIN ASSEMBLY – COMPONENTS – includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.

To Disassemble – (with firing pin assembly removed from bolt) Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged or broken parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when firing pin cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 2).



Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable — no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a no. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank

To Reassemble – Reassemble all parts of firing pin assembly. Hold Bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

#### FRONT SIGHT

To Disassemble – Support front sight ramp to prevent damage to barrel and drive out front sight. Use brass rod or plastic hammer to avoid damaging front sight.

To Reassemble – Place front sight in dovetail slot of front sight ramp. Support ramp and drive front sight into ramp from right to left.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble – Follow reverse order. Tighten screws securely.

REAR SIGHT ASSEMBLY — factory listed to include rear sight collar, rear sight eyepiece, rear sight leaf, rear sight windage screw.

To Disassemble – Unscrew and remove rear sight screw and rear sight assembly.

To Reassemble – Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

**REAR SIGHT STEP** – design to raise or lower rear sight assembly for range purposes.

To Disassemble – Grasp eyepiece, lift upward and slide rear sight step rearward and remove from base.

To Replace – Interchangeable – no factory adjustment required. Additional steps, marked for size are available for range purposes.

To Reassemble — Lift eyepiece and slide step into place, High end faces forward.

#### REAR SIGHT BASE

To Disassemble – (with rear sight assembly and step removed) Unscrew and remove rear sight base screws and washers. Disassemble rear sight base from barrel.

To Reassemble - Follow reverse order.

TRIGGER ASSEMBLY – in general, this assembly is similar to M/600 – differing only in the redesign of sear and safety cam assembly(2 pieces) to sear safety cam (1 piece). Function, assembly and disassembly is unaltered.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETEinclude front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quick-detachable (Q. D.).type.

Assembly - Swivel Screws to Stock (M/660 Only)

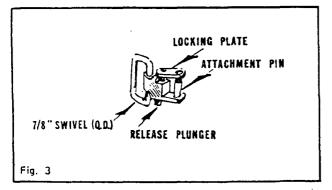
Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole  $2\frac{1}{2}$  inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom line of stock. Countersink this drilled hole with no. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut — Use 3/8 inch drill. Locate screw hole approximately 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

#### Assembly - Swivel Assembly (2) Q. D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 3).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### Assembly - Strap to Assembled Swivels

Insert tongue of strap through one swivel. Loop strap back and through keeper and pull strap until buckle is near mid point of strap. Slide keeper back near swivel to form loop. Insert tongue of strap through large and then small openings of buckle. Insert strap through other swivel, double strap back and insert small diameter of brass fastener through slots. Adjust strap to suit. To remove strap, simply unsnap quick detachable swivels from stock screws.

SLING STRAP – A sling strap complete with mountings is packaged with each MAGNUM carbine. When attaching, assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger or swivel until small plate lifts and can be swung free of attaching stud on swivel. Insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

## CYCLE OF OPERATION

Models 660 and 660 Magnum Carbine are lightweight, high power, bolt action, fixed magazine repeaters chambered for a number of center fire calibers. The receiver is drilled and tapped — ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens: forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by springloaded firing pin and mainspring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A carn at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operating cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

(Cont. on Page 5)

PARTS LIST

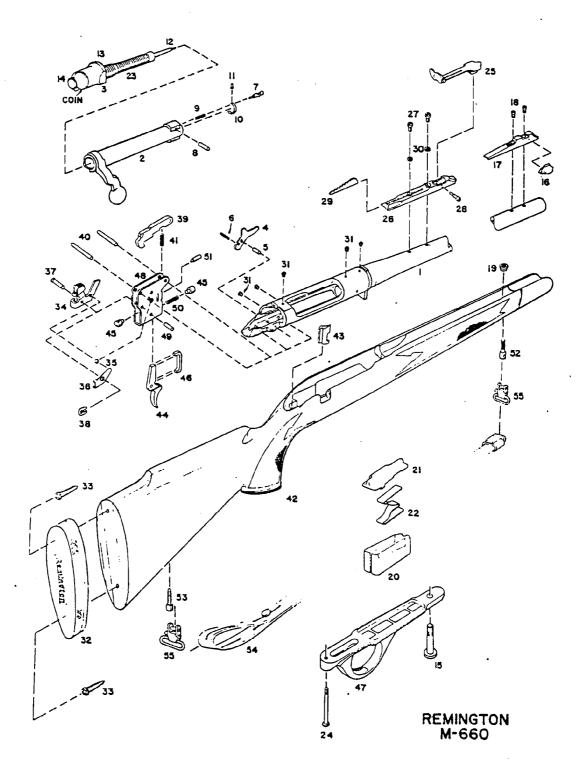
## REMINGTON FIELD SERVICE MANUAL

/iew No.	Part No.	NAME OF PART	View Ne.		NAME OF PART
1	29860	Barrel Assembly, 308 Win. (includes Barrel,	22	17891	Magazine Spring
		Barrel Bracket, Receiver)		17983	Magazine Spring, 222 Rem.
	29861	Barrel Assembly, 222 Rem.	23	15411	Main Spring
1	29863	Barrel Assembly, 6MM Rem.	24	17580	Rear Guard Screw
	29865	Barrel Assembly, 243 Win,	25	24525	Rear Sight Assembly (includes Rear Sight Collar
1	29866	Barrel Assembly, 6.5 Rem. Mag.		14010	Rear Sight Eyepiece, Rear Sight Leaf, Rea Sight Windage Screw)
	29867	Barrel Assembly, 350 Rem. Mag.	1 24	25313	
	29870	Bolt Assembly, 308 Win. (includes Bolt Body As-	26		Rear Sight Base
		sembly and Bolt Handle)	27	16023	Rear Sight Base Screw
1	29871	Bolt Assembly, 222 Rem.	28	16456	Rear Sight Screw
2	29873	Bolt Assembly, 6.5 Rem. Mag., 350 Rem. Mag.	29	28095	Rear Sight Step (selected sizes)
	29890	Bolt Final Assembly, 308 Win. (includes Bolt	30	16968	Rear Sight Washer
1		Assembly, Ejector, Ejector Pin, Ejector Spring,	31	17034	Receiver Plug Screw
		Extractor, Extractor Rivet, Firing Pin Assembly)	32	21386	Recoil Pad, Magnum Caliber
1	29891	Bolt Final Assembly, 222 Rem.	33	25410	Recoil Pad Screw, Magnum Caliber
	29893	Bolt Final Assembly, 6.5 Rem. Mag., 350 Rem.		15651	Reinforcing Screw
			34	26795	Safety Assembly (includes Safety and Safety
3	15676	Bolt Plug		_	Thumbpiece)
4	15412	Bolt Stop	35	26850	Safety Detent Ball
5	24484	Bolt Stop Pin	36	15432	Safety Detent Spring
6	15413	Bolt Stop Spring	37	17043	Safety Pivot Pin
	15741	Butt Plate	38	17044	Safety Snap Washer
	25410	Butt Plate Screw	· 39	15666	Sear Safety Cam
	14390	Butt Plate Spacer	40	24476	Sear Pin
7 ¦	17017	Ejector	41	17047	Sear Spring
	15852	Ejector, 222 Rem.		29835	Stock Assembly (includes Butt Plate, Butt Plat
8	17676	Ejector Pin			Screw (2), Butt Plate Spacer, Fore-end Tip
9	17019	Ejector Spring			Fore-end Tip Plug, Fore-end Tip Spacer, Gri
	16254	Extractor			Cap, Grip Cap Inlay, Grip Cap Screw, Gri
ĺ	15850	Extractor, 222 Rem.			Cap Spacer, Reinforcing Screw (2), Stock)
0	15709	Extractor, 6.5 Rem. Mag., 350 Rem. Mag.	42	29880	Stock Assembly, Magnum Caliber (includes Fore
· •	27340	Extractor Rivet			end Tip, Fore-end Tip Plug, Fore-end Ti Spacer, Grip Cap, Grip Cap Inlay, Grip Ca
	27342	Extractor Rivet, 222 Rem.			Screw, Grip Cap Spacer, Recoil Pad, Reco
11	27341	Extractor Rivet, 6.5 Rem. Mag., 350 Rem. Mag.			Pad Screw (2), Front Swivel Nut, Reinforcing
. 1					Screw (2), Stock)
12	15410	Firing Pin	43	15883	Tang Support, Magnum Caliber
13	28600	Firing Pin Assembly (includes Bolt Plug, Firing	44	15435	Trigger
		Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	45	17049	Trigger Adjusting Screw
	17022	· · · · ·		14714	Trigger Adjusting Screw, Front
	17022	Firing Pin Cross Pin		26730	Trigger Assembly (includes Trigger Housing
4	15673	Firing Pin Head			Safety Snap Washer, Sear Safety Cam, Sea
15	15653	Front Guard Screw		1	Spring, Trigger, Trigger Adjusting Screw (2)
ó	15373	Front Sight			Trigger Connector, Trigger Pin, Trigger Spring Trigger Stop Screw)
17	28510	Front Sight Ramp		15426	
8	28505	Front Sight Ramp Screw	46	15436	
9		-	47	15437	Trigger Guard
17	15357	Front Swivel Nut	48	15429	Trigger Housing
	14391	Grip Cap	49	24477	Trigger Pin
	15390	Grip Cap Inlay	50	17978	Trigger Spring
	15757	Grip Cap Screw	51	17053	Trigger Stop Screw
	14392	Grip Cap Spacer			
	15433	Magazine	ł	Į	SLING STRAP EQUIPMENT
1	15842	-		14694	Sling Steps Accombly and Manufines Council
	}	Magazine, 222 Rem.		14074	<b>a</b> 1 <i>i</i> <b>a</b> <i>i</i>
:0	15648	Magazine, 6.5 Rem. Mag., 350 Rem. Mag.			· Includes:
	17056	Magazine Follower	52	15356	Front Swivel Screw
	16793	Magazine Follower, 222 Rem,	53	15358	Rear Swivel Screw
21	15667	Magazine Follower, 6.5 Rem. Mag., 350 Rem.	54	30855	Sling Strap Assembly 7/8"
		Mag.	55	26555	
	15742			15357	
			1	1	The second

EXPLODED VIEW

REMINGTON FIELD SERVICE MANUAL

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#### (Cont. from Page 2)

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired by release of trigger.

#### SAFETY

The safety thumbpiece, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two internal functions. When safety thumbpiece is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position ("S marking) brings an arm into slot in bolt preventing bolt being opened, Pushing safety forward to FIRE position ("F marking) nulifies above condition and will allow firing.

The Remington Models 660 and 660 Magnum are lightweight, compact length, carbines. These carbines are bolt action repeaters and are produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights—"fixed" front and adjustable rear – are mounted on the barrel. The receiver is drilled and tapped for telescope or receiver sights.



The basic operation of the bolt and repeating action of these carbines is similar to that of Models 600 and 600 Magnum. Therefore, the assembly and servicing instructions for 660 and 660 Magnum will list only those parts of unlike design and operation.

The instruction folder/parts list, Form RD 5733, packaged with each carbine gives operating instructions, care and maintenance for these models. A breakdown of part prices, service and shipping instructions is included.

Precaution: Make sure no live cartridges remain in rifle before cleaning, servicing or shipping.

### INDEX

#### Page

Bolt Final Assembly - Components
Firing Pin Assembly from Bolt Assembly
Firing Pin Assembly – Components
Front Sight
Front Sight Ramp
Rear Sight Assembly
Rear Sight Step

1 Rear Sight Base 1 Trigger Assembly 2 1 Sling Strap Assembly and Mountings Complete 2 1 1 Sling Strap ------2 Cycle of Operation -----2.5 1 Parts List 3 1 Exploded View 4 1

Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Illion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

Page

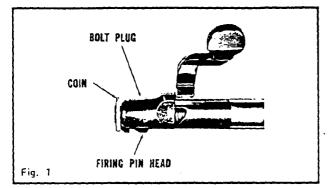
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BOLT FINAL ASSEMBLY - COMPONENTS: includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet and firing pin assembly which includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted in slot near back edge of firing pin head. (See Fig. 1). Hold Bolt handle and turn bolt plug until entire firing pin assembly can be unscrewed and removed from bolt assembly.



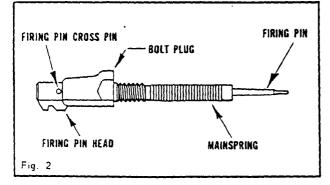
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

FIRING PIN ASSEMBLY - COMPONENTS - includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.

To Disassemble – (with firing pin assembly removed from bolt) Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged or broken parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when firing pin cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 2).



Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable --- no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a no. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill thru cross pin hole in firing pin head. Orill thru firing pin shank

To Reassemble – Reassemble all parts of firing pin assembly. Hold Bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

#### FRONT SIGHT

To Disassemble – Support front sight ramp to prevent damage to barrel and drive out front sight. Use brass rod or plastic hammer to avoid damaging front sight.

To Reassemble – Place front sight in dovetail slot of front sight ramp. Support ramp and drive front sight into ramp from right to left.

#### FRONT SIGHT RAMP

To Disassemble - Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble – Follow reverse order. Tighten screws securely.

REAR SIGHT ASSEMBLY - factory listed to include rear sight collar, rear sight eyepiece, rear sight leaf, rear sight wind-age screw.

To Disassemble – Unscrew and remove rear sight screw and rear sight assembly.

To Reassemble – Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

**REAR SIGHT STEP** – design to raise or lower rear sight assembly for range purposes.

To Disassemble – Grasp eyepiece, lift upward and slide rear sight step rearward and remove from base.

To Replace – Interchangeable – no factory adjustment required. Additional steps, marked for size are available for range purposes.

To Reassemble – Lift eyepiece and slide step into place, High end faces forward.

#### REAR SIGHT BASE

To Disassemble – (with rear sight assembly and step removed) Unscrew and remove rear sight base screws and washers. Disassemble rear sight base from barrel.

To Reassemble – Follow reverse order.

TRIGGER ASSEMBLY – in general, this assembly is similar to M/600 – differing only in the redesign of sear and safety cam assembly(2 pieces) to sear safety cam (1 piece). Function, assembly and disassembly is unaltered.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETEinclude front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, keeper, fastener. Strap is  $7/8^{\prime\prime}$  wide. Swivel assemblies are quick-detachable (Q. D.) type.

Assembly - Swivel Screws to Stock (M/660 Only)

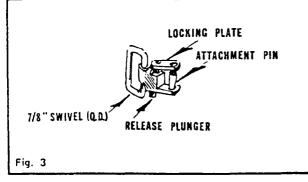
Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole  $2\frac{1}{2}$  inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom line of stock. Countersink this drilled hole with no. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut – Use 3/8 inch drill, Locate screw hole approximately 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

Assembly - Swivel Assembly (2) Q. D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 3).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### Assembly - Strap to Assembled Swivels

Insert tongue of strap through one swivel. Loop strap back and through keeper and pull strap until buckle is near mid point of strap. Slide keeper back near swivel to form loop. Insert tongue of strap through large and then small openings of buckle. Insert strap through other swivel, double strap back and insert small diameter of brass fastener through slots. Adjust strap to suit. To remove strap, simply unsnap quick detachable swivels from stock screws.

SLING STRAP – A sling strap complete with mountings is packaged with each MAGNUM carbine. When attaching, assemble both quick detachable (Q, D, ) swivel assemblies to stock. To do this, push plunger or swivel until small plate lifts and can be swung free of attaching stud on swivel. Insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

## CYCLE OF OPERATION

Models 660 and 660 Magnum Carbine are lightweight, high power, bolt action, fixed magazine repeaters chambered for a number of center fire calibers. The receiver is drilled and tapped – ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

#### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by springloaded firing pin and mainspring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operating cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

(Cont. on Page 5)

PARTS LIST

## REMINGTON FIELD SERVICE MANUAL

/iew No.	Port No.	NAME OF PART	View No.	Part No.	NAME OF PART
Ì	29860	Barrel Assembly, 308 Win. (includes Barrel,	22	17891	Magazine Spring
1		Barrel Bracket, Receiver)		17983	Magazine Spring, 222 Rem.
	29861	Barrel Assembly, 222 Rem.	23	15411	Main Spring
	29863	Barrel Assembly, 6MM Rem.	24	17580	Rear Guard Screw
	29865	Barrel Assembly, 243 Win	25	24525	Rear Sight Assembly (includes Rear Sight Collar
1	29866 29867	Barrel Assembly, 6.5 Rem. Mag.			Rear Sight Eyepiece, Rear Sight Leaf, Rea Sight Windage Screw)
		Barrel Assembly, 350 Rem. Mag.	26	25313	Rear Sight Base
	29870	Bolt Assembly, 308 Win. (includes Balt Body As- sembly and Bolt Handle)	27	16023	Rear Sight Base Screw
	29871	Bolt Assembly, 222 Rem.	28	16456	Rear Sight Screw
2	29873	Bolt Assembly, 6.5 Rem. Mag., 350 Rem. Mag.	29	28095	Rear Sight Step (selected sizes)
-	29890	Bolt Final Assembly, 308 Win. (includes Bolt	30	16968	Rear Sight Washer
		Assembly, Ejector, Ejector Pin, Ejector Spring,	31	17034	Receiver Plug Screw
		Extractor, Extractor Rivet, Firing Pin Assembly)	32	21386	Recoil Pad, Magnum Caliber
	29891	Bolt Final Assembly, 222 Rem.	33	25410	Recoil Pad Screw, Magnum Caliber
	29893	Bolt Final Assembly, 6.5 Rem. Mag., 350 Rem.		15651	Reinforcing Screw
		Mag	34	26795	Safety Assembly (includes Safety and Safety
3	15676	Boit Plug			Thumbpiece)
4	15412	Bolt Stop	35	26850	Safety Detent Ball
5	24484	Bolt Stop Pin	36	15432	Safety Detent Spring
6	15413	Bolt Stop Spring	37	17043	Safety Pivot Pin
	15741	Butt Plate	38	17044	Safety Snap Washer
	25410	Butt Plate Screw	39	15666	Sear Safety Cam
	14390	Butt Plate Spacer	40	24476	Sear Pin
7 1	17017	Ejector	41	17047	Sear Spring
	15852	Ejector, 222 Rem.		29835	Stock Assembly (includes Butt Plate, Butt Plate
4	17676	Ejector Pin			Screw (2), Butt Plate Spacer, Fore-end Tip
2	17019	Ejector Spring			Fore-end Tip Plug, Fore-end Tip Spacer, Grip
	16254	Extractor			Cap, Grip Cap Inlay, Grip Cap Screw, Grip Cap Spacer, Reinforcing Screw (2), Stock)
1	15850	Extractor, 222 Rem.	42	29880	Stock Assembly, Magnum Caliber (includes Fore
	15709	Extractor, 6.5 Rem. Mag., 350 Rem. Mag.		2/000	end Tip, Fore-end Tip Plug, Fore-end Tip
	27340	Extractor Rivet			Spacer, Grip Cap, Grip Cap Inlay, Grip Cap
1	27342	Extractor Rivet, 222 Rem.			Screw, Grip Cap Spacer, Recoil Pad, Recoi
Ì	27341	Extractor Rivet, 6.5 Rem. Mag., 350 Rem. Mag.			Pad Screw (2), Front Swivel Nut, Reinforcing Screw (2), Stock)
2	15410	Firing Pin	43	15883	Tang Support, Magnum Caliber
3	28600	Firing Pin Assembly (includes Bolt Plug, firing	44	15435	Trigger
		Pin, Firing Pin Cross Pin, Firing Pin Head,	45	17049	Trigger Adjusting Screw
	17000	Main Spring)		14714	Trigger Adjusting Screw, Front
	17022	Firing Pin Cross Pin		26730	Trigger Assembly (includes Trigger Housing
	15673	Firing Pin Head			Safety Snap Washer, Sear Safety Cam, Sea
	15653	Front Guard Screw			Spring, Trigger, Trigger Adjusting Screw (2)
5	15373	Front Sight			Trigger Connector, Trigger Pin, Trigger Spring Trigger Stop Screw)
7	28510	Front Sight Ramp	46	15436	
3	28505	Front Sight Ramp Screw	47	15437	Trigger Connector
9	15357	Front Swivel Nut	48	15437	Trigger Guard Trigger Housing
	14391	Grip Cap	49	24477	Trigger Pin
		Grip Cap Inlay	50	17978	Trigger Spring
	15757		51	17053	Trigger Spring
		Grip Cap Screw	51	1/033	Trigger Stop Screw
	14392	Grip Cap Spacer			
	15433	Magazine			SLING STRAP EQUIPMENT
	15842	Magazine, 222 Rem		14694	Sling Strap Assembly and Mountings Complete
0	15648	Magazine, 6.5 Rem. Mag., 350 Rem. Mag.			Includes:
- {	17056	Magazine Follower	52	15358	Front Swivel Screw
	16793	Magazine Follower, 222 Rem.	53	15358	Rear Swivel Screw
1	15667	Magazine Follower, 6.5 Rem. Mag., 350 Rem.	54	30855	Sling Strap Assembly 7/8"
		Mag,	55	26555	Swivel Assembly, Q.D.
	15742	Magazine Spacer, 222 Rem.	1	15357	Front Swivel Nut
		muguzine spacer, ZZZ kem.			

(Cont. from Page 2)

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

### FEEDING

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

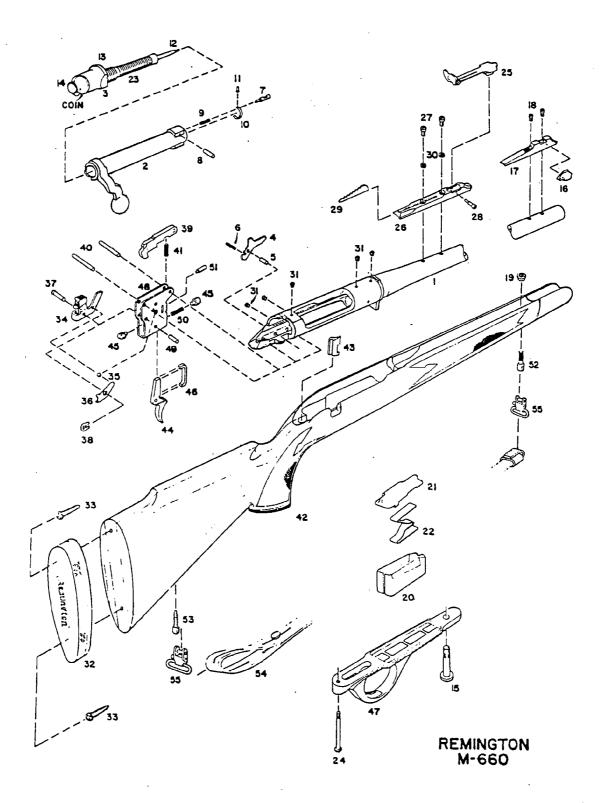
Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired by release of trigger.

#### SAFETY

The safety thumbpiece, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety has two internal functions. When safety thumbpiece is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam that locks cam against firing pin head preventing firing. Second function of safety in this SAFE position ("S marking) brings an arm into slot in bolt preventing bolt being opened, Pushing safety forward to FIRE position ("F marking) nulifies above condition and will allow firing.



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## REMINGTON FIELD SERVICE MANUAL

The Remington Models 660 and 660 Magnum are lightweight, compact length, carbines. These carbines are bolt action repeaters and are produced in a number of center fire calibers. A fixed box magazine may be top loaded to full capacity. Open sights-"fixed" front and adjustable rear - are mounted on the barrel. The receiver is drilled and tapped for telescope or receiver sights.



The basic operation of the bolt and repeating action of these carbines is similar to that of Models 600 and 600 Magnum. Therefore, the assembly and servicing instructions for 660 and 660 Magnum will list only those parts of unlike design and operation.

The instruction folder/parts list, Form RD 5733, packaged with each carbine gives operating instructions, care and maintenance for these models. A breakdown of part prices, service and shipping instructions is included.

Precaution: Make sure no live cartridges remain in rifle before cleaning, servicing or shipping.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. **Arms Service Division** llion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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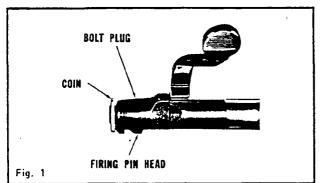
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BOLT FINAL ASSEMBLY - COMPONENTS: includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet and firing pin assembly which includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

#### FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from rifle, Pull firing pin head rearward until coin or washer can be inserted in slot near back edge of firing pin head. (See Fig. 1). Hold Bolt handle and turn bolt plug until entire firing pin assembly can be unscrewed and removed from bolt assembly.



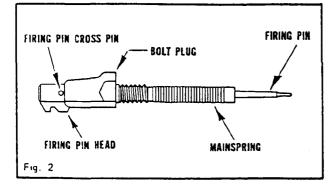
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

FIRING PIN ASSEMBLY - COMPONENTS - includes bolt plug, tiring pin, firing pin cross pin, firing pin head, main spring.

To Disassemble – (with firing pin assembly removed from bolt) Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged or broken parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when firing pin cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 2).



Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable --- no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a no. 42 size drill (.093").

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clear and free of any obstructions. Seat shank of firing pin firmly onto firing pin head, Align drill thru cross pin hole in firing pin head. Drill thru firing pin shank

To Reassemble – Reassemble all parts of firing pin assembly. Hold Bolt plug retracted against tension of reassembled mainspring. Insert firing pin cross pin thru firing pin head and shank of firing pin. Release tension on bolt plug.

#### FRONT SIGHT

To Disassemble – Support front sight ramp to prevent damage to barrel and drive out front sight. Use brass rod or plastic hammer to avoid damaging front sight.

To Reassemble – Place front sight in dovetail slot of front sight ramp. Support ramp and drive front sight into ramp from right to left.

#### FRONT SIGHT RAMP

To Disassemble – Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order. Tighten screws securely.

REAR SIGHT ASSEMBLY – factory listed to include rear sight collar, rear sight eyepiece, rear sight leaf, rear sight wind-age screw.

To Disassemble – Unscrew and remove rear sight screw and rear sight assembly.

To Reassemble – Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

**REAR SIGHT STEP** – design to raise or lower rear sight assembly for range purposes.

To Disassemble – Grasp eyepiece, lift upward and slide rear sight step rearward and remove from base.

To Replace – Interchangeable – no factory adjustment required. Additional steps, marked for size are available for range purposes.

To Reassemble — Lift eyepiece and slide step into place, High end faces forward.

#### REAR SIGHT BASE

To Disassemble – (with rear sight assembly and step removed) Unscrew and remove rear sight base screws and washers. Disassemble rear sight base from barrel.

#### To Reassemble - Follow reverse order.

### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

SLING STRAP ASSEMBLY and MOUNTINGS COMPLETEinclude front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly (2).

Note: Sling strap assembly includes strap, keeper, fastener. Strap is 7/8" wide. Swivel assemblies are quick-detachable (Q. D.) type.

Assembly - Swivel Screws to Stock (M/660 Only)

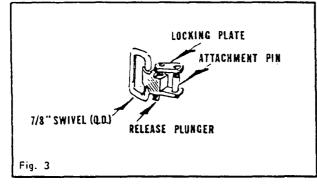
Rear Swivel Screw – Use No. 15 size drill (.180"). Locate screw hole 2½ inches from toe of stock (minus butt plate). Drill hole 1 inch deep at  $90^{\circ}$  with bottom line of stock. Countersink this drilled hole with no. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw - Use No. 13 drill.

Front Swivel Nut – Use 3/8 inch drill, Locate screw hole approximately 3 inches from front end of stock. Drill hole completely thru stock at  $90^{\circ}$  with barrel radius stock cut. Countersink barrel radius cut into this drilled hole to depth of .225 inches. Countersink allows for seating of front swivel nut. Assemble front swivel thru hole and tighten to stock with front swivel nut.

#### Assembly - Swivel Assembly (2) Q. D.

Swivel assembly (same for front and rear) can be assembled to swivel screw in stock as follows. Press against spring loaded release plunger to lift locking plate from attachment pin. Swing plate to clear attachment pin. (See Fig. 3).



After attaching to swivel screw, swing and lower locking plate upon attachment pin. This will lock swivel to screw.

#### Assembly - Strap to Assembled Swivels

Insert tongue of strap through one swivel. Loop strap back and through keeper and pull strap until buckle is near mid point of strap. Slide keeper back near swivel to form loop. Insert tongue of strap through large and then small openings of buckle. Insert strap through other swivel, double strap back and insert small diameter of brass fastener through slots. Adjust strap to suit.

### MODEL 660 & 660 MAGNUM

To remove strap, simply unsnap quick detachable swivels from stock screws.

SLING STRAP – A sling strap complete with mountings is packaged with each MAGNUM carbine. When attaching, assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger or swivel until small plate lifts and can be swung free of attaching stud on swivel. Insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

## CYCLE OF OPERATION

Models 660 and 660 Magnum Carbine are lightweight, high power, bolt action, fixed magazine repeaters chambered for a number of center fire calibers. The receiver is drilled and tapped — ready to accept most popular makes of scopes and mounts. Basic operation of bolt is similar to most rifles of this type. Movement of bolt handle upward and fully back opens; forward and down closes and locks bolt.

### FIRING

Firing cycle is basically release of a spring-loaded firing pin for purpose of striking primer of cartridge and igniting same. More specifically, pulling or squeezing of trigger moves connector forward leaving sear unsupported against "cocked" firing pin head. With support removed, sear is cammed down by springloaded firing pin and mainspring drives firing pin forward to strike primer.

#### UNLOCKING

Raising bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward and holds it in cocked position, in a notch at rear of bolt. See LOCKING for transfer cocking movement to sear.

#### EXTRACTION

This phase of operating cycle is essentially one of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

(Cont. on Page 5)

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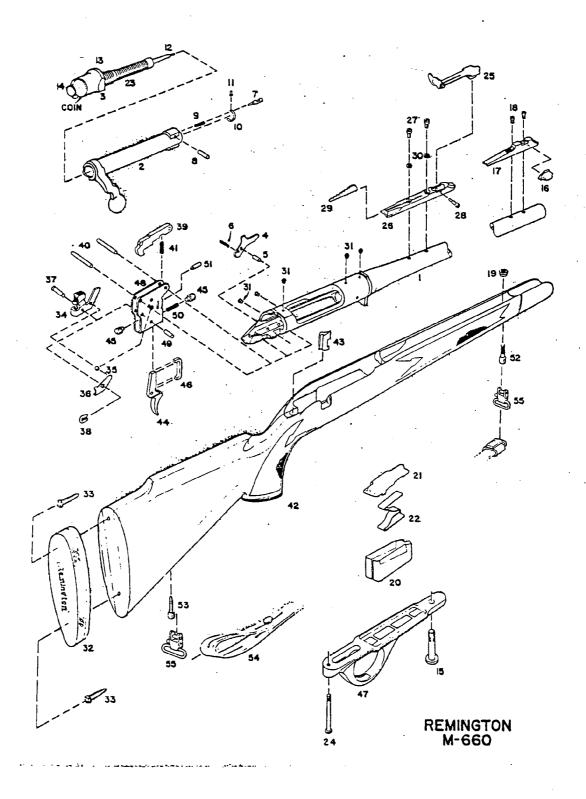
riew Na	Port No.	NAME OF PART		Vie Ni			
		Barrel Assembly, 308 Win.		30	1696	Rear Sight Washer	
		Barrei Assembly, 222 Rem.		31	1703	-	
		Barrel Assembly, 6MM Rem.	•	32	2138		-
		Barrel Assembly, 243 Win.			2541		
1		Barrel Assembly, 6.5 Rem. Mag.		33	1565		
•		Barrel Assembly, 350 Rem. Mag.				-	(Restricted)
		Boit Assembly, 308 Win.		34	2679		
		Boit Assembly, 222 Rem.		35	2685		(Restricted)
2		Bolt Assembly, 65. Rem. Mag., 350 Rem. M	20	36	1543	2 Safety Switch Detent Spring	(Restricted)
2		Bolt Final Assembly, 308 Win.	-3.				
				37	1704	•	(Restricted)
		Bolt Final Assembly, 222 Rem.		38	1704	Safety Switch Snap Washer	(Restricted)
		Solt Final Assembly, 6.5 Rem. Mag., 350 R	em.	39	1566	5 Sear Safety Cam	(Restricted)
		Mag.		40	2447	5 Sear Pin	(Restricted)
3	15676	Bolt Plug		41	1704	7 Sear Spring	(Restricted)
4	15412		Restricted)	1	2983	5 Stock Assembly	,
5	24484	Bolt Stop Pin (	Restricted)	42	2988	3 Stock Assembly, Magnum Caliber	
6	15413	Bolt Stop Spring	Restricted)	43	1588		
	15741	Butt Plate		44	1543		(Restricted)
	25410	Butt Plate Screw			1704	30	(Restricted)
	14390	Butt Plate Spacer		173	1471		(Retricted)
	17017	Ejector					(Restricted)
	15852	Ejector, 222 Rem.		1	2673		
					1543	50	(Restricted)
	17676	Ejector Pin		47	1543		
9	17019	Ejector Spring		48	1542	9 Trigger Háusing	(Restricted)
	16254	Extractor		49	2447	7 Trigger Pin	(Restricted)
	15850	Extractor, 222 Rem.		50	1797	8 Trigger Spring	(Restricted)
10	15709	Extractor, 6.5 Rem. Mag., 350 Rem. Mag.		1 51	1705	3 Trigger Stop Screw	(Restricted)
	27340	Extractor Rivet					
	27342	Extractor Rivet, 222 Rem.	•	1			
11	27341	Extractor Rivet, 6.5 Rem. Mag., 350 Rem.	Mag.				
12	15410	Firing Pin					
13	28600	Firing Pin Assembly				SLING STRAP EQUIPMENT	
	17022	Firing Pin Cross Pin		1		Sente Strive Edonment	
14	15673	Firing Pin Head		1		4 Olice Chara Astembly and Mauntines	Complete
15	15653	Front Guard Screw			1469		Complete
16	15373	Front Sight				Includes:	
17	28510	Front Sight Ramp		52			
	28505	Front Sight Ramp Screw		53	1535		
18		Front Swivel Nut		54	308	-	
19	15357			55		-	
	14391	Grip Cap		1	153	7 Front Swivel Nut	
	15390	Grip Cap Inlay					
	15757	Grip Cap Screw		- {			
	14392	Grip Çap Spacer					
	15433	Magazine		1			
	15842	Magazine, 222 Rem.					
20	15648	Magazine, 6.5 Rem, Mag., 350 Rem, Mag.		1			
	17056	Magazine Follower		1			
	16793	Magazine Follower, 222 Rem.					
21	15667	Magazine Follower, 6.5 Rem. Mag., 350 Ri	em.				
- •		Mag.					
	15742	Magazine Spacer, 222 Rem.					
12		-		1			
22	17891	Magazine Spring		1			
	17893	Magazine Spring, 222 Rem.		1			
23	15411	Main Spring		1			
24	17580	Rear Guard Screw		1			
25	24525	Rear Signt Assembly					
26	25313	Rear Sight Base		1			
27	16023	Rear Sight Base Screw					
28	16456	Rear Sign1 Screw					
	28095	Arear Signt Step (selected sizes)					

REMINGTON FIELD SERVICE MANUAL

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EXPLODED

VIEW



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#### (Cont. from Page 2)

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is halted by bolt stop.

#### FEEDING ·

With bolt halted rearward, topmost cartridge in magazine is allowed to move upward against feeding lips on bottom edge of receiver, allowing itself to be moved ahead as bolt is advanced with a forward motion of bolt handle. Bullet guides cartridge into chamber via a feeding ramp on lower side of receiver.

#### LOADING

Loading cycle consists briefly of moving cartridge into chamber once it is free of feeding lips in receiver.

#### LOCKING

Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Gun is now ready to be fired by release of trigger.

#### SAFETY SWITCH

The safety switch thumbpiece, located on right rear of receiver, is operated by a push and pull action of thumb. This two-position safety switch has two internal functions. When safety switch thumbpiece is pulled rearward by a slight down pressure of thumb, a cam is brought into position under safety cam that locks cam against firing pin head preventing firing. Second function of safety switch in this SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt being opened. Pushing safety switch forward to FIRE position ("F" marking) nullifies above conditions and will allow firing.

The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725.

Therefore, the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.



The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

MODEL 700

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Ejector Pin	#17676	1,2&3
Ejector Spring	#17019	1,2&3
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## REMINGTON FIELD SERVICE MANUAL

## TRIGGER GUARD (ADL GRADE)

<u>To Disassemble</u> - Unscrew and remove rear and center guard screws and remove trigger guard.

<u>To Replace</u> - Interchange with no factory adjustment required.

To Reassemble - Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

<u>Caution</u>: Before assembling stock to receiver, particularly on ADL Grade, locate magazine fully into magazine recess in bottom of receiver. This will prevent any damage to stock when stock is tightened against receiver.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

<u>To Disassemble</u> - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

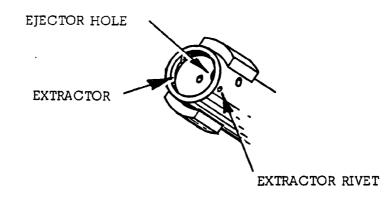
<u>Caution:</u> Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

EJECTOR RETAINING PIN EJECTOR Drive Out Here EJECTOR SPRING

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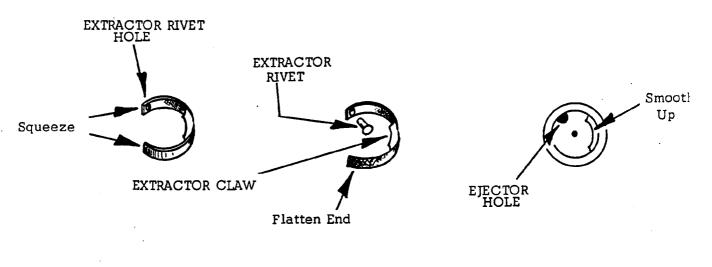
## BOLT FINAL ASSEMBLY Continued

Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)



Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)



Straighten tail of extractor. (See sketch above)

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## REMINGTON FIELD SERVICE MANUAL

### BOLT FINAL ASSEMBLY Continued

Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Disassemble, if necessary, and rebend extractor as indicated in sketch on preceding page

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch on preceding page)

<u>Note</u>: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

To Disassemble - See Model 725 manual and disassemble in the same manner.

<u>To Replace</u> - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

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SIGHTS

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REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

<u>To Disassemble</u> - Spread cover slightly and push forward in cover slots on either side of the ramp.

To Replace - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

### FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
- <u>To Replace</u> Interchangeable no factory adjustment required.

To Reassemble - Follow reverse order.

- FRONT SIGHT RAMP (Screw on type, used on the following calibers only: 222, 222 Magnum, 243, 6mm, 7mm Magnum and 264 Magnum)
- <u>To Disassemble</u> Unscrew front sight ramp screw and pry ramp up off ramp pins.
- To Replace Interchangeable no factory adjustment required.
- <u>To Reassemble</u> Place ramp pins in holes on top of barrel, align pins with holes in bottom of ramp and tap ramp down on to barrel until seated. Screw in ramp screw.

NOTE: Other calibers (308, 270, 280 and 30-06) have a brazed on front sight ramp which is not easily disassembled.

SLING STRAP ASSEMBLY & MOUNTINGS, COMPLETE - A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle --- assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

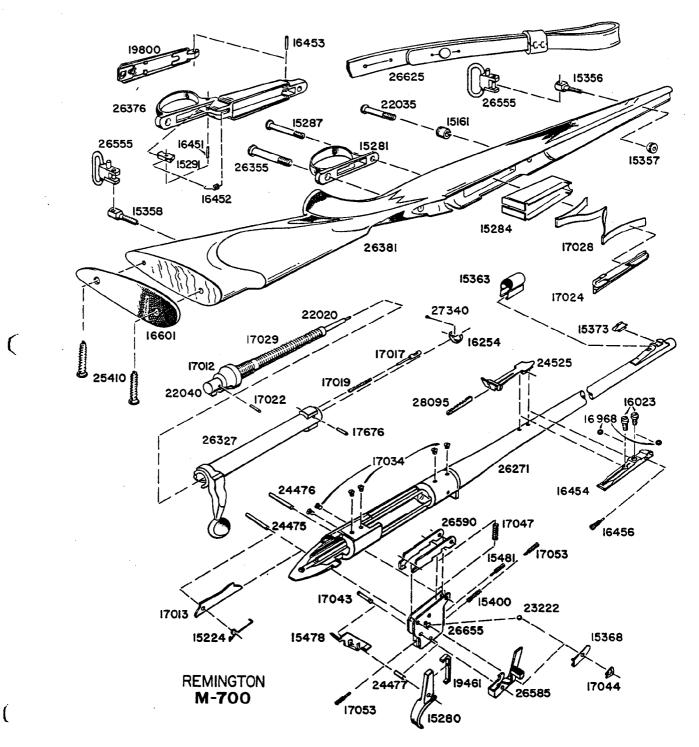
To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

Slide front keeper band on free end of strap. Then insert strap thru front swivel and double strap back and thru attached front keeper. Insert brass fastener thru matching slots to join strap in desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

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## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied – ADL (standard) and BDL. Included in the BDL grade is the Model 700 VARMINT – an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.

The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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# Bolt Final Assembly. Bolt Final Assembly, Components Firing Pin Assembly, Components Firing Pin Assembly, Components Rear Sight Assembly, Components Front Sight Hood (BDL Grade) Front Sight Ramp Trigger Guard (ADL Grade). Trigger Guard Assembly, Components Magazine Magazine Spring

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## BOLT FINAL ASSEMBLY

To Disassemble —With safety switch forward on FIRE position lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

To Service – Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety switch forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY – COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR – EJECTOR PIN – EJECTOR SPRING (in bolt assembly)

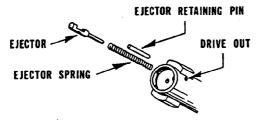


FIG. 1

To Disassemble – With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. (See Fig. 1).

To Reassemble – Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

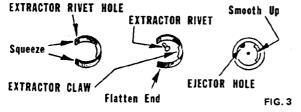
Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR - EXTRACTOR RIVET (in bolt assembly)

To Disassemble – Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.



To Service – Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble – Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See Fig. 3). Straighten tail of extractor. (See Fig. 3). Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

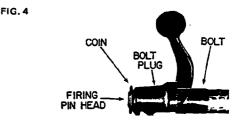
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

## FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. (See Fig. 4). Unscrew and remove firing pin assembly from bolt assembly.

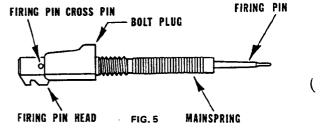


To Service – Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

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FIRING PIN ASSEMBLY – COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



To Disassemble - (with firing pin assembly removed from bolt).

**Caution:** Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble – Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

## FRONT SIGHT HOOD (BDL Grade only)

To Disassemble – Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service – Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### FRONT SIGHT

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To Disassemble – Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble - Follow reverse order.

## FRONT SIGHT RAMP

**To Disassemble** — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

## TRIGGER GUARD (ADL Grade)

To Disassemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble – Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

**TRIGGER GUARD ASSEMBLY – COMPONENTS (BDL** Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. **To Disassemble –** Drive out floor plate pivot pin and remove floor plate from trigger guard.

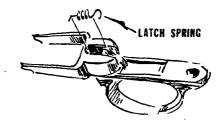
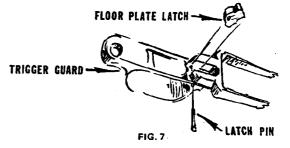


FIG. 6

Caution: Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin - left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble – Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble – Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

## TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

#### STOCK ASSEMBLY

To Disassemble – Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble- Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY – COMPONENTS (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble – Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement, if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble- Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

STOCK ASSEMBLY – COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore-end tip, fore-end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble – See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble – Follow reverse order.

BARREL ASSEMBLY – Includes barrel, barrel brackets, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE: Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q.D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7/8" wide. Swivel assemblies are (Q.D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels – insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust trap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

## **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action — completing the cycle. Each operation is described in sequence below:

## FIRING

With action closed and locked and safety switch in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

## UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

## COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

## EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8'' with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear — completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

## LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY SWITCH

The safety switch, located at right rear of receiver is operated by a push and pull action on the safety switch button. This two-position safety switch has two internal functions. When safety switch is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety switch in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety switch forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

## MALFUNCTIONS

## **Cause and Correction**

**Over-Ride** 

Cause:

- 1. Magazine Follower binds.
  - Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.

Correction: 1. Adjust side angle on Magazine Box.

- 2. Change Spring.
- 3. Correct.
- 4. Straighten or replace Follower.

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## **Stems Chamber**

- Cause: 1. Sharp or rough Receiver Rails.
  - 2. Sharp edge rear end of Chamber.
    - 3. Rough Ramp in Receiver.
    - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - 2. Remove sharpness.
  - 3. Polish Ramp.
  - 4. Adjust.
- **Bolt Closes Hard Over Shells**
- Cause: 1. Bolt interferes with shell rim.
  - 2. Extractor interferes with shell rim.
  - 3. Ejector binds or fails to retract far enough.
  - 4. Burr at Ejector Hole on Bolt.
  - 5. Sharp corners on Bolt Lugs.
  - 6. Extractor Rivet loose.

## Correction: 1. Remove interference or change Bolt.

- 2. Fit new Extractor (grind relief in new Extractor behind Claw).
- 3. Free up or replace.
- 4. Deburr.
- 5. File radius.
- 6. Tighten or replace Rivet.

## Fails to Extract

Cause:

- 1. Tight, rough or oversize Chamber.
- 2. Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
- 4. Height of Claw not correct.
- 5. Extractor stuck back.
- Correction: 1. Ream if tight or rough. Change Barrel Assembly if oversize.
  - 2. Fit new Extractor.
  - 3. Fit new Extractor.
  - 4. Fit new Extractor.
  - 5. Replace Extractor.

#### **Fails To Eject**

- Cause: 1. Burr at Ejector Hole in Bolt.
  - 2. Ejector binds or fails to retract far enough.
    - 3. Extractor Rivet loose.
    - 4. Extractor drops shell.

## Correction: 1. Deburr.

- 2. Free up or replace.
  - 3. Re-stake or replace.
- 4. Replace Extractor.

## Misfires

- Cause: 1. Short Firing Pin (damaged).
  - 2. Firing Pin binds.
  - 3. Short Firing Pin protrusion.
  - 4. Firing Control out of adjustment.
  - 5. Faulty ammunition.

## Correction: 1. Replace.

- 2. Free up or replace.
- 3. Change Firing Pin or Bolt.
- 4. Return the firearm to the factory.
- 5. Replace ammunition.

## Follows Down

- Cause: 1. Trigger out of adjustment.
  - 2. Improper vertical engagement of Sear and Connector.
    - 3. Trigger doesn't retract.
    - 4. Corners on Sear or Connector rounded.
    - 5. Trigger binds on Trigger Guard.
    - 6. Not enough tension on Weight Screw (light pull).
- Correction: 1. Return the firearm to the factory.
  - 2. Return the firearm to the factory.
  - 3. Return the firearm to the factory.
  - 4. Return the firearm to the factory.
  - 5. File Trigger Guard eliminate interference.
  - 6. Return the firearm to the factory.

## **Bolt Opens Hard**

- Cause: 1. See Fails to Extract.
  - 2. Upset Extraction Cam on Bolt Handle.
  - 3. Burr at Ejector Hole in Bolt.
  - 4. Blown or set back Primer on shell.
  - . . . . . .
- Correction: 1. See Fails to Extract.
  - 2. Smooth up.
  - 3. Deburr.
  - 4. Ream Chamber if throat is shallow (ammunition may be at fault).

#### **Bolt Pulls Out**

- Cause: 1. Bolt Stop or Bolt Release binds. 2. Bolt Stop or Bolt Release broken.
- Correction: 1. Return the firearm to the factory.
  - Return the firearm to the factory.

## Safety Switch Works Too Hard or Too Freely

- Cause: 1. Safety switch binds (works hard).
  2. Safety switch Snap Washer stretched out (Safety Switch works too freely.)
- Correction: 1. Return the firearm to the factory. 2. Return the firearm to the factory.

#### **Bulges or Blows Cases**

- Cause: 1. Oversize Chamber.
  - Maximum head space.
- Correction: 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

## Bolt Binds

Cause:	1	Guard	Screws	protrude	into	Bolt	track
Gause.	1.	Guaru	OCI C 44 3	protrage		001	LIQUE.

- 2. Scope Screws protrude into Bolt track.
- 3. Bolt Handle interference on Stock.
- 4. Step at rear of Bolt Lugs.
- Correction: 1. File ends of Screws.
  - 2. File ends of Screws.
    - 3. Correct Stock or fit new Stock.
    - 4. File to blend.

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# REMINGTON FIELD SERVICE MANUAL

PARTS LIST

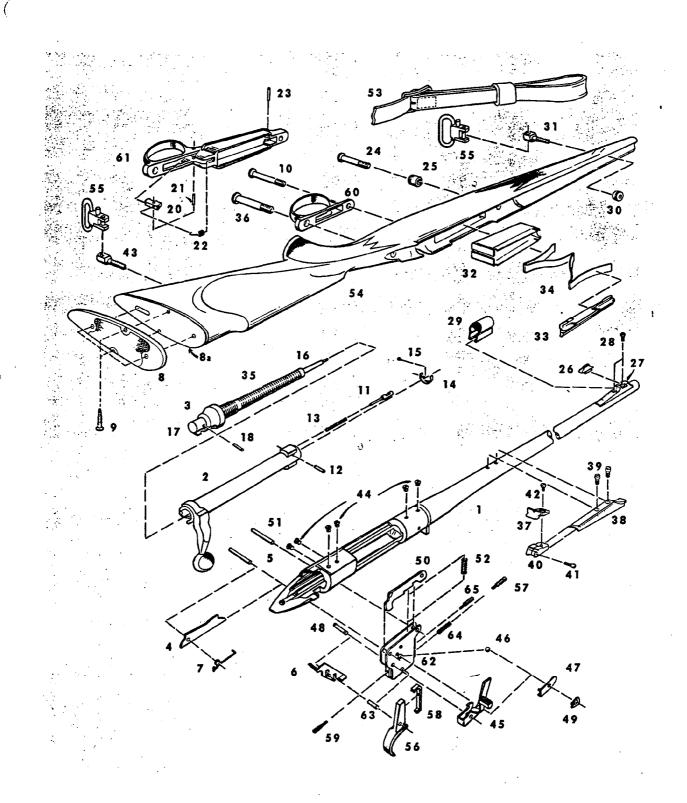
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iew No.	NAME OF PAR	T	View No.	NAME OF PART	·
IOTE: Bas	ic 30-06 Caliber listed below. See Section	onal View for proper			
ide	ntity of parts.		35	Main Spring	
			36	Rear Guard Screw	
1	Barrel Assembly		37	Rear Sight Aperture	
2	Bolt Assembly		38	Rear Sight Base	
	Bolt Final Assembly		39	Rear Sight Base Screw (2)	
3	Bolt Plug		40	Rear Sight Slide	
l -	Bolt Stop	(Restricted)	41	Elevation Screw	
5	Bolt Stop Pin	(Restricted)	42	Windage Screw	
i	Bolt Stop Release	(Restricted)	43 44	Rear Swivel Screw, BDL Grade Receiver Plug Screw	
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	Butt Plate		46		(Restricted)
a	Butt Plate Spacer, BDL		40	Safety Switch Detent Ball	(Restricted)
	Butt Plate Screw		47	Safety Switch Detent Spring	(Restricted)
	Center Guard Screw, ADL Grade		_	Safety Switch Pivot Pin	(Restricted)
	Ejector		49 50	Safety Switch Snap Washer	
	Ejector Pin			Sear Safety Cam	(Restricted)
	Ejector Spring		51	Sear Pin	(Restricted) (Restricted)
	Extractor		52	Sear Spring	(Hestricted)
	Fastener, Sling Strap		53	Sling Strap Assembly, BDL Grade	
	Firing Pin		1	Sling Strap Assembly and Mountin	gs Complete
	Firing Pin Assembly		54	Stock Assembly, ADL Grade	
	Firing Pin Cross Pin			Stock Assembly, BDL Grade	
	Floor Plate Latch, BDL Grade			Stock Reinforcing Screw (not show	
	Floor Plate Latch Pin, BDL Grade	•		Stock Reinforcing Screw Dowel (n	
	Floor Plate Latch Spring, BDL Gr		55	Swivel Assembly, BDL Grade (Q.D	
	Floor Plate Plvot Pin, BDL Grade		56	Trigger	(Restricted)
	Front Guard Screw		57	Trigger Adjusting Screw	(Restricted)
	Front Guard Screw Bushing, ADL	Grade	{	Trigger Assembly	(Restricted)
	Front Sight		58	Trigger Connector	(Restricted)
	Front Sight (Low)		59	Trigger Engagement Screw	(Restricted)
	Front Sight Ramp		60	Trigger Guard	
	Front Sight Ramp, BDL Grade		61	Trigger Guard, BDL Grade	
	Front Sight Ramp Screw			Trigger Guard Assembly, BDL Gra	
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	Front Swivel Nut, BDL Grade		63	Trigger Pin	(Restricted)
	Front Swivel Screw, BDL Grade		64	Trigger Spring	(Restricted)
	Grip Cap, BDL Grade (not shown	,	65	Trigger Stop Screw	(Restricted)
	Grip Cap Screw				
	Grip Cap Spacer, BDL Grade (not	shown)	-		
	Magazine, ADL Grade		1		
	Magazine, BDL Grade (not shown	)	i		
	Magazine Follower		1		
	Magazine Follower, BDL Grade		ł		
	Magazine Tab Screw, ADL Grade		Į		
	Magazine Spring		ł		
	Magazine Spring, BDL Grade				

SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



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MODEL 700

# **MALFUNCTIONS**

## **CAUSE and CORRECTION**

## (Con't. from Page 4)

## Doesn't Group

- Cause: 1. Crown of Barrel damaged.
  - 2. Leading of Bore.
  - 3. Oversize Bore.
  - 4. Improper bedding of Barrel in Stock.
  - 5. Loose Sights.

#### Correction: 1. Recrown.

- Lead or change Barrel.
   Change Barrel.

- Correct bedding.
   Tighten or replace.

Point of Impact Not Correct

- Cause:
- Barrel not straight.
   Horns, breaks, etc. in Bore.
   Improper or loose Sights.
- **Correction:**

1. Straighten.

Correct if possible.
 Tighten or change Sights.

Rev. 382

NAME OF PART

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700 LEFT HAND MODEL

NAME OF PART

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# REMINGTON FIELD SERVICE MANUAL

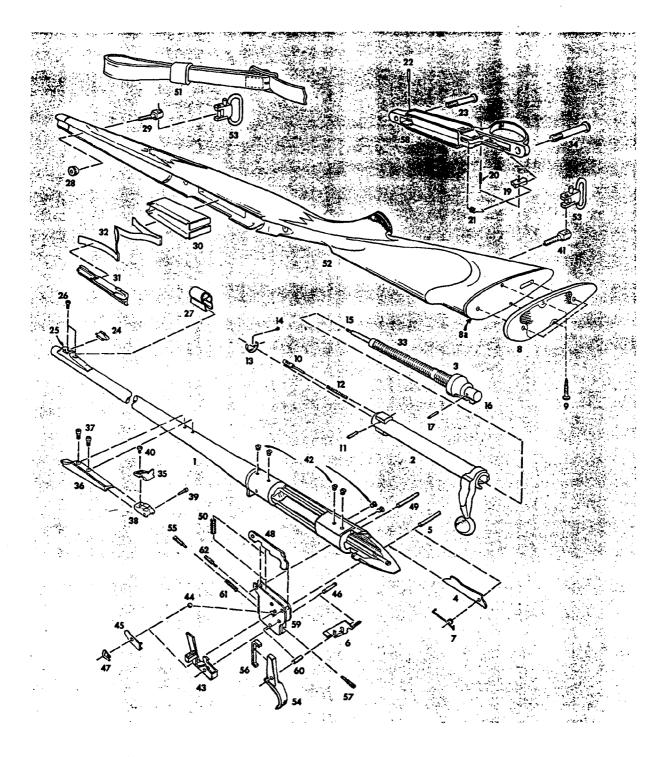
View No.

NOTE: Basic 30-06 caliber listed below. 46 Safety Switch Pivot Pin (Restricted) 47 Safety Switch Snap Washer (Restricted) 48 Sear Safety Cam (Restricted) Barrel Assembly 49 Sear Pin (Restricted) Bolt Assembly 50 Sear Spring (Restricted) Bolt Final Assembly 51 Sling Strap Assembly Bolt Plug Sling Strap Assembly and Mountings Complete Bolt Stop (Restricted) 52 Stock Assembly Bolt Stop Pin (Restricted) Stock Reinforcing Screw (Restricted) **Bolt Stop Release** Stock Reinforcing Screw Dowel (Restricted) Bolt Stop Spring 53 Swivel Assembly (Q.D.) **Butt Plate** 54 Trigger (Restricted) **Butt Plate Spacer** 55 **Trigger** Adjusting Screw (Restricted) Butt Plate Screw Trigger Assembly (Restricted) Ei ector 56 (Restricted) Trigger Connector Ejector Pin 57 Trigger Engagement Screw (Restricted) Ejector Spring 58 Trigger Guard Extractor Trigger Guard Assembly Extractor Rivet 59 Trigger Housing Assembly (Restricted) Fastener, Sling Strap (Restricted) 60 Trigger Pin Firing Pin (Restricted) 61 Trigger Spring Firing Pin Assembly 62 Trigger Stop Screw (Restricted) Firing Pin Cross Pin Floor Plate Latch Floor Plate Latch Pin Floor Plate Latch Spring Floor Plate Pivot Pin Front Guard Screw Front Sight Front Sight (Low) Front Sight Ramp Front Sight Ramp Screw Front Sight Hood Front Swivel Nut Front Swivel Screw Grip Cap Grip Cap Spacer Grip Cap Spacer Screw Magazine Magazine Follower Magazine Spring Main Spring **Rear Guard Screw Rear Sight Aperture** Rear Sight Base Rear Sight Screw Rear Sight Slide **Elevation Screw** Windage Screw **Rear Swivel Screw Receiver Plug Screw** Safety Switch Assembly (Restricted) Safety Switch Detent Ball (Restricted) Safety Switch Detent Spring (Restricted)

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MODEL 700 LEFT HAND MODEL

REMINGTON FIELD SERVICE MANUAL



EXPLODED VIEW

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied – ADL (standard) and BDL. Included in the BDL grade is the Model 700 VARMINT – an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. **Arms Service Division** llion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

Page

## BOLT FINAL ASSEMBLY

To Disassemble – With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release – located in front of trigger and remove bolt final assembly from rifle.

To Service – Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

**BOLT FINAL ASSEMBLY – COMPONENTS:** Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR - EJECTOR PIN - EJECTOR SPRING (in bolt assembly)

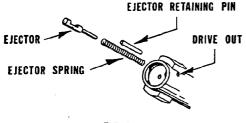


FIG. 1

To Disassemble – With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. (See Fig. 1).

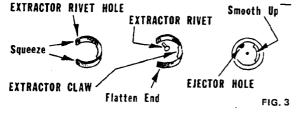
To Reassemble - Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR – EXTRACTOR RIVET (in bolt assembly) To Disassemble – Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.



To Service – Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble – Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See Fig. 3). Straighten tail of extractor. (See Fig. 3). Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

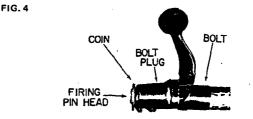
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

## FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

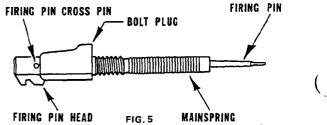
To Disassemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. (See Fig. 4). Unscrew and remove firing pin assembly from bolt assembly.



To Service – Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

FIRING PIN ASSEMBLY - COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



To Disassemble - (with firing pin assembly removed from bolt).

**Caution:** Main spring is under compression. Disassembly of this unit is **not recommended** unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service — All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble – Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

## FRONT SIGHT HOOD (BDL Grade only)

To Disassemble – Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service – Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### FRONT SIGHT

To Disassemble – Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble - Follow reverse order.

#### FRONT SIGHT RAMP

**To Disassemble** — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

## TRIGGER GUARD (ADL Grade)

To Disassemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow reverse order.

## TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble – Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

**TRIGGER GUARD ASSEMBLY** – **COMPONENTS** (BDL Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. **To Disassemble** – Drive out floor plate pivot pin and remove floor plate from trigger guard.

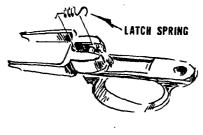
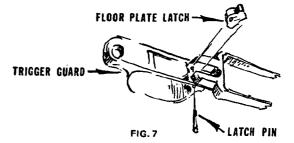


FIG. 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin - left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble – Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble – Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

BOLT STOP - BOLT STOP SPRING - BOLT STOP PIN To Disassemble - Remove bolt final assembly and stock assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

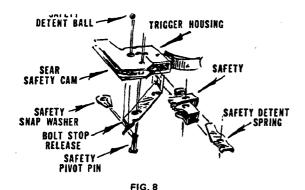
To Reassemble – Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place bolt stop in slot with contoured edge facing up and hole to rear. Align holes and drive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble – Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. (See Fig. 8).

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

To Reassemble – Follow reverse order. Safety assembly and bolt stop should pivot freely.



## TRIGGER ASSEMBLY

To Disassemble – Remove bolt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety carn.

To Service – Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connectorsear engagement may be required.

To Reassemble - Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: Includes bolt stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

To Disassemble – Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

**To Service** — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble – Place trigger connector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring

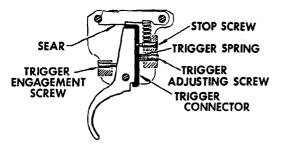


FIG. 9

and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

## TRIGGER ADJUSTMENT (See Fig. 9)

Remove stock assembly and trigger guard.

IMPORTANT: Adjustment or removal of trigger engagement screw (behind trigger) is not recommended unless for replacement. This screw is factory adjusted to provide correct amount of trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger — is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clockwise for heavier weight of pull and counter clockwise for lighter pull. Travel of Trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

#### STOCK ASSEMBLY

To Disassemble – Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble - Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY – COMPONENTS (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble – Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble - Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

STOCK ASSEMBLY – COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore-end tip, fore-end tip spacer, grip cap, grip cap spacer, front swivel nut. To Disassemble – See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble - Follow reverse order.

BARREL ASSEMBLY – Includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE: Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, O.D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7/8" wide. Swivel assemblies are (Q.D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle – assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply shap quick detachable swivels from stock screws and remove strap.

NOTE: After all reassembling and / or adjustments see safety performance check.

FGH-RES. 3-76

## **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action - completing the cycle. Each operation is described in sequence below:

## FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

## UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

## COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

## **EXTRACTION**

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8'' with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear — completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

## FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

## LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

## LOCKING

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Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

## SAFETY

The safety, located at right rear of receiver is operated by a push and pull action on the safety button. This two-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position "F" marking) nullifies above conditions and rifle may be fired.

## Over-Ride

- Cause: 1. Magazine Follower binds.
  - 2. Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.

Correction: 1. Adjust side angle on Magazine Box.

- 2. Change Spring.
- 3. Correct.
- 4. Straighten or replace Follower.

## **Stems Chamber**

- Cause: 1. Sharp or rough Receiver Rails.
  - 2. Sharp edge rear end of Chamber.
  - 3. Rough Ramp in Receiver.
  - 4. Magazine Box loose in Receiver.

Correction: 1. Polish or file.

- 2. Remove sharpness.
- 3. Polish Ramp.
- 4. Adjust.

## Bolt Closes Hard Over Shells

- Cause: 1. Bolt interferes with shell rim.
  - Extractor interferes with shell rim.
    - 3. Ejector binds or fails to retract far enough.
    - 4. Burr at Ejector Hole on Bolt.
    - 5. Sharp corners on Bolt Lugs.
    - 6. Extractor Rivet loose.

## Correction: 1. Remove interference or change Bolt.

- Fit new Extractor (grind relief in new Extractor behind Claw).
  - 3. Free up or replace.
  - 4. Deburr.
  - 5. File radius.
  - 6. Tighten or replace Rivet.

## **Fails to Extract**

- Cause: 1. Tight, rough or oversize Chamber.
  - Extractor broken or damaged.
    - 3. Not enough Hook space on Extractor.
    - 4. Height of Claw not correct.
    - 5. Extractor stuck back.

Correction: 1. Ream if tight or rough.

- Change Barrel Assembly if oversize.
- 2. Fit new Extractor.
- 3. Fit new Extractor.
- 4. Fit new Extractor.
- 5. Replace Extractor.

# REMINGTON FIELD SERVICE MANUAL

PARTS LIST

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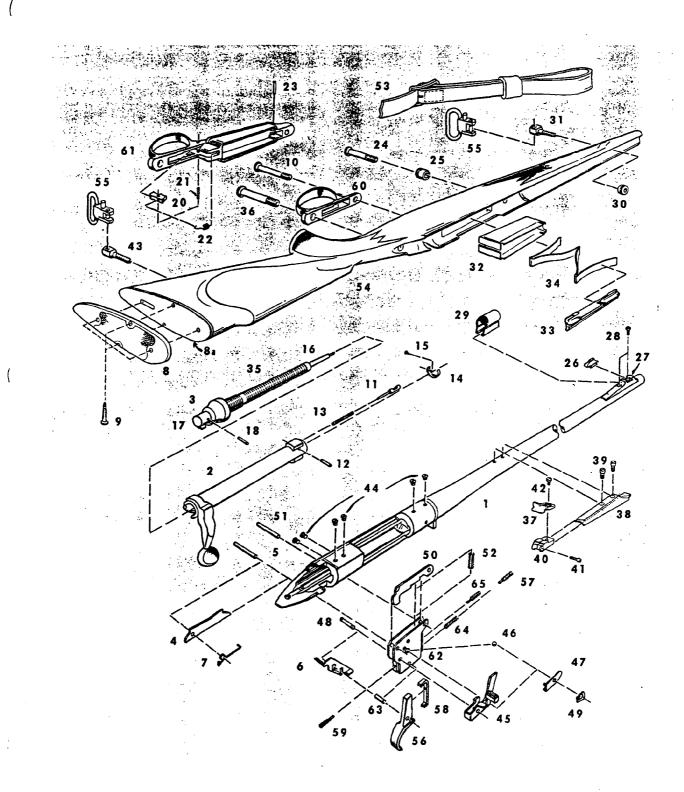
View No.	Port No.	NAME OF PART	View No.	Part No.	NAME OF PART
TE.	Basia	30-06 Caliber listed below. See Sectional View for proper			
JIE:		y of parts. See added page for other caliber part listings.		91017	Magazine Follower, BDL Grade
		,		15940	Magazine Tab Screw, ADL Grade
		Barrel Assembly	34	17028	Magazine Spring
!		Boit Assembly		15677	Magazine Spring, BDL Grade
		Bolt Final Assembly	35	17029	Main Spring
; ·	17012	Bolt Plug	36	26355	Rear Guard Screw
	17013	Bolt Stop	37	32510	Rear Sight Aperture
•	24475	Bolt Stop Pin	38	32500	Rear Sight Base
	15478	Bolt Stop Release	39	28505	Rear Sight Base Screw (2)
	15224	Bolt Stop Spring	40	90905	Rear Sight Slide
9	90953	Butt Plate	41	90906	Elevation Screw
a (	90954	Butt Plate Spacer, BDL	42	90904	Windage Screw
:	25380	Butt Plate Screw	43	15358	Rear Swivel Screw, BDL Grade
	15287	Center Guard Screw, ADL Grade	44	17034	Receiver Plug Screw
	17017	Ejector	45	26585	Safety Assembly
	17676	Ejector Pin	46	23222	Safety Detent Ball
	17019	Ejector Spring	47	15368	Safety Detent Spring
	14669	Extractor	48	17043	Safety Pivot Pin
:	27340	Extractor Rivet	49	17044	Safety Snap Washer
	15376	Fastener, Sling Strap	50	15666	Sear Safety Cam
	22020	Firing Pin	51	24476	Sear Pin
	2040	Firing Pin Assembly	52	17047	Sear Spring
	7022	Firing Pin Cross Pin	53	30855	Sling Strap Assembly, BDL Grade
	5291	Floor Plate Latch, BDL Grade		26990	Sling Strap Assembly and Mountings Complete
	6451	Floor Plate Latch Pin, BDL Grade	54	33366	Stock Assembly, ADL Grade
	6452	Floor Plate Latch Spring, BDL Grade		33371	Stock Assembly, BDL Grade
	6453	Floor Plate Pivot Pin, BDL Grade		1 <b>8</b> 186	Stock Reinforcing Screw (not shown)
	2035	Front Guard Screw		16970	Stock Reinforcing Screw Dowel (not shown)
	5161	Front Guard Screw Bushing, ADL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)
	5373	Front Sight	56	15280	Trigger
	5719	Front Sight (Low)	57	17053	Trigger Adjusting Screw
	28510	Front Sight Ramp		26345	Trigger Assembly
	5635	Front Sight Ramp, BDL Grade	58	19461	Trigger Connector
	28505	Front Sight Ramp Screw	59	91128	Trigger Engagement Screw
	5363	Front Sight Hood, BDL Grade	60	15281	Trigger Guard
	5357	Front Swivel Nut, BDL Grade	61	26376	Trigger Guard, BDL Grade
	5356	Front Swivel Screw, BDL Grade		26371	Trigger Guard Assembly, BDL Grade
	5356 10957	Grip Cap, BDL Grade (not shown)	62	26655	Trigger Housing Assembly
	25380	Grip Cap Screw	63	24477	Trigger Pin
	0958		64	15400	Trigger Spring
		Grip Cap Spacer, BDL Grade (not shown)	65	15481	Trigger Stop Screw
	5284	Magazine, ADL Grade			
	6430	Magazine, BDL Grade (not shown)			
g	0952	Magazine Follower			

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SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



6

## ADDITIONAL CALIBERS (Not Shown in Sectional View) INCLUDES VARMINT MODEL

# REMINGTON FIELD SERVICE MANUAL

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Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

Part No.	NAME OF PART	Part No.	NAME OF PART
15709	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm
15850	Extractor, 222-223 Rem., 17 Rem.		Rem., 22-250 Rem., BDL Grade, 17 Rem.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223
27342	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.		Rem., 243 Win., 6mm Rem., 22-250 Rem.
22021	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-	33375	Stock Assembly, Varmint, BDL Grade, 25-06
	250 Rem., 223 Rem., 17 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 &
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308		308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
	Win., 6mm Rem., 22-250 Rem. 223 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.,
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308		223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.
	Win., 6mm Rem., 22-250 Rem., 17 Rem.		
22037	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308		CALIBERS: 375 H & H Magnum, 458 WIN. MAGNUM
	Win., 6mm Rem., 22-250 Rem., 17 Rem.	27265	Barrel Assembly, 375 H & H Mag.
16204	Front Scope Base, Varmint	27266	Barrel Assembly, 458 Win. Mag.
14659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	15709	Extractor
28511	Front Sight Ramp, ADL Grade	16771	Front Sight, 375 H & H Mag.
15992	Front Sight Ramp, BDL Grade	23805	Front Sight, 458 Win. Mag.
15282	Magazine, ADL Grade, 222 Rem.	27270	Stock Assembly, 375 H & H Mag., 458 Win. Mag. (in-
16716	Magazine, BDL Grade, 222 Rem., 223 Rem., 17 Rem.		cludes same as standard Magnum except Stock Bolt (2),
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem.	4	Nut (2), Cover (4) used)
	22-250 Rem.		
16715	Magazine, BDL. Grade, 243 & 308 Win., 6mm Rem.	1	DISCONTINUED or SERVICE PARTS
	22-250 Rem.	26270	Barrel Assembly, 280 Rem.
14756	Magazine, BDL Grade	20467	Extractor, 222 Cal.
90951	Magazine Follower, 222 Rem., 223 & 17 Rem.	17639	Ejector, 222 Cal.
90982 ·	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264
	Rem.		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL
15742	Magazine Spacer, 222 Rem.		Grade
15286	Magazine Spacer, 222 Rem., BDL Grade	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.		Rem., 222 Rem. Mag., 243 Win., BDL Grade
91133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win.,
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		ADL Grade
15698	Magazine Spring, 22-250 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264
15699	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win.,		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
	BDL Grade	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem.,
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win.,		264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
	17 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight
18843	Rear Scope Base, Varmint		Assembly, Rear Sight Base, Rear Sight Base Screw (2),
90949	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag.		Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2)
25410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		
18842	Scope Base Screw, Rear Varmint		
16205	Scope Base Screw, Front Varmint	1	
33380	Stock Assembly, 7mm Rem. Mag., ADL Grade		
33365	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm		
	Rem., 22-250 Rem., ADL Grade		
33385	Stock Assembly, 7mm Rem. Mag., 264 & 300 Win. Mag.,	1	
	BDL Grade		

Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

## **MALFUNCTIONS**

## **CAUSE and CORRECTION**

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## (Con't. from Page 4)

Fails to Eject		-	Bolt Pulls Ou	it .
Cause:	2. Ejector	Ejector Hole in Bolt. binds or fails to retract far enough. or Rivet loose.	Cause:	<ol> <li>Bolt Stop or Bolt Release binds.</li> <li>Bolt Stop or Bolt Release broken,</li> </ol>
		or drops shell.	Correction:	1. Free up. 2. Replace.
Correction:	1. Deburr.	or replace.		
	3. Re-stake	e or replace.	Safe Works T	oo Hard or Too Freely
Misfires	4. Replace	Extractor.	Cause:	<ol> <li>Safe binds (works hard).</li> <li>Safety Snap Washer stretched out (Safe works too freely).</li> </ol>
	1 Oh			1. 5
Cause: -	<ol> <li>Firing P</li> <li>Short Fi</li> <li>Firing C</li> </ol>	iring Pin protrusion. Control out of adjustment.	Correction:	1. Free up. 2. Replace Washer.
	5. Faulty a	ammunition.	Bulges or Blo	iws Cases
Correction:	1. Replace 2. Free up	or replace.	Cause:	<ol> <li>Oversize Chamber.</li> <li>Maximum head space.</li> </ol>
	3. Change 4. Adjust.	Firing Pin or Bolt.	Correction:	<ol> <li>Change Barrel or Barrel and Receiver Assembly.</li> <li>Fit new Bolt (ammunition may be at fault).</li> </ol>
Follows Down				
Cause:	1. Trigger	Adjusting Screw, rear, out of adjust-	Bolt Binds	
	Sear and	improper horizontal engagement of d Connector). er vertical engagement of Sear and	Cause:	<ol> <li>Guard Screws protrude into Bolt track.</li> <li>Scope Screws protrude into Bolt track.</li> </ol>
	Connect 3. Trigger (	tor. doesn't retract.		<ol> <li>Bolt Handle interference on Stock.</li> <li>Step at rear of Bolt Lugs.</li> </ol>
	5. Trigger	on Sear or Connector rounded. binds on Trigger Plate. bugh tension on Weight Screw (light	Correction:	<ol> <li>File ends of Screws.</li> <li>File ends of Screws.</li> <li>Correct Stock or fit new Stock.</li> <li>File to blend.</li> </ol>
Correction:	1. Adjust.			
		Fire Control.	Doesn't Grou	lb.
	4. Fit new	Fire Control. Fire Control. liminate interference.	Cause:	1. Crown of Barrel damaged. 2. Leading of Bore.
	6. Adjust.			<ol> <li>Oversize Bore.</li> <li>Improper bedding of Barrel in Stock.</li> <li>Loose Sights.</li> </ol>
Bolt Opens Ha	ď		Correction:	1. Recrown
Cause:	2. Upset E: 3. Burr at l	s to Extract. xtraction Cam on Bolt Handle. Ejector Hole in Bolt. rr set back Primer on shell.	Correction.	<ol> <li>Lead or change Barrel.</li> <li>Change Barrel.</li> <li>Correct bedding.</li> <li>Tighten or replace.</li> </ol>
Correction:	1. See Fail: 2. Smooth	s to Extract. up.	Point of Imp	act Not Correct
	3. Deburr.		•	
	4. Ream C munitio	Chamber if throat is shallow (am- n may be at fault).	Cause:	<ol> <li>Barrel not straight.</li> <li>Horns, breaks, etc. in Bore.</li> <li>Improper or loose Sights.</li> </ol>
			Correction:	<ol> <li>Straighten.</li> <li>Correct if possible.</li> <li>Tighten or change Sights.</li> </ol>

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## MODEL 700 LEFT HAND MODEL

# REMINGTON FIELD SERVICE MANUAL

•w 0.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOI		: 30-06 caliber listed below. For other caliber parts	41	15358	Rear Swivel Screw
	and i	numbers see additional calibers list.	42	17034	Receiver Plug Screw
			43	32900	Safety Assembly
1		Barrel Assembly	44	23222	Safety Detent Ball
2		Bolt Assembly	45	90557	Safety Detent Spring
		Bolt Final Assembly	46	17043	Safety Pivot Pin
3	17012	Bolt Plug	47	17044	Safety Snap Washer
4	17013	Bolt Stop	48	15666	Sear Safety Cam
5	24475	Bolt Stop Pin	49	24476	Seer Pin
6	90555	Bolt Stop Release	50	17047	Sear Spring
7	90554	Bolt Stop Spring	51	30855	Sling Strap Assembly
8	90953	Butt Plate		26990	Sling Strap Assembly and Mountings Complete
8a	90954	Butt Plate Spacer	52	33391	Stock Assembly
9	25380	Butt Plate Screw	1	18186	Stock Reinforcing Screw
10	17017	Ejector	1	16970	Stock Reinforcing Screw Dowel
11	17676	Ejector Pin	53	26555	Swivel Assembly (Q.D.)
12	17019	Ejector Spring	54	15280	Trigger
13	14669	Extractor	55	17053	Trigger Adjusting Screw
4	27340	Extractor Rivet		32895	Trigger Assembly
	15376	Fastener, Sling Strap	56	19461	Trigger Connector
5	22020	Firing Pin	57	91128	Trigger Engagement Screw
6	22040	Firing Pin Assembly	58	26376	Trigger Guard
17	17022	Firing Pin Cross Pin	1	26371	Trigger Guard Assembly
9	15291	Floor Plate Latch	59	32905	Trigger Housing Assembly
20	16451	Floor Plate Latch Pin	60	24477	Trigger Pin
21	16452	Floor Plate Latch Spring	61	15400	Trigger Spring
22	16453	Floor Plate Pivot Pin	62	15481	Trigger Stop Screw
23	22035	Front Guard Screw			
24	15373	Front Sight			
	15719	Front Sight (Low)			·
25	15635	Front Sight Ramp			
26	28505	Front Sight Ramp Screw	}		
27	15363	Front Sight Hood	1		
28	15357	Front Swivel Nut			ADDITIONAL CALIBERS
29	15356	Front Swivel Screw	1		
	90957	Grip Cap	1		NOTE: Part not listed same as 30-06 Caliber
	90958	Grip Cap Spacer	1		Percel Association 7 and 10
	25380	Grip Cap Spacer Screw	1		Barrel Assembly, 7mm Rem. Mag
30 	16430		1		Barrel Assembly, 270 Win.
31	91017	Magazine Follower	1	15700	Bolt Assembly, 7mm Rem. Mag.
2	15677	Magazine Spring		15709	Extractor, 7mm Rem. Mag.
3	17029	Main Spring		27341	Extractor Rivet, 7mm Rem. Mag
4	26355	Rear Guard Screw		14659	Front Sight, 7mm Rem. Mag.
5	23510	Rear Sight Aperture	1	90949	Recoil Pad, 7mm Rem. Mag.
6	32500	Rear Sight Base	1	25410	Recoil Pad Screw, 7mm Rem. Mag.
7	28505	Rear Sight Screw		33395	Stock Assembly, 7mm Rem. Mag.
8	90905	Rear Sight Slide			
9	90906	Elevation Screw			
0	90904	Windage Screw	1		

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EXPLODED VIEW

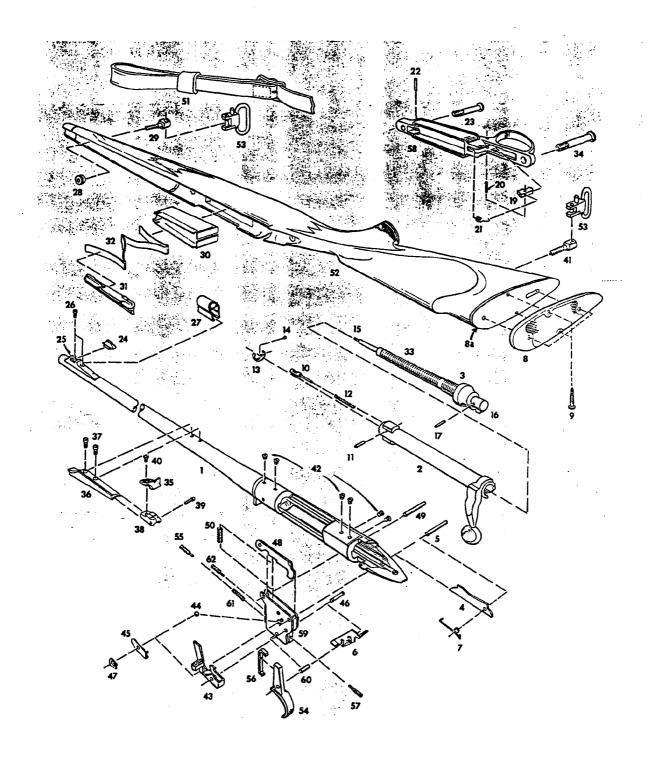
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# REMINGTON FIELD SERVICE MANUAL

MODEL 700 LEFT HAND MODEL



## SAFETY PERFORMANCE CHECK

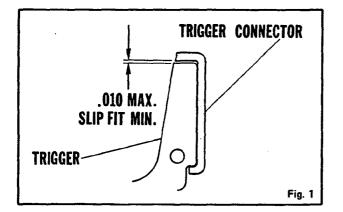
After reassembly, the following checks for proper function of the safety should be made.

Close bolt. Put safety ON SAFE. Lift bolt handle. (Bolt handle should not raise). Pull trigger (firing pin should not fall). Action of trigger pull should be smooth (no bind, drag, click or catch). Release trigger (trigger should return to former position). Put safety ON FIRE position (firing pin should not fall). Pull trigger (firing pin should fall). Repeat test at least three (3) times.

Safety should function on two (2) positive stop positions (ON SAFE – FIRE). If positions are not positive, check parts. Inspect detent holes, retainer, retainer pin, detent, detent spring and related parts for possible cause. Replace any worn or damaged parts and lubricate with a dry lubricant. Reassemble and check. If stop positions are not positive replace complete trigger housing assembly.

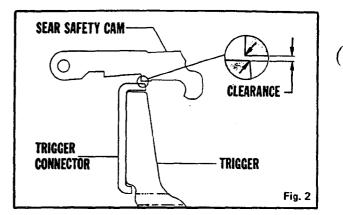
NOTE: Lubrication should not be used as a remedy for trigger housing assembly problems. The cause should be positively located and corrected.

When repairing trigger housing assembly wash parts thoroughly with a petroleum solvent. An accumulation of gun oil or dried oil can build a film that may cause malfunctions. Relubricate with a dry lubricant and reassemble. Check clearance between trigger and trigger connector .010 MAX. slip fit (MIN.) with feeler gage (see Fig. 1). Check trigger connector for straightness and cracks at trigger stop screw hole. Make sure there is no bind or catch in trigger, sear safety cam or safety lever about pivots.

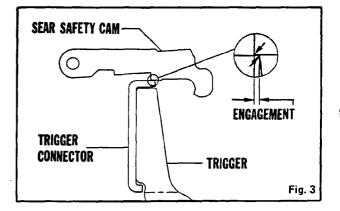


When replacing trigger housing assembly, take care not to bend or spring the housing. Sear safety cam should pivot freely. To check, remove bolt, move safety to OFF SAFE, pull trigger and press down on rear of sear safety cam and release.

For proper safety function there must be clearance between trigger connector and sear safety cam. To check close bolt and put safety ON SAFE. Visually inspect through hole in side of trigger housing (see Fig. 2). If there is no clearance, replace safety assembly, or trigger housing assembly. Corners must be sharp. (Arrows).



Sear safety cam and trigger connector engagement of .015'' - .020'' on field rifles and .010'' - .015'' on target rifles is critical (see Fig. 3). Replace any worn or damaged parts. To adjust, close bolt and place safety OFF SAFE. Turn trigger engagement screw clockwise until rifle fires. Turn screw counterclockwise ½ turn ( $90^{\circ}$ ) and check engagement. (see note A). Corners must be sharp. (Arrows).



To adjust trigger stop screw, close bolt and put safety OFF SAFE. Turn trigger stop screw clockwise until it touches trigger. Pull and hold trigger rearward. Turn trigger stop screw counter clockwise until rifle fires. Turn an additional 1/8 turn for clearance. (see note A).

Trigger pull adjustment on any field rifle should never be adjusted below three (3) pounds. (see note A).

Trigger pull adjustment on any target rifle should never be adjusted below two (2) pounds. (see note A).

NOTE A: After any adjustments to trigger housing assembly screws, repeat all safety checks. Check for "follow down." See malfunctions. Restake or reseal screws with DuPont Duco cement.

When replacing stock assembly, check for clearance between following parts: Safety Lever – Stock; Trigger – Trigger Guard; Trigger – Stock.

## MODELS 725-721-722-700-600

## MALFUNCTIONS

- "Follow Down." After reassembling rifle, check for "follow down" condition. (Firing pin moves to uncocked position as bolt is closed). Put safety OFF SAFE. Close bolt smartly. Firing pin should remain cocked (dry fire to check). "Follow down" may be caused by improper sear safety cam – trigger connector engagement or by trigger being held back by interference between trigger and stock, trigger and trigger guard, and / or trigger housing. "Follow down" can also be caused by sear safety cam binding, by missing parts and / or broken connector. (see note B).
- 2. "Firing Pin Falls." If firing pin falls when rifle is jarred or when bolt handle is lifted check following:

Firing pin head binds in guide slot in receiver. Firing pin head and slot should align. To check, remove firing pin assembly from bolt. Reassemble bolt to receiver. Small cocking notch on rear edge of bolt should align with slot in receiver.

Guide slot in receiver should be free of burrs. Remove trigger housing and clean any burrs from slot.

This malfunction may also be caused by improper sear safety cam – trigger connector engagement. Adjust engagement as previously described. (see note B).

3. "Firing Pin Fails to Fall." If firing pin fails to fall when trigger is pulled or trigger has to be pulled more than once. See firing pin falls for possible cause and corrections. (see note B).

NOTE B: Correct malfunction 100% or return rifle to factory.

For smooth operation, a good quality gun grease should be applied to threads on bolt plug, firing pin head cocking cam at rear of bolt and on locking lug engagement area.

> JPL-RES. 3-76

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied - ADL (standard) and BDL. Included in the BDL grade is the Model 700 VARMINT - an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. **Arms Service Division** Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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## BOLT FINAL ASSEMBLY

To Disassemble —With safety switch forward on FIRE position lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

To Service – Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety switch forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY – COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR – EJECTOR PIN – EJECTOR SPRING (in bolt assembly)

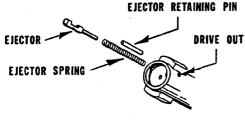


FIG. 1

To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. (See Fig. 1).

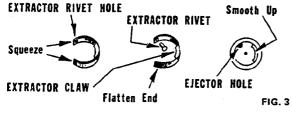
To Reassemble – Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR – EXTRACTOR RIVET (in bolt assembly) To Disassemble – Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.



To Service – Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble — Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See Fig. 3). Straighten tail of extractor. (See Fig. 3). Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

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Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

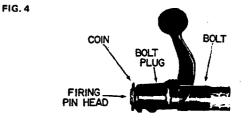
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

## FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble -- Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. (See Fig. 4). Unscrew and remove firing pin assembly from bolt assembly.

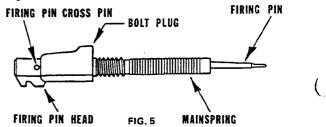


To Service – Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

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FIRING PIN ASSEMBLY - COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



To Disassemble - (with firing pin assembly removed from bolt).

Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble – Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

## FRONT SIGHT HOOD (BDL Grade only)

To Disassemble – Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service – Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### FRONT SIGHT

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To Disassemble – Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble – Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

## TRIGGER GUARD (ADL Grade)

To Disassemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow reverse order.

## TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble – Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

TRIGGER GUARD ASSEMBLY – COMPONENTS (BDL Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. To Disassemble – Drive out floor plate pivot pin and remove floor plate from trigger guard.

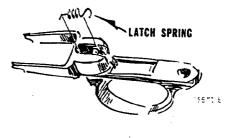
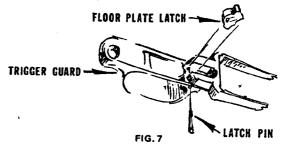


FIG. 6

Caution: Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin - left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble – Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble – Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

#### STOCK ASSEMBLY

To Disassemble – Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble- Follow reverse order. Tighten screws securely.

**STOCK ASSEMBLY – COMPONENTS** (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. **To Disassemble –** Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement, if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble- Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

STOCK ASSEMBLY – COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore-end tip, fore-end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble – See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble- Follow reverse order.

BARREL ASSEMBLY – Includes barrel, barrel brackets, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

**SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE:** Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q.D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7/8" wide. Swivel assemblies are (Q.D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle – assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels – insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust trap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

## **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action — completing the cycle. Each operation is described in sequence below:

## FIRING

With action closed and locked and safety switch in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

## EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear - completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

## LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

## SAFETY SWITCH

The safety switch, located at right rear of receiver is operated by a push and pull action on the safety switch button. This two-position safety switch has two internal functions. When safety switch is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety switch in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety switch forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

## MALFUNCTIONS

## **Cause and Correction**

## **Over-Ride**

- Cause: 1. Magazine Follower binds.
  - 2. Damaged Follower Spring.
    - 3. Magazine Spring caught under Guard.
    - 4. Tabs on Follower bent.

Correction: 1. Adjust side angle on Magazine Box.

- 2. Change Spring.
- 3. Correct.
- 4. Straighten or replace Follower.

#### Stems Chamber

- Cause: 1. Sharp or rough Receiver Rails. 2. Sharp edge - rear end of Chamber.
  - 3. Rough Ramp in Receiver.
  - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - 2. Remove sharpness.
  - 3. Polish Ramp.
  - 4. Adjust.

## **Bolt Closes Hard Over Shells**

- Cause: 1. Bolt interferes with shell rim.
  - 2. Extractor interferes with shell rim.
  - 3. Ejector binds or fails to retract far enough.
  - 4. Burr at Ejector Hole on Bolt.
  - 5. Sharp corners on Bolt Lugs.
  - 6. Extractor Rivet loose.

## Correction: 1. Remove interference or change Bolt.

- 2. Fit new Extractor (grind relief in new Extractor behind Claw).
- 3. Free up or replace.
- 4. Deburr.
- 5. File radius.
- 6. Tighten or replace Rivet.

## **Fails to Extract**

- Cause: 1. Tight, rough or oversize Chamber.
  - 2. Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
  - 4. Height of Claw not correct.
  - 5. Extractor stuck back.
- Correction: 1. Ream if tight or rough. Change Barrel Assembly if oversize.
  - 2. Fit new Extractor.
  - 3. Fit new Extractor.
  - 4. Fit new Extractor.
  - 5. Replace Extractor.

## Fails To Eject

- Cause: 1. Burr at Ejector Hole in Bolt.
  - 2. Ejector binds or fails to retract far enough.
  - 3. Extractor Rivet loose.
  - 4. Extractor drops shell.
- Correction: 1. Deburr.
  - 2. Free up or replace.
  - 3. Re-stake or replace.
  - 4. Replace Extractor.

## Misfires Cause:

- 1. Short Firing Pin (damaged).
- 2. Firing Pin binds.
- 3. Short Firing Pin protrusion.
- 4. Firing Control out of adjustment.
- 5. Faulty ammunition.

## Correction: 1. Replace.

- 2. Free up or replace.
- 3. Change Firing Pin or Bolt.
- 4. Return the firearm to the factory.
- 5. Replace ammunition.

## **Follows** Down

- Cause: 1. Trigger out of adjustment.
  - 2. Improper vertical engagement of Sear and Connector.
  - 3. Trigger doesn't retract.
    - 4. Corners on Sear or Connector rounded.
    - 5. Trigger binds on Trigger Guard.
    - Not enough tension on Weight Screw (light pull).
- Correction: 1. Return the firearm to the factory.
  - 2. Return the firearm to the factory.
  - 3. Return the firearm to the factory.
  - 4. Return the firearm to the factory.
  - 5. File Trigger Guard eliminate interference.
  - 6. Return the firearm to the factory.

## **Bolt Opens Hard**

- Cause: 1. See Fails to Extract.
  - 2. Upset Extraction Cam on Bolt Handle.
  - 3. Burr at Ejector Hole in Bolt.
  - 4. Blown or set back Primer on shell.

Correction: 1. See Fails to Extract.

- 2. Smooth up.
- 3. Deburr.
- 4. Ream Chamber if throat is shallow (ammunition may be at fault).

## Boit Pulis Out

- Cause: 1. Bolt Stop or Bolt Release binds.
  - 2. Bolt Stop or Bolt Release broken.
- Correction: 1. Return the firearm to the factory. 2. Return the firearm to the factory.

## Safety Switch Works Too Hard or Too Freely

- Cause: 1. Safety switch binds (works hard). 2. Safety switch Snap Washer stretched out (Safety Switch works too freely.)
- **Correction: 1.** Return the firearm to the factory. 2. Return the firearm to the factory.

## **Bulges or Blows Cases**

- Cause: 1. Oversize Chamber.
  - 2. Maximum head space.
- Correction: 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

## **Bolt Binds**

- Cause: 1. Guard Screws protrude into Bolt track.
  - 2. Scope Screws protrude into Bolt track.
    - 3. Bolt Handle interference on Stock.
    - 4. Step at rear of Bolt Lugs.
- Correction: 1. File ends of Screws.
  - 2. File ends of Screws.
    - 3. Correct Stock or fit new Stock.
    - 4. File to blend.

# REMINGTON FIELD SERVICE MANUAL

PARTS LIST

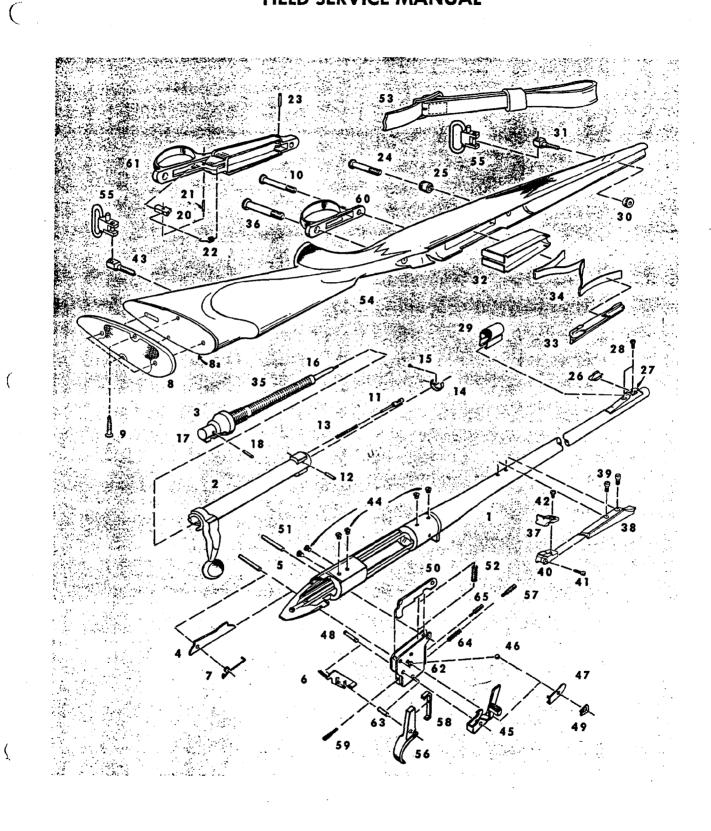
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'iew No.	Part No.	NAME OF PART		View No.	Part No.	NAME OF PART	
IOT	E: Basic 3	0-06 Caliber listed below. See Sectional	View for proper	-			
	identity	y of parts. See added page for other calib	er part listings.	35	17029	Main Spring	
				36	26355	Rear Guard Screw	
1		Barrel Assembly		37	32510	Rear Sight Aperture	
2		Bolt Assembly		39	91595 28505	Rear Sight Base	
		Bolt Final Assembly		40	28505 90905	Rear Sight Base Screw (2) Been Sight Slide	
3	17012	Bolt Plug			90905	Rear Sight Slide	
4	17013	Bolt Stop	(Restricted)	41	90904 90904	Elevation Screw	
5	24475	Bolt Stop Pin	(Restricted)	42	15358	Windage Screw Rear Swivel Screw, BDL Grade	
6	15478	Boit Stop Release	(Restricted)	43	15356	Receiver Plug Screw	
7	15224	Bolt Stop Spring	(Restricted)	45	26585	Safety Switch Assembly	(Restricted)
8	90953	Butt Plate		46	23222	Safety Switch Detent Ball	(Restricted)
3a	90954	Butt Plate Spacer, BDL		40	15368	Safety Switch Detent Spring	(Restricted)
Э	25380	Butt Plate Screw		48	17043	Safety Switch Pivot Pin	(Restricted)
D	15287	Center Guard Screw, ADL Grade		49	17043	•	(Restricted)
1	17017	Ejector		50	15666	Safety Switch Snap Washer Sear Safety Cam	(Restricted)
2	17676	Ejector Pin		51	24476	Sear Pin	(Restricted)
3	17019	Ejector Spring		52	17047	Sear Spring	(Restricted)
4	91816	Extractor		52	30855	Sling Strap Assembly, BDL Grade	(Hestileted)
	15376	Fastener, Sling Strap			26990	Sling Strap Assembly, BDE Glade	Complete
5	22020	Firing Pin		54	33366	Stock Assembly, ADL Grade	omprete
7	22040	Firing Pin Assembly		1.04	33371	Stock Assembly, BDL Grade	
3	17022	Firing Pin Cross Pin			18186	Stock Reinforcing Screw (not show	n)
)	15291	Floor Plate Latch, BDL Grade			16970	Stock Reinforcing Screw Dowel (no	· .
1	16451	Floor Plate Latch Pin, BDL Grade		55	26555	Swivel Assembly, BDL Grade (Q.D.)	
2	16452	Floor Plate Latch Spring, BDL Grade		56	15280		(Restricted)
3	16453	Floor Plate Plvot Pin, BDL Grade		57	17053	Trigger Trigger Adjusting Screw	(Restricted)
1	22035	Front Guard Screw		1 37	26345	Trigger Adjusting Screw	(Restricted)
5	15161	Front Guard Screw Bushing, ADL Gra	de	58	19461	Trigger Assembly Trigger Connector	(Restricted)
6	15373	Front Sight		59	91128		(Restricted)
	15719	Front Sight (Low)		60	15281	Trigger Engagement Screw	(nestricted)
7	28510	Front Sight Ramp		61	26376	Trigger Guard Trigger Guard, BDL Grade	
	15635	Front Sight Ramp, BDL Grade			26376	Trigger Guard, BDL Grade	
В	28505	Front Sight Ramp Screw		62		Trigger Guard Assembly, BDL Grad	(Restricted)
9	15363	Front Sight Hood, BDL Grade		62 63	26655 24477	Trigger Housing Assembly Trigger Rin	(Restricted)
D	15357	Front Swivel Nut, BDL Grade		64	15400	Trigger Pin Trigger Spring	
1	15358	Front Swivel Screw, BDL Grade		65	15400	Trigger Spring	(Restricted) (Restricted)
	90957	Grip Cap, BDL Grade (not shown)		00	10401	Trigger Stop Screw	(nestricted)
	25380	Grip Cap Screw					
	90958	Grip Cap Spacer, BDL Grade (not show	wn)				
2	15284	Magazine, ADL Grade					
	16430	Magazine, BDL Grade (not shown)		1			
3	90952	Magazine Follower					
	91017	Magazine Follower, BDL Grade					
	15940	Magazine Tab Screw, ADL Grade					
4	17028	Magazine Spring					
	15677	Magazine Spring, BDL Grade					

SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



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R2524322

## ADDITIONAL CALIBERS (Not Shown in Sectional View) INCLUDES VARMINT MODEL

# REMINGTON FIELD SERVICE MANUAL

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## Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

art No.	NAME OF PART	Part No.	NAME OF PART
		33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm
91837	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.		Rem. 22-250 Rem., BDL Grade, 17 Rem.
91906	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223
22021	Firing Pin,222 Rem., 234-308 Win., 6mm Rem. Mag., 22-		Rem.,243 Win., 6mm Rem., 22-250 Rem.
	250 Rem., 223 Rem., 17 Rem.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 &
	Win., 6mm Rem., 22-250 Rem. 223 Rem.		308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.,
	Win., 6mm Rem., 22-250 Rem., 17 Rem.		223 Rem., 243 Win., 6mm Rem., 22·250 Rem.
22037	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308		
	Win., 6mm Rem., 22-250 Rem., 17 Rem.		CALIBERS: 375 H & H MAGNUM, 458 WIN. MAGNUM
16204	Front Scope Base, Varmint	27265	Barrel Assembly, 375 H & H Mag.
14659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	27266	Barrel Assembly, 458 Win. Mag.
28511	Front Sight Ramp, ADL Grade	15709	Extractor
15992	Front Sight Ramp, BDL Grade	16771	Front Sight, 375 H & H Mag.
15282	Magazine, ADL Grade, 222 Rem.	23805	Front Sight, 458 Win. Mag.
16716	Magazine, BDL Grade, 222 Rem., 223 Rem., 17 Rem.	27270	Stock Assembly, 375 H & H Mag., 458 Win. Mag. (in-
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem.		cludes same as standard Magnum except Stock Bolt (2)
	22-250 Rem.		Nut (2), Cover (4) used)
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem.		
	22-250 Rem.		DISCONTINUED or SERVICE PARTS
14756	Magazine, BDL Grade	26270	Barrel Assembly, 280 Rem.
90951	Magazine Follower, 222 Rem., 223 & 17 Rem.	20467	Extractor, 222 Cal.
90982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250	17639	Ejector, 222 Cal.
	Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag. 264
15742	Magazine Spacer, 222 Rem.		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL
15286	Magazine Spacer, 222 Rem., BDL Grade		Grade
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222
91133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		Rem., 222 Rem. Mag., 243 Win., BDL Grade
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win.,
15698	Magazine Spring, 22-250 Rem.		ADL Grade
15699	Magazine Spring, 22-250 Rem., 6mm Rem. 243 Win.,	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264
43050	BDL Grade		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win.,	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem.,
10042	17 Rem.		264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
18843	Rear Scope Base, Varmint	28200	Rear Sight Assembly, Complete (includes Rear Sight
90949 25410	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag.	1	Assembly, Rear Sight Base, Rear Sight Base Screw (2),
	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.	1	Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2)
18842 16204	Scope Base Screw, Rear Varmint	15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag.
	Scope Base Screw, Front Varmint	15850	Extractor, 222-223 Rem., 17 Rem.
33380	Stock Assembly, 7mm Rem, Mag., ADL Grade	27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.
33365	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade	27342	Extractor Rivet, 222-223 Rem., 17 Rem.
33385	Stock Assembly, 7mm Rem. Mag., 264 & 300 Win. Mag.,		
	BDL Grade	1	

Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

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# **MALFUNCTIONS**

## **CAUSE and CORRECTION**

## (Con't. from Page 4)

## Doesn't Group

Cause:

- Crown of Barrel damaged.
   Leading of Bore.
- 3. Oversize Bore.
- Improper bedding of Barrel in Stock.
   Loose Sights.

Correction: 1. Recrown.

- 2. Lead or change Barrel.
- Change Barrel.
   Correct bedding.
   Tighten or replace.

Point of Impact Not Correct

- 1. Barrel not straight.
  - Horns, breaks, etc. in Bore.
     Improper or loose Sights.
- Correction:

Cause:

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- Straighten.
   Correct if possible.
   Tighten or change Sights.

Rev. 382

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## MUDEL 700 LEFT HAND MODEL

# REMINGTON FIELD SERVICE MANUAL

liew No.	Part No.	NAME OF PART		View No.	Part No.	NAME OF PART		
NOT	E:	Basic 30-06 caliber listed below. Fo		46	17043	Safety Switch Pivot Pin	(Restricted)	
		and numbers, see additional caliber	: list.	47	17044	Safety Switch Snap Washer	(Restricted)	
				48	15666	Sear Safety Cam	(Restricted)	
1		Barrel Assembly		49	24476	Sear Pin	(Restricted)	
2		Bolt Assembly		50	17047	Sear Spring	(Restricted)	
		Boit Final Assembly		51	30855	Sling Strap Assembly		
3	17012	Bolt Plug			26990	Sling Strap Assembly and Mountings	Complete	
4	17013	Bolt Stop	(Restricted)	52		Stock Assembly		
5	24475	Bolt Stop Pin	(Restricted)	1	18186	Stock Reinforcing Screw		
6	90555	Bolt Stop Release	(Restricted)	1	16970	Stock Reinforcing Screw Dowel		
7	90554	Bolt Stop Spring	(Restricted)	53	26555	Swivel Assembly (Q.D.)		
8	90953	Butt Plate		54	15280	Trigger	(Restricted)	
	90954	Butt Plate Spacer		55	17053	Trigger Adjusting Screw	(Restricted)	
	25380	Butt Plate Screw		1 33	32895	Trigger Assembly	(Restricted)	
-	17017	Ejector	,	66			(Restricted)	•
	17676	Ejector Pin	•	1	19461	Trigger Connector		
	17019	Ejector Spring		57	91128	Trigger Engagement Screw	(Restricted)	
	91816	Extractor		58	26376	Trigger Guard		
	27340	Extractor Rivet			26371	Trigger Guard Assembly	(Den. 1-1-1)	
	27340 15376	Fastener, Sling Strap		59	32905	Trigger Housing Assembly	(Restricted)	
		-		60	24477	Trigger Pin	(Restricted)	
	22020	Firing Pin		61	15400	Trigger Spring	(Restricted)	
	22040	Firing Pin Assembly		62	15481	Trigger Stop Screw	(Restricted)	
	17022	Firing Pin Cross Pin						
-	15291	Floor Plate Latch						
	16451	Floor Plate Latch Pin		1	•	ADDITIONAL CALIBERS		
	16452	Floor Plate Latch Spring						
	16453	Floor Plate Pivot Pin				NOTE: Parts not listed, same as 30-0	6 Caliber.	
	22035	Front Guard Screw		1				
	15373	Front Sight				Barrel Assembly, 7mm Rem. Mag.		
	15719	Front Sight (Low)				Barrel Assembly, 270 Win.		
25	15635	Front Sight Ramp		1		Bolt Assembly, 7mm Rem. Mag.		
26	28505	Front Sight Ramp Screw		1	91837	Extractor, 7mm Rem. Mag.		
27	15363	Front Sight Hood			27341	Extractor Rivet, 7mm Rem. Mag.		
28	15357	Front Swivel Nut			14659	Front Sight, 7mm Rem. Mag.		
29	15358	Front Swivel Screw			90949	Recoil Pad, 7mm Rem. Mag.		
	90957	Grip Cap			25410	Recoil Pad Screw, 7mm Rem. Mag.		
	90958	Grip Cap Spacer			33395	Stock Assembly, 7mm Rem. Mag.		
	25380	Grip Cap Spacer Screw						
30	16430	Magazine		1				
31	91017	Magazine Follower						
32	15677	Magazine Spring						
	17029	Main Spring		1				
	26355	Rear Guard Screw		1				
	32510	Rear Sight Aperture		1				
	91595	Rear Sight Base						
	28505	Rear Sight Screw		1				
	90905	Rear Sight Slide		1				
	90906	Elevation Screw						
	90904	Windage Screw		{				
	15358	Rear Swivel Screw						
	17034	Receiver Plug Screw						
	32900	Safety Switch Assembly	(Restricted)	1				
	23222	Safety Switch Detent Ball	(Restricted)	1				
	90557			-				
/Q	90337	Safety Switch Detent Spring	(Restricted)	1				

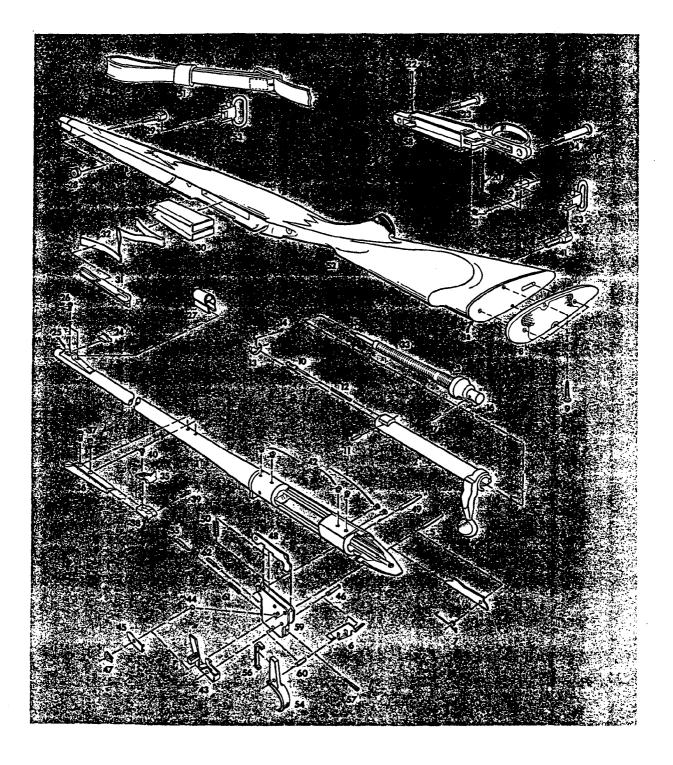
EXPLODED VIEW

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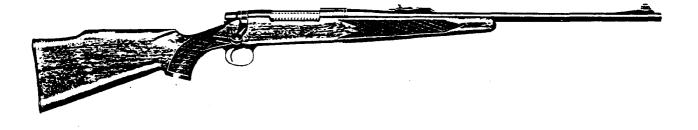
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# REMINGTON FIELD SERVICE MANUAL



## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied — ADL (standard) and BDL. Included in the BDL grade is the model 700 VARMINT — an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The instruction folder RD-5461 is packaged with each new rifle. Folders may also be obtained from the retailer or dealer. This folder outlines operating instructions, instructions for care and maintenance of the rifle and a complete parts list.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber.

Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Bolt Final Assembly, Components	1
Firing Pin Assembly	
Firing Pin Assembly, Components	1
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Rear Sight Step	2
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Front Sight	2
Front Sight Ramp	2
Trigger Guard (ADL Grade)	2
Trigger Guard Assembly (BDL Grade)	2
Trigger Guard Assembly, Components	2
Magazine	
Magazine Follower	
Magazine Spring	

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Bolt Stop	2
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Safety Assembly	
	3
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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division llion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

## BOLT FINAL ASSEMBLY

**To Disassemble** — With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

**To Service** — Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY — COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

## EJECTOR — EJECTOR PIN — EJECTOR SPRING (in bolt assembly)

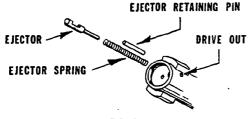


FIG. 1

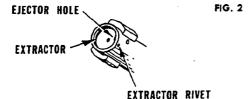
To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. See Fig. 1.

To Reassemble — Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

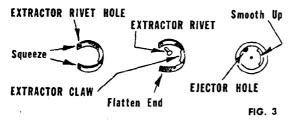
Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR --- EXTRACTOR RIVET (in bolt assembly)

To Disassemble—Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.



To Service — Parts are interchangeable. Extractor rivet will' most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble—Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. See Fig. 3. Straighten tail of extractor. See Fig. 3. Place extractor inside rim in bolt face. Align hole in ( extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

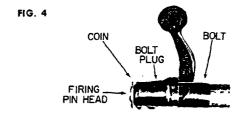
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

Aften tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

## FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

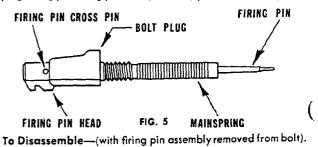
To Disassemble — Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted ( into slot near back edge of firing pin head. See Fig. 4. Unscrew and remove firing pin assembly from bolt assembly.



**To Service** — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble --- Follow reverse order.

FIRING PIN ASSEMBLY — COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



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Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. See Fig. 5. Release parts carefully and disassemble.

**To Service** – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

**To Reassemble** — Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (includes rear sight collar, rear sight eyepiece, rear sight leaf, rear sight windage screw).

**To Disassemble** — Unscrew and remove rear sight screw. Remove rear sight assembly from rear sight base.

To Service — Interchangeable with no factory adjustment required. Replacement as a unit is recommended.

To Reassemble — Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

### **REAR SIGHT STEP**

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To Disassemble—Grasp and lift rear sight eyepiece and slide rear sight step rearward.

To Service — Interchangeable. Additional steps, marked for size, are available for range purposes.

To Reassemble — Follow reverse order. Large end of step should face forward.

### **REAR SIGHT BASE**

To Disassemble — Remove rear sight assembly and rear sight step. Unscrew and remove rear sight base screws, washer and base.

To Reassemble — Follow reverse order.

FRONT SIGHT HOOD (BDL Grade only)

**To Disassemble** — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base.

To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble — Follow reverse order.

### FRONT SIGHT

To Disassemble — Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble — Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble — Follow reverse order.

### TRIGGER GUARD (ADL Grade)

To Disassemble — Unscrew and remove trigger guard screws and disassemble trigger guard from stock.

To Reassemble — Follow reverse order.

### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble—Remove bolt assembly. Unscrew and remove

front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly.

Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble — Follow reverse order. Tighten screws firmly.

**TRIGGER GUARD ASSEMBLY**—**COMPONENTS** (BDL Grade) includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

**To Disassemble** — Drive out floor plate pivot pin and remove floor plate from trigger guard.

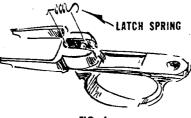
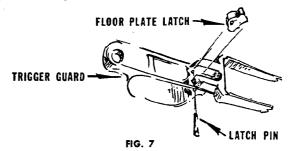


FIG. 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard. See Fig. 6.



Drive out floor plate latch pin — left to right and remove floor plate latch from trigger guard. See Fig. 7.

To Reassemble — Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE — MAGAZINE FOLLOWER — MAGAZINE SPRING

To Disassemble — Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble — Follow reverse order.

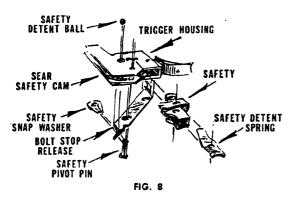
#### BOLT STOP - BOLT STOP SPRING - BOLT STOP PIN

**To Disassemble** — Remove bolt final assembly and stock assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

To Reassemble — Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place bolt stop in slot with contoured edge facing up and hole to rear. Align holes and drive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble — Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove



bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. See Fig. 8.

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

To Reassemble — Follow reverse order. Safety assembly and bolt stop should pivot freely.

### TRIGGER ASSEMBLY

**To Disassemble** — Remove bolt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety cam.

**To Service** — Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connector-sear engagement may be required.

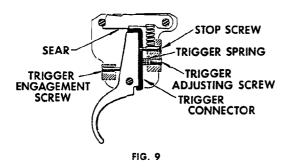
To Reassemble — Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: Includes bolt stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

**To Disassemble** — Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

**To Service** — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble — Place trigger connector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring



and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

### TRIGGER ADJUSTMENT. See Fig. 9.

Remove stock assembly and trigger guard.

IMPORTANT: Adjustment or removal of trigger engagement screw (behind trigger) is not recommended unless for replace-( ment. This screw is factory adjusted to provide correct amount of trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger—is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clockwise for heavier weight of pull and counter clockwise for lighter pull.

Travel of Trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

### STOCK ASSEMBLY

To Disassemble — Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble --- Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY — COMPONENTS (ADL Grade) includes butt plate, butt plate screw (2), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble — Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

**To Reassemble**—Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

**STOCK ASSEMBLY** — **COMPONENTS** (BDL Grade) includes ADL grade components plus butt plate spacer, fore end tip, fore end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble — See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble — Follow reverse order.

BARREL ASSEMBLY—includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE:

Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q. D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7/8" wide. Swivel assemblies are (Q. D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

FGH - RES. 569

# **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action —completing the cycle. Each operation is described in sequence below:

### FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is commed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

### **EXTRACTION**

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately  $\gamma_8$ " with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

#### **EJECTION**

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

### SAFETY

The safety, located at right rear of receiver, is operated by a push and pull action on the safety button. This two-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

# MALFUNCTIONS

### **Cause and Correction**

### Over-Ride

Cause:	1.	Magazine Follower binds	i.
	2.	Damaged Follower Sprin	a.

- Magazine Spring caught under Guard.
- 4. Tabs on Follower bent.
- Correction: 1. Adjust side angle on Magazine Box. 2. Change Spring.
  - 3. Correct.
  - 4. Straighten or replace Follower.

### **Stems Chamber**

Cause:	1.	Sharp or rough Receiver Rails.
	2.	Sharp edge - rear end of Chamber
	3.	Rough Ramp in Receiver.
	4.	Magazine Box loose in Receiver.
		•

- Correction: 1. Polish or file.
  - Remove sharpness.
  - Polish Ramp.
  - 4. Adjust.

#### **Bolt Closes Hard Over Shells**

- Cause: 1. Bolt interferes with shell rim.
  - 2. Extractor interferes with shell rim.
    - 3. Ejector binds or fails to retract far enough.
  - 4. Burr at Ejector Hole on Bolt.
  - 5. Sharp corners on Bolt Lugs.
  - 6. Extractor Rivet loose.
- Correction: 1. Remove interference or change Bolt.
  - Fit new Extractor (grind relief in new Extractor behind Claw).
    - 3. Free up or replace.
    - 4. Deburr.
    - 5. File radius.
    - 6. Tighten or replace Rivet.

### **Fails to Extract**

Cause:

- Tight, rough or oversize Chamber.
  - 2. Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
- 4. Height of Claw not correct.
  - 5. Extractor stuck back.

Correction: 1. Ream if tight or rough.

Change Barrel Assembly if oversize.

- 2. Fit new Extractor.
- 3. Fit new Extractor.
- 4. Fit new Extractor.
- 5. Replace Extractor.

(Continued on page 8)

PARTS LIST

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		NAME OF PART	No.	Part No.	NAME OF PART	
NOTE:	Basic 30	-06 Caliber listed below, See Sectional View for proper		15752	Magazine Follower, BDL Grade	
	identity	of parts. See added page for other caliber part listings.		15940	Magazine Tab Screw (ADL Grade)	
1		Barrel Assembly	34	17028	Magazine Spring	
2		Bolt Assembly		15677	Magazine Spring, BDL Grade	
[		Bolt Final Assembly	35	17029	Main Spring	
3	17012	Bolt Plug	36	26355	Rear Guard Screw	
4	17013	Bolt Stop	37	32510	Rear Sight Aperture	
5	24475	Bolt Stop Pin	38	32500	Rear Sight Base	
6	15478	Bolt Stop Release	39	28505	Rear Sight Base Screw (2)	
7	15224	Bolt Stop Spring	40	90905	Rear Sight Slide	
8	14472	Butt Plate	41	90906	Elevation Screw	
9	25410	Butt Plate Screw	42	90904	Windage Screw	
10	15287	Center Guard Screw, ADL Grade	43	15358	Rear Swivel Screw, BDL Grade	
11	17017	Ejector	44	17034	Receiver Plug Screw	
12	17676	Ejector Pin	45	26585	Safety Assembly	
13	17019	Ejector Spring	46	23222	Safety Detent Bali	
14	14669	Extractor	47	15368	Safety Detent Spring	
15	27340	Extractor Rivet	48	17043	Safety Pivot Pin	
	15376	Fastener, Sling Strap	49	17044	Safety Snap Washer	
16	22020	Firing Pin	50	15666	Sear Safety Cam	
17 <sup>·</sup>	22040	Firing Pin Assembly	51	24476	Sear Pin	
18	17022	Firing Pin Cross Pin	52 ·	17047	Sear Spring	
19	19800	Floor Plate, BDL Grade	53	30855	Sling Strap Assembly, BDL Grade	
20	15291	Floor Plate Latch, BDL Grade		26990	Sling Strap Assembly and Mountings Complete	
21	16451	Floor Plate Latch Pin, BDL Grade	54	26381	Stock Assembly, ADL Grade	
22	16452	Floor Plate Latch Spring, BDL Grade		26401	Stock Assembly, BDL Grade	
23	16453	Floor Plate Pivot Pin, BDL Grade		18186	Stock Reinforcing Screw (not shown)	
24	22035	Front Guard Screw		16970	Stock Reinforcing Screw Dowel (not shown)	
25	15161	Front Guard Screw Bushing, ADL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)	
26	15373	Front Sight	56	15280	Trigger	
-	15719	Front Sight (Low)	57	17053	Trigger Adjusting Screw	
27	28510	Front Sight Ramp		26345	Trigger Assembly	
-	15635	Front Sight Ramp, BDL Grade	58	19461	Trigger Connector	
28	28505	Front Sight Ramp Screw	59	17053	Trigger Engagement Screw	
29	15363	Front Sight Hood, BDL Grade	60	15281	Trigger Guard	
30	15357	Front Swivel Nut, BDL Grade	61	26376	Trigger Guard, BDL Grade	
31	15356	Front Swivel Screw, BDL Grade		26371	Trigger Guard Assembly, BDL Grade	
	15331	Grip Cap, BDL Grade (not shown)	62	26655	Trigger Housing Assembly	
	30505	Grip Cap Spacer, BDL Grade (not shown)	63	24477	Trigger Pin	
32	15284	Magazine, ADL Grade	64	15400	Trigger Spring	
	16430	Magazine, BDL Grade (not shown)	65	15481	Trigger Stop Screw	
33	17024	Magazine Follower				

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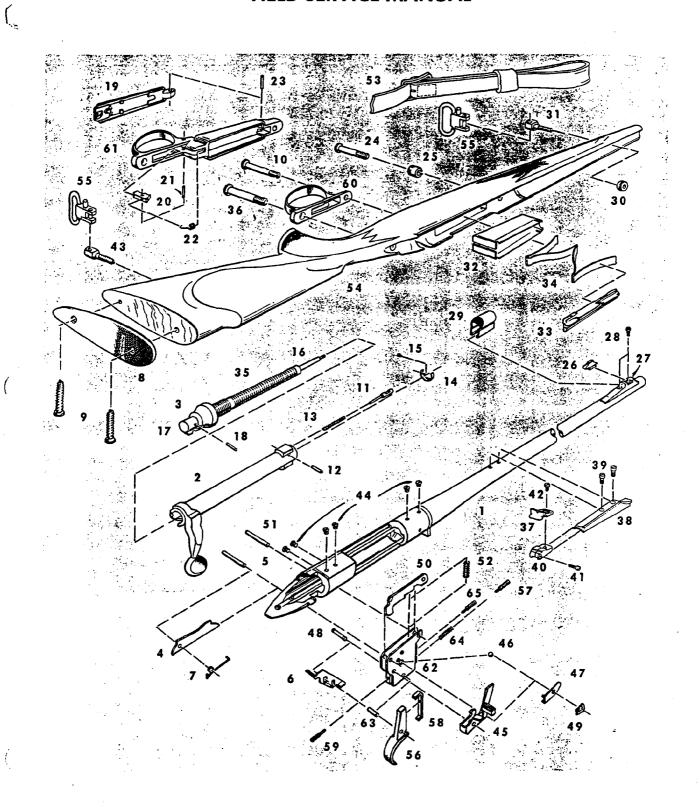
Parts Subject to Change Without Notice

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SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



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### ADDITIONAL CALIBERS (Not Shown in Sectional View)

### **INCLUDES VARMINT MODEL**

# REMINGTON FIELD SERVICE MANUAL

MODEL 700

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Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

Part No.	NAME OF PART	Part No.	NAME OF PART
15709	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
15850	Extractor, 222-223 Rem., 17 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem.,
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.		243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
27342	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem.,
22021	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem.		17 Rem.,223 Rem.,243 Win.,308 Win.,6mm
	Mag., 22-250 Rem., 223 Rem., 17 Rem.		Rem., 22-250 Rem.
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win.,		CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
	308 Win.,6mm Rem.,22-250 Rem.223 Rem.	27265	Barrel Assembly, 375 H&H Mag.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem.	27266	Barrel Assembly, 458 Win. Mag.
	243 & 308 Win., 6mm Rem., 22-250 Rem.,	15709	Extractor
	17 Rem.	16771	Front Sight, 375 H&H Mag.
22037	Front Guard Screw, 222 Rem., 223 Rem., 243 &	23805	Front Sight, 458 Win. Mag.
	308 Win.,6mm Rem.,22-250 Rem.,17 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as
16204 14659	Front Scope Base, Varmint Front Sight, 7mm Rem. Mag., 264 Win. Mag.		standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used
28511	Front Sight Ramp, ADL Grade		DISCONTINUED or SERVICE PARTS
15992	Front Sight Ramp, BDL Grade	26270	Barrel Assembly, 280 Rem.
15282	Magazine, ADL Grade, 222 Rem.	20467	Extractor, 222 Cal.
16716	Magazine, BDL Grade, 222 Rem., 223 Rem.,	17639	Ejector, 222 Cal.
15283	17 Rem. Magazine, ADL Grade, 243 & 308 Win., 6mm	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
16715	Rem. 22-250 Rem. Magazine, BDL Grade, 243 & 308 Win., 6mm	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
10715	Rem. 22-250 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
14756	Magazine, BDL Grade	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag.,
91018	Magazine Follower, 222 Rem.	1	222 Rem., 222 Rem. Mag., 243 Win.
90982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag. 222 Rem., 222 Rem. Mag., 243 Win.
15285	Magazine Spacer, 222 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Rear Sight Rear Server (2) Rear Sight Server Rear
16826	Magazine Spacer, 222 Rem., BDL Grade	1	Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rea Sight Step, Rear Sight Washer (2)
15286	Magazine Spacer,223 Rem., BDL Grade, 17 Rem.	\$	
17983	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		
15698	Magazine Spring, 22-250 Rem.	1	
15699	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade		
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win., 17 Rem.		
18843	Rear Scope Base, Varmint		
90949	Recoil Pad, 7mm Rem.Mag.264 & 300 Win.Mag.	1	
25410	Recoil Pad Screw,7mm Rem.Mag.,264 & 300		
8842	Win. Mag. Scope Base Screw, Rear Varmint		
16205	Scope Base Screw, Front Varmint	1	
33380	Stock Assembly, 7mm Rem. Mag., ADL Grade		
33365	Stock Assembly, 222 Rem., 243 Win., 308 Win.,		
33385	6mm Rem., 22-250 Rem., ADL Grade Stock Assembly,7mm Rem.Mag.,264-300 Win.		
33370	Mag., BDL Grade	Į	
	Stock Assembly,222 Rem.,243 Win.,308 Win. 6mm Rem.,22-250 Rem.,BDL Grade,17 Rem.		
33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.		

Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

# MALFUNCTIONS

# **CAUSE and CORRECTION**

# (Con't. from Page 4)

### **Fails to Eject**

Cause:

- Burr at Ejector Hole in Bolt.
   Ejector binds or fails to retract far enough.
- 3. Extractor Rivet loose.
- 4. Extractor drops shell.

#### Correction: 1. Deburr.

- 2. Free up or replace.
- 3. Re-stake or replace.
- 4. Replace Extractor.

# Misfires Cause:

- Short Firing Pin (damaged).
  - 2. Firing Pin binds.
  - 3. Short Firing Pin protrusion.
  - 4. Firing Control out of adjustment.
  - 5. Faulty ammunition.
- Correction: 1. Replace.
  - 2. Free up or replace.
  - 3. Change Firing Pin or Bolt.
  - 4. Adjust.

### **Follows Down**

Cause:

 Trigger Adjusting Screw, rear, out of adjustment (improper horizontal engagement of Sear and Connector).

- 2. Improper vertical engagement of Sear and Connector.
- 3. Trigger doesn't retract.
- 4. Corners on Sear or Connector rounded.
- 5. Trigger binds on Trigger Plate.
- 6. Not enough tension on Weight Screw (light pull).

### Correction: 1. Adjust.

- 2. Fit new Fire Control.
- 3. Fit new Fire Control.
- 4. Fit new Fire Control.
- 5. File eliminate interference.
- 6. Adjust.

### **Bolt Opens Hard**

- 1. See Fails to Extract.
- 2. Upset Extraction Cam on Bolt Handle.
- 3. Burr at Ejector Hole in Bolt.
- 4. Blown or set back Primer on shell.

### Correction: 1. See Fails to Extract.

Cause:

2. Smooth up.

3. Deburr.

4. Ream Chamber if throat is shallow (ammunition may be at fault).

### **Boit Pulls Out**

- Cause: 1. Bolt Stop or Bolt Release binds.
  - 2. Bolt Stop or Bolt Release broken.
- Correction: 1. Free up.
  - 2. Replace.

### Safe Works Too Hard or Too Freely

- Cause: 1. Safe binds (works hard).
  - Safety Snap Washer stretched out (Safe works too freely).
- Correction: 1. Free up.
  - 2. Replace Washer.

### **Bulges or Blows Cases**

- Cause: 1. Oversize Chamber.
  - Maximum head space.
- Correction: 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

### **Bolt Binds**

- Cause: 1. Guard Screws protrude into Bolt track.
  - Scope Screws protrude into Bolt track.
  - 3. Bolt Handle interference on Stock.
  - 4. Step at rear of Bolt Lugs.
- Correction: 1. File ends of Screws.
  - 2. File ends of Screws.
    - 3. Correct Stock or fit new Stock.
    - 4. File to blend.

### **Doesn't Group**

- Cause: 1. Crown of Barrel damaged.
  - Leading of Bore.
    - 3. Oversize Bore.
    - 4. Improper bedding of Barrel in Stock.
  - 5. Loose Sights.

### Correction: 1. Recrown.

- Lead or change Barrel.
  - 3. Change Barrel.
  - 4. Correct bedding.
  - 5. Tighten or replace.

### Point of Impact Not Correct

Cause: 1. Barrel not straight.

Horns, breaks, etc. in Bore.
 Improper or loose Sights.

Correction: 1. Straighten,

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- 2. Correct if possible.
  - 3. Tighten or change Sights.

# PARTS LIST

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# MODEL 700 LEFT HAND MODEL

# REMINGTON FIELD SERVICE MANUAL

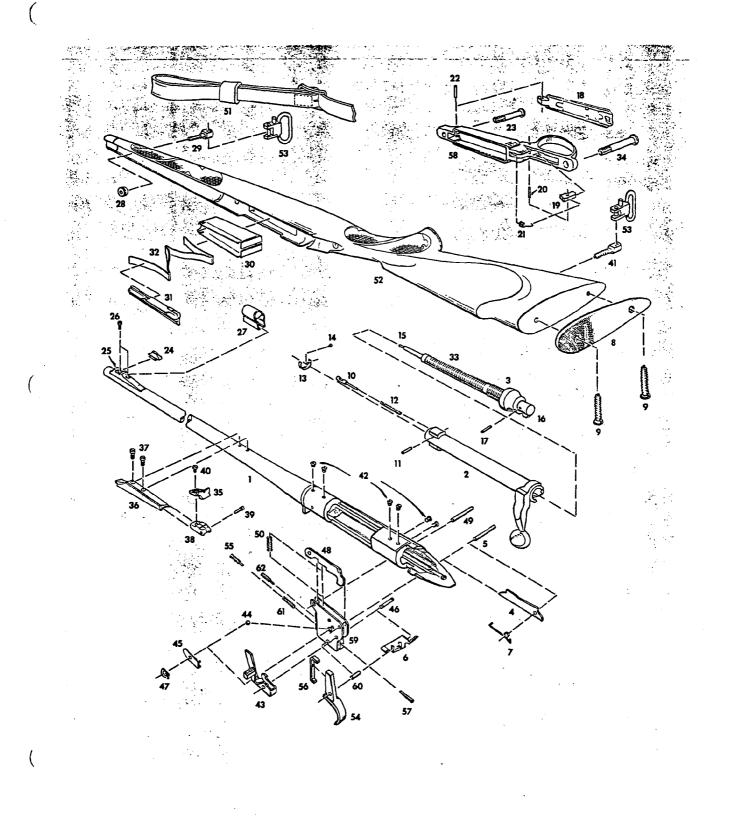
No.	Part No.	NAME OF PART	View No.	Part No.		
NOTE	: Basic	: 30-06 caliber listed below. For other caliber parts	51	30855	Sling Strap Assembly	
	and r	numbers see additional calibers list.		26990	Sling Strap Assembly and Mountings Complete	
			52	32890	Stock Assembly	
1		Barrel Assembly		18186	Stock Reinforcing Screw	
2		Bolt Assembly		16970	Stock Reinforcing Screw Dowel	
		Bolt Final Assembly	53	26555	Swivel Assembly (Q. D.)	
3	17012	Bolt Plug	54	15280	Trigger	
4	17013	Bolt Stop	55	17053	Trigger Adjusting Screw	
5	24475	Bolt Stop Pin		32895	Trigger Assembly	
6	90555	Bolt Stop Release	56	19461	Trigger Connector	
7	90554	Bolt Stop Spring	57	17053	Trigger Engagement Screw	
8	14472	Butt Plate	58	26376	Trigger Guard	
9	25410	Butt Plate Screw	1.0	26371	Trigger Guard Assembly	
10	17017	Ejector	59	32905	Trigger Housing Assembly	
11	17676	Ejector Pin	60	24477.	Trigger Pin	•
12	17019	Ejector Spring	61	15400	Trigger Spring	
			62	15481	Trigger Stop Screw	
13 14	14669	Extractor Rivet	02	10401	Ingger Stoh Sciem-	
14	27340					
46	15376	Fastener, Sling Strap				
15	22020				ADDITIONAL CALIBERS	
16	22040	Firing Pin Assembly			NOTE: Part not listed same as 30-06 Caliber	
17	17022	Firing Pin Cross Pin	1			
18	19800	Floor Plate			Barrel Assembly, 7mm Rem. Mag	
19	15291	Floor Plate Latch			Barrel Assembly, 270 Win.	
20	16451	Floor Plate Latch Pin		32862	Bolt Assembly, 7mm Rem. Mag	
	16452	Floor Plate Latch Spring		15709	Extractor, 7mm Rem. Mag	
	16453	Floor Plate Pivot Pin	· ·	27341	Extractor Rivet, 7mm Rem. Mag	(
	22035	Front Guard Screw		14659	Front Sight, 7mm Rem. Mag	
24	15373	Front Sight		21387	Recoil Pad, 7mm Rem. Mag	
	157 19	Front Sight (Low)		25410	Recoil Pad Screw, 7mm Rem. Mag	
25	15635	Front Sight Ramp		32880	Stock Assembly, 7mm Rem. Mag.	
26	28505	Front Sight Ramp Screw		02000	otock Assembly, Anith Helli, Mag.	
27	15363	Front Sight Hood				
28	15357	Front Swivel Nut				
29	15356	Front Swivel Screw	1			
	15331	Grip Cap				
	30505	Grip Cap Spacer				
30	16430	Magazine				
31	15752	Magazine Follower				
	15677	Magazine Spring				
	17029	Main Spring				
	25355	Rear Guard Screw				
	32510	Rear Sight Aperture				
	32500	Rear Sight Base				
	28505	Rear Sight Screw				
	20505	Rear Sight Slide				
	90906	Elevation Screw				
	90904	Windage Screw				
	15358	Rear Swivel Screw				
	17034	Receiver Plug Screw				
	32900	Safety Assembly				
	23222	Safety Detent Ball				
	90557	Safety Detent Spring				
	17043	Safety Pivot Pin				
17	17044	Safety Snap Washer				
	15666	Sear Safety Cam				
9	24476	Sear Pin				,
	17047	Sear Spring				(
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EXPLODED VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700 LEFT HAND MODEL



MODEL 700 Introduction

# REMINGTON PIELD SERVICE MANUAL

The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725 or other bolt action repeating rifles. Therefore, the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.

The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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 MODEL 700

Sights (See 725 Manual)

B Barrel Assembly (See 725 Manual) 1

Stock Assembly (See 725 Manual)

**Trigger Guard Assembly** 

Magazine (also see 725 Manual)

**Bolt Final Assembly** 

Bolt Stop, Bolt Stop Pin, Bolt Stop Spring

Safety (See 721-722 Manual)

Trigger Assembly (See 721-722 Manual)

Page

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1 & 2

MODEL 700 Assembly Page 1

### TRIGGER GUARD (ADL GRADE)

To Disassemble - Unscrew and remove rear and center guard screws and remove trigger guard.

To Replace - Interchange with no factory adjustment required.

To Reassemble - Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

<u>Caution</u>: Before assembling stock to receiver, particularly on ADL Grade, locate magazine fully into magazine recess in bottom of receiver. This will prevent any damage to stock when stock is tightened against receiver.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

- <u>To Disassemble</u> Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)
  - <u>Caution:</u> Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

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# REMINGTON FIELD SERVICE MANUAL

# BOLT FINAL ASSEMBLY Continued

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Disassemble ejector and ejector spring from breach bolt. Drive extractor rivet from breach bolt - outside to inside. (See sketch below)

Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below).

Straighten tail of extractor. (See sketch above)

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# BOLT FINAL ASSEMBLY Continued

Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breach bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under boit rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Disassemble, if necessary, and rebend extractor as indicated in sketch above.

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breach bolt rim. (See sketch on preceding page)

<u>Note</u>: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

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### REMINGTON FIELD SERVICE MANUAL

### SIGHTS

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

<u>To Disassemble</u> ~ Spread cover slightly and push forward in cover slots on either side of the ramp.

To Replace - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

### FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
- To Replace Interchangeable no factory adjustment required.

To Reassemble - Follow reverse order.

- FRONT SIGHT RAMP (Screw on type, used on the following calibers only: 222, 222 Magnum, 243, 6mm, 7mm Magnum and 264 Magnum)
- <u>To Disassemble</u> Unscrew front sight ramp screw and pry ramp up off ramp pins.
- To Replace Interchangeable no factory adjustment required.
- <u>To Reassemble</u> Place ramp pins in holes on top of barrel, align pins with holes in bottom of ramp and tap ramp down on to barrel until seated. Screw in ramp screw.
- NOTE: Other calibers (308, 270, 280 and 30-06) have a brazed on front sight ramp which is not easily disassembled.

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### REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY & MOUNTINGS, COMPLETE - A sling strap complete with mountings is packaged with each BDL Grade fifle. When attaching to rifle --- assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Full strap to move rear keeper back in tight loop against rear swivel.

Slide front keeper band on free end of strap. Then insert strap thru front swivel and double strap back and thru attached front keeper. Insert brass fastemer thru matching slots to join strap in desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

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# REMINGTON FIELD SERVICE MANUAL

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(Reserve for Sectional View)

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Barrel Assembly (See 725 Manual)

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Magazine (also see 725 Manual)

**Bolt Final Assembly** 

Bolt Stop, Bolt Stop Pin, Bolt Stop Spring

Safety (See 721-722 Manual)

Trigger Assembly (See 721-722 Manual)

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MODEL 700 ASSEMBLY

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# REMINGTON FIELD SERVICE MANUAL

### TRIGGER GUARD (ADL GRADE)

- <u>To Disassemble</u> Unscrew and remove rear and center guard screws and remove trigger guard.
- To Replace Interchange with no factory adjustment required.
- To Reassemble Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate

(See Model 725 Manual)

MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

- <u>Caution</u>: Before assembling stock to receiver, particularly on ADL Grade, locate magazine fully into magazine recess in bottom of receiver. This will prevent any damage to stock when stock is tightened against receiver.
- <u>To Disassemble</u> Pry up extractor from inner rim, on face of bolt, and disassemble extractor and rivet from bolt.
- <u>To Replace</u> Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)

Straighten tail of extractor. (See sketch above)

MODEL 700

# REMINGTON FIELD SERVICE MANUAL

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The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725 or other bolt action repeating rifles. Therefore, the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.

The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

### MAGAZINE Continued

- <u>To Reassemble</u> Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.
  - <u>Note:</u> If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor unit must be supplied for reassembly.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

- <u>To Disassemble</u> Disassemble breech bolt from gun. Drive ejector retaining pin from breech bolt. (Seesketch below)
  - <u>Caution</u>: Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)

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BOLT FINAL ASSEMBLY Continued  $\mathbf{r}_{ij} \in \mathbf{r}_{j}$ 

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MODEL 700

ASSEMBLY

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

To Reassemble - Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Or disassemble, if necessary, and rebend extractor as indicated in sketch above.

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch above)

Note: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

### BOLT STOP (See sectional view on last page)

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To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align hole and tap in bolt stop pin.

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# REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied - ADL (standard) and 8DL. Included in the BDL grade is the Model 700 VARMINT - an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.

The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

#### BOLT FINAL ASSEMBLY

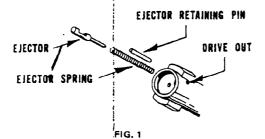
To Disassemble – With safety switch forward on FIRE position lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release – located in front of trigger and remove bolt final assembly from rifle.

To Service – Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety switch forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY – COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR - EJECTOR PIN - EJECTOR SPRING (in bolt assembly)

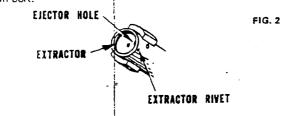


To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. (See Fig. 1).

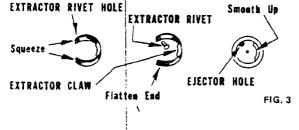
To Reassemble – Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR – EXTRACTOR RIVET (in bolt assembly) To Disassemble – Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.



To Service – Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble — Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See Fig. 3). Straighten tail of extractor. (See Fig. 3). Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

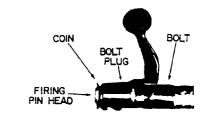
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. (See Fig. 4). Unscrew and remove firing pin assembly from bolt assembly.



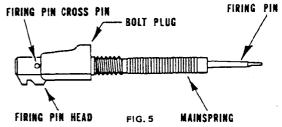
To Service — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

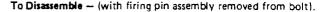
To Reassemble - Follow reverse order.

FIG. 4

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FIRING PIN ASSEMBLY - COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.





Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble – Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

REAR SIGHT ASSEMBLY (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

#### FRONT SIGHT HOOD (BDL Grade only)

To Disassemble — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### FRONT SIGHT

To Disassemble – Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble - Follow neverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

### TRIGGER GUARD (ADL Grade)

To Disassemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow severse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble -- Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

TRIGGER GUARD ASSEMBLY – COMPONENTS (BDL Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. To Disassemble – Drive out floor plate pivot pin and remove floor plate from trigger guard.

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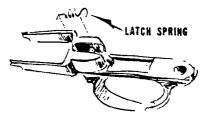
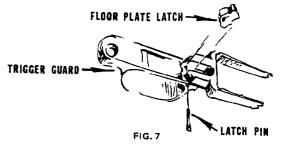


FIG. 6

Caution: Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin - left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble – Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble – Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

### STOCK ASSEMBLY

To Disassemble— Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble— Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY – COMPONENTS (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble – Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement, if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble. Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

STOCK ASSEMBLY – COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore-end tip, fore-end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble— See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble- Follow reverse order.

BARREL ASSEMBLY – Includes barrel, barrel brackets, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE: Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q.D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7/8" wide. Swivel assemblies are (Q.D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle – assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust trap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

# CYCLE OF OPERATION

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action — completing the cycle. Each operation is described in sequence below: 1

#### FIRING

With action closed and locked and safety switch in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cockee firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver,  $t_{r}^{-1}$ 

#### COCKING

Cocking takes place as bolt handle is raised. A carn at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

### EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped

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by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8'' with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear — completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

### SAFETY SWITCH

The safety switch, located at right rear of receiver is operated by a push and pull action on the safety switch button. This two-position safety switch has two internal functions. When safety switch is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety switch in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety switch forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

# MALFUNCTIONS

### **Cause and Correction**

Over-Ride

- Cause: 1. Magazine Follower binds.
  - 2. Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.

Correction: 1. Adjust side angle on Magazine Box.

- Change Spring.
   Correct.
- 4. Straighten or replace Follower.

### Stems Chamber

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Stems Char	πb	Hr i		Follows Do	wn	1 
Cause:	2. 3.	Sharp or rough Receiver i Sharp edge- rear end of C Rough Ramp in Receiver Magazine Box loose in Re	Chamber.	Cause:	2. 3.	Trigger out of adjustment. Improper vertical engagement of Sear and Connector. Trigger doesn't retract. Corners on Sear or Connector rounded.
Correction:	2. 3.	Polish or file. Remove sharpness. Polish Ramp. Adjust.			5. 6.	Trigger binds on Trigger Guard. Not enough tension on Weight Screw (light pull).
Bolt Closes	Ha	rd Over Shells		Correction:	2.	Return the firearm to the factory. Return the firearm to the factory. Return the firearm to the factory.
Cause:	2. 3.	Bolt interferes with shell Extractor interferes with Ejector binds or fails to re Burr at Ejector Hole on B	shell rim. etract far enough.		4. 5.	Return the firearm to the factory. File Trigger Guard - eliminate interference. Return the firearm to the factory.
		Sharp corners on Bolt Lu Extractor Rivet loose.	gs.	Boit Opens	Ha	ard .
Correction:	2. 3.	Remove interference or c Fit new Extractor (grind behind Claw). Free up or replace. Deburr.	hange Bolt. relief in new Extractor	Cause:	2. 3. 4.	See Fails to Extract. Upset Extraction Cam on Bolt Handle. Burr at Ejector Hole in Bolt. Blown or set back Primer on shell. See Fails to Extract.
Fails to Ext	6.	File radius. Tighten or replace Rivet.			2. 3.	Smooth up. Deburr. Ream Chamber if throat is shallow (am-
Cause:		Tight, rough or oversize C	`hamber		_	munition may be at fault).
Cause:	2.	Extractor broken or dama Not enough Hook space of	aged.	Bolt Pulls C		· · · · · · · · · · · · · · · · · · ·
	4.	Height of Claw not correct Extractor stuck back.	et.	Cause:		Bolt Stop or Bolt Release binds. Bolt Stop or Bolt Release broken.
Correction:		Ream if tight or rough. Change Barrel Assembly i Fit new Extractor.	f oversize.		2.	Return the firearm to the factory. Return the firearm to the factory.
	3.	Fit new Extractor. Fit new Extractor.		Safety Swit		Works Too Hard or Too Freely Safety switch binds (works hard).
Fails To Eje		Replace Extractor.				Safety switch Snap Washer stretched out (Safety Switch works too freely.)
Cause:	2.	Burr at Ejector Hole in Bo Ejector binds or fails to re Extractor Rivet loose.		Correction:		Return the firearm to the factory. Return the firearm to the factory.
		Extractor drops shell.		Bulges or B	llov	ws Cases
Correction:	2.	Deburr. Free up or replace. Re-stake or replace.		Cause:		Oversize Chamber. Maximum head space:
Misfires		Replace Extractor.		Correction		Change Barrel or Barrel and Receiver Assembly. Fit new Bolt (ammunition may be at fault).
Cause:	1.	Short Firing Pin (damage	d).	Bolt Binds		
	3. 4. 5.	Firing Pin binds. Short Firing Pin protrusic Firing Control out of adju Faulty ammunition.		Cause:	2. 3.	Guard Screws protrude into Bolt track. Scope Screws protrude into Bolt track. Bolt Handle interference on Stock. Step at rear of Bolt Lugs.
Correction:	2. 3. 4.	Replace. Free up or replace. Change Firing Pin or Bolt Return the firearm to the Replace ammunition.		Correction:	2. 3.	File ends of Screws. File ends of Screws. Correct Stock or fit new Stock. File to blend.
			4			

MODEL 700

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# REMINGTON FIELD SERVICE MANUAL

PARTS LIST

iew Ne	Part No.	NAME O	FPART	View Ne.	Part No.	NAME OF PART	
ют	: Basic 3	0-06 Caliber listed below	. See Sectional View for proper				
	identity	of parts. See added pag	e for other caliber part listings.	35	17029	Main Spring	
				36	26355	Rear Guard Screw	
1		Barrel Assembly		37	32510	Rear Sight Aperture	
2		Bolt Assembly		38	91595	Rear Sight Base	
		Bolt Final Assembly		39	28505	Rear Sight Base Screw (2)	
3	17012	Bolt Plug		40	90905	Rear Sight Slide	
4	17013	Bolt Stop	(Restricted)	41	90906	Elevation Screw	
5	24475	Boit Stop Pin	(Restricted)	42	90904 15358	Windage Screw	
6	15478	Bolt Stop Release	(Restricted)	43	17034	Rear Swivel Screw, BDL Grade Receiver Plug Screw	
7	15224	Bolt Stop Spring	(Restricted)	45	26585	Safety Switch Assembly	(Restricted)
8	90953	Butt Plate		46	23222	Safety Switch Detent Ball	(Restricted)
8a	90954	Butt Plate Spacer, BDL	-	47	15368	Safety Switch Datent Spring	(Restricted)
9	25380	Butt Plate Screw		48	17043	Safety Switch Plyot Pin	(Restricted)
0	15287	Center Guard Screw, A	DL Grade	49	17044	Safety Switch Snap Washer	(Restricted)
1	17017	Ejector		50	15666	Seer Safety Cam	(Restricted)
2	17676	Ejector Pin		51	24476	Sear Pin	(Restricted)
3	17019	Ejector Spring		52	17047	Sear Spring	(Restricted)
4	91816	Extractor		53	30855	Sling Strap Assembly, BDL Grade	
	15376	Fastener, Sling Strap			26990	Sling Strap Assembly and Mountings (	Complete
5	22020	Firing Pin		54	33366	Stock Assembly, ADL Grade	
7	22040	Firing Pin Assembly		1	33371	Stock Assembly, BDL Grade	
8	17022	Firing Pin Cross Pin		1	18186	Stock Reinforcing Screw (not shown)	
0	15291	Floor Plate Latch, BDI	L Grade		16970	Stock Reinforcing Screw Dowel (not :	
1	16451	Floor Plate Latch Pin,	BDL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)	
2	16452	Floor Plate Latch Sprin	ng, BDL Grade	56	15280	Trigger	(Restricted)
3	16463	Floor Plate Plvot Pln, I	BDL Grade	57	17053	Trigger Adjusting Screw	(Restricted)
4	22035	Front Guard Screw			26345	Trigger Assembly	(Restricted)
5	15161	Front Guard Screw Bu	shing, ADL Grade	58	19461	Trigger Connector	(Restricted)
6	15373	Front Sight		59	91128	Trigger Engagement Screw	(Restricted)
	15719	Front Sight (Low)		60	15281	Trigger Guard	(11000110100)
7	28510	Front Sight Ramp		61	26376	Trigger Guard, BDL Grade	
	15635	Front Sight Ramp, BI	DL Grade		26371	Trigger Guard Assembly, BDL Grade	
8	28505	Front Sight Ramp Scr	w	62	26655	Trigger Housing Assembly	(Restricted)
9	15363	Front Sight Hood, \$D	L Grade	63	24477	Trigger Pin	(Restricted)
0	15357	Front Swivel Nut, BDI	L Grade	64	15400	Trigger Spring	(Restricted)
1	15358	Front Swivel Screw B	DL Grade	65	15481	Trigger Stop Screw	(Restricted)
	90957	Grip Cap, BDL Grade	(not shown)				
	25380	Grip Cap Screw		ł			
	90958	Grip Cap Spacer, BDL	Grade (not shown)			•	
2	15284	Magazine, ADL Grade					
	16430	Magazine, BDL Grade	(not shown)				
3	90952	Magazine Follower					
	91017	Magazine Follower, Bl					
	15940	Magazine Tab Screw, /	ADL Grade				
4	17028	Magazine Spring					
	15677	Magazine Spring, BDL	Grade	ł			

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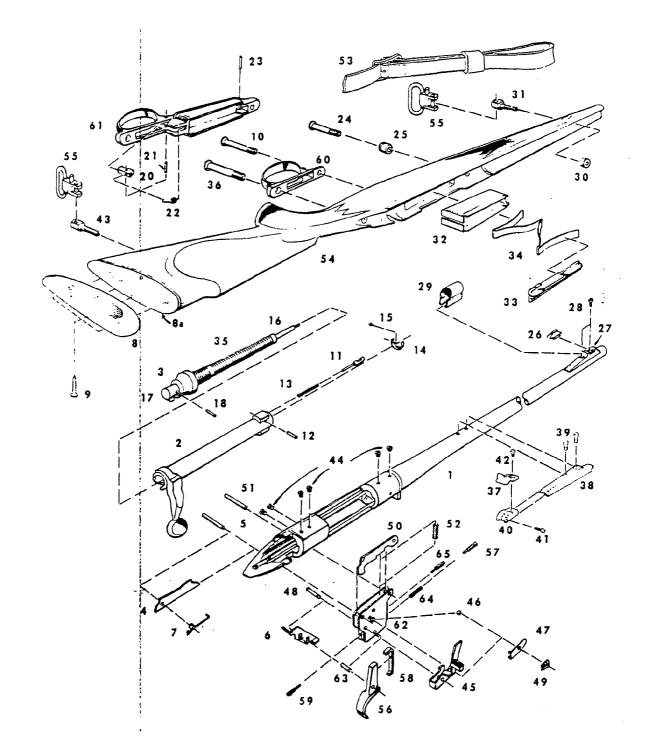
SECTIONAL VIEW

2014

# REMINGTON FIELD SERVICE MANUAL

MODEL 700

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# ADDITIONAL CALIBERS (Not Shown in Sectional View) CLUDES VARMINT MODEL

# REMINGTON FIELD SERVICE MANUAL

MODEL 700

### Note: Caliber part numbers not listed below same as 30-06

(222 Rem. Mag. discontinued)

). 	NAME OF PART	Part Ne.	NAME OF PART
		33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm
1837	Extractor, 7mm Rem., Mag., 264-300 Win, Mag.		Rem. 22-250 Rem., BDL Grade, 17 Rem.
1906	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223
2021	Firing Pln,222 Rem., 234-208 Win., 6mm Rem. Mag., 22-		Rem.,243 Win., 6mm Rem., 22-250 Rem.
	250 Rem., 223 Rem., 17 Rem.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
2041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 &
	Win., 6mm Rem., 22-250 Rem. 223 Rem.		308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
6434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.
	Win., 6mm Rem., 22-250 Rem., 17 Rem.		223 Rem., 243 Win., 6mm Rem., 22-250 Rem.
2037	Front Guard Screw, 222 Fem., 223 Rem., 243 & 308		
	Win., 6mm Rem., 22-250 ftem., 17 Rem.		CALIBERS: 375 H & H MAGNUM, 458 WIN. MAGNUM
6204	Front Scope Base, Varmint	27265	Barrel Assembly, 375 H & H Mag.
4659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	27266	Barrel Assembly, 458 Win. Mag.
8511	Front Sight Ramp, ADL Grade	15709	Extractor
5992	Front Sight Ramp, BDL Gade	16771	Front Sight, 375 H & H Mag.
5282	Magazine, ADL Grade, 222 Rem.	23805	Front Sight, 458 Win. Mag.
6716	Magazine, BDL Grade, 222 Rem., 223 Rem., 17 Rem.	27270	Stock Assembly, 375 H & H Mag., 458 Win. Mag. (in-
5283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem.		cludes same as standard Magnum except Stock Bolt (2)
	22-250 Rem.		Nut (2), Cover (4) used)
6715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem.		
	22-250 Rem.		DISCONTINUED or SERVICE PARTS
4756	Magazine, BDL Grade	26270	Barrel Assembly, 280 Rem.
0951	Magazine Follower, 222 Rem., 223 & 17 Rem.	20467	Extractor, 222 Cal.
0982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250	17639	Ejector, 222 Cal.
	Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag. 264
5742	Magazine Spacer, 222 Rem	10/1/	
5286	Magazine Spacer, 222 Remi, BDL Grade	ļ	Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL
528 <b>6</b>	Magazine Spacer, 223 Remi, BDL Grade, 17 Rem.	45264	Grade
1133	Magazine Spring, 222 Rem, 223 Rem., 17 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222
7891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		Rem., 222 Rem. Mag., 243 Win., BDL Grade
5698	Magazine Spring, 22-250 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win.
56 <b>99</b>	Magazine Spring, 22-250 Rem., 6mm Rem. 243 Win.,		ADL Grade
	BDL Grade	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264
7058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win.,		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
	17 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem.,
8843	Rear Scope Base, Varmint		264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
0949	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag.	28200	Rear Sight Assembly, Complete (Includes Rear Sight
5410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		Assembly, Rear Sight Base, Rear Sight Base Screw (2),
8842	Scope Base Screw, Rear Varmint		Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2)
6204	Scope Base Screw, Front Varmint	15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag.
3380	Stock Assembly, 7mm Reni, Mag., ADL Grade	15850	Extractor, 222-223 Rem., 17 Rem.
3365	Stock Assembly, 222 Rem 243 Win., 308 Win., 6mm	27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.
	Rem., 22-250 Rem., ADL Grade	27342	Extractor Rivet, 222-223 Rem., 17 Rem.
3385			
1993	Stock Assembly, 7mm Rent. Mag., 264 & 300 Win. Mag.,		
	BDL Grade	1	

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Parts Subject to Change Without Notice

# MALFUNCTIONS

# **CAUSE and CORRECTION**

# (Con't. from Page 4)

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### Doesn't Group

Cause:

- 1. Crown of Barrel damaged.
  - 2. Leading of Bore.
  - 3. Oversize Bore.
  - Improper bedding of Barrel in Stock.
     Loose Sights.
- Correction: 1. Recrown
  - Lead or change Barrel.
     Change Barrel.
     Correct bedding.
  - - 5. Tighten dr replace.

Point of Impact Not Correct

- Cause:
- 1. Barrel not straight. 2. Horns, breaks, etc. in Bore. 3. Improper or loose Sights.
- 1. Straighten. Correction:
  - 2. Correct if possible.
    - 3. Tighten or change Sights.

Rev. 382

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# REMINGTON FIELD SERVICE MANUAL

Ne.	NAME OF PAR	, 	Ne.	Ne.	NAME OF PAR	· · · · · · · · · · · · · · · · · · ·
DTE:	Basic 30-06 caliber listed below.		46	17043	Safety Switch Pivot Pin	(Restricted)
	and numbers, see additional calib	eers list.	47	17044	Safety Switch Snap Washer	(Restricted)
	)		48	15666	Sear Safety Cam	(Restricted)
	Barrel Assembly		49	24476	Sear Pin	(Restricted)
	Bolt Assembly		50	17047	Sear Spring	(Restricted)
	Bolt Final Assembly		51	30855	Sling Strap Assembly	
17012	Bolt Plug			26990	Sling Strap Astembly and Mounting	s Complete
17013	Bolt Stop	(Restricted)	52	33391	Stock Assembly	
24475	Bolt Stop Pin	(Restricted)		18186	Stock Reinforcing Screw	
90555	Boit Stop Release	(Restricted)		16970	Stock Reinforcing Screw Dowel	
90554	Bolt Stop Spring	(Restricted)	53	26555	Swivel Assembly (Q.D.)	
90953	Butt Plate		54	15280	Trigger	(Restricted)
a 90954	Butt Plate Spacer		55	17053	Trigger Adjusting Screw	(Restricted)
25380	Butt Plate Screw		{	32895	Trigger Assembly	(Restricted)
17017	Ejector		56	19461	Trigger Connector	(Restricted)
17676	Ejector Pin		57	91128	Trigger Engagement Screw	(Restricted)
17019	Ejector Spring		58	26376	Trigger Guard	
91816	Extractor			26371	Trigger Guard Assembly	
27340	Extractor Rivet		59	32905	Trigger Housing Assembly	(Restricted)
15376	Fastener, Sling Strap		60	24477	Trigger Pin	(Restricted)
22020	Firing Pln		61	15400	Trigger Spring	(Restricted)
22040	Firing Pin Assembly	·	62	15481	Trigger Stop Screw	(Restricted)
17022	Firing Pin Cross Pin			19401	Ingger otop ourew	(114)(16163)
15291	Floor Plate Latch		1			
16451	Floor Plate Latch Pin					
16451	Floor Plate Latch Spring				ADDITIONAL CALIBERS	5
16452	Floor Plate Pivot Pin					
	Front Guard Screw				NOTE: Parts not listed, same as 30	-06 Caliber.
22035						
15373	Front Sight				Barrel Assembly, 7mm Rem. Mag.	
15719	Front Sight (Low)				Barrel Assembly, 270 Win.	
15635	Front Sight Ramp				Bolt Assembly, 7mm Rem. Mag.	
28505	Front Sight Ramp Screw			91837	Extractor, 7mm Rem. Mag.	
15363	Front Sight Hood		ļ	27341	Extractor River, 7mm Rem. Mag.	
15357	Front Swivel Nut			14659	Front Sight, 7mm Rem. Mag.	
15358	Front Swivel Screw			90949	Recoil Pad, 7mm Rem. Mag.	
90957	Grip Cap		1	25410	Recoil Pad Screw, 7mm Rem, Mag.	
90958	Grip Cap Spacer			33395	Stock Assembly, 7mm Rem. Mag.	
25380	Grip Cap Spacer Screw		ł			
16430	Magazine		1			
91017	Magazine Follower					
15677	Magazine Spring		1			
17029	Main Spring					
26355	Rear Guard Screw		}			
32510	Rear Sight Aperture		ļ			
91595	Rear Sight Base		1			
28505	Rear Sight Screw		1			
90905	Rear Sight Slide	•	1			
90906	Elevation Screw					
90904	Windage Screw		1			
15358	Rear Swivel Screw		1			
17034	Receiver Plug Screw		1			
32900	Safety Switch Assembly	(Restricted)	1			
23222	Safety Switch Detent Ball	(Restricted)	l			
90557	Safety Switch Detent Spring	(Restricted)	1			
			1			

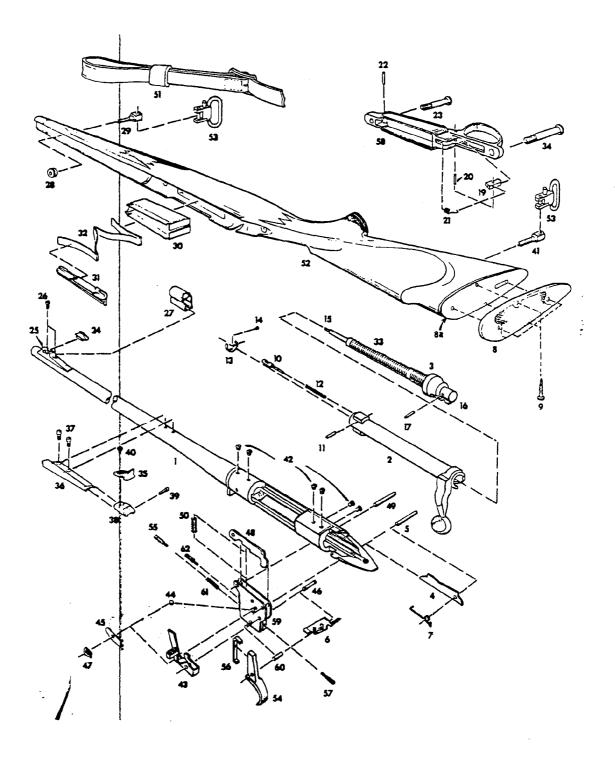
EXPLODED VIEW

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# REMINGTON FIELD SERVICE MANUAL

MODEI 700 LEFT HAND MODEI



# REMINGTON Model 700

The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725.

Therefore, the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.



The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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## REMINGTON FIELD SERVICE MANUAL

		Page
Trigger Guard (ADL Grade)	#15281	1
Center Guard Screw	#15287	1
Rear Guard Screw	#26355	1
Trigger Guard Assembly (BDL Grade) (See 725 Manual)	#26371	1
Magazine (ADL Grade)	#15284	1
Bolt Final Assembly (ADL Grade)	#26317	1,2&3
Bolt	#26327	1,2&3
Ejector	#17017	1,2&3
Ejector Pin	#17676	1,2&3
Ejector Spring	#17019	1,2&3
Extractor	#16254	1,2&3
Extractor Rivet	#27340	1,2&3
Bolt Stop	#17013	3
Bolt Stop Pin	#24475	3
Bolt Stop Spring	#15224	3
Sights		4
Rear Sight Assembly (See 725 Manual)		4
Front Sight	#15373	4
Front Sight Hood	#15363 1	4
Front Sight Ramp	#16717	4
Front Sight Ramp Pin (2)	#24477	4
Front Sight Ramp Screw	#19025	4

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Sling Strap Assembly & Mountings,	Complete #26990	5
. Sling Strap Assembly	#26625	5
Swivel Assembly (2)	#26555	5
Front Swivel Nut	#15357	5
Front Swivel Screw	#15356	5
Rear Swivel Screw	#15358	5
Sectional View		6

service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. **Bridgeport, Connecticut** 

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Send all guns for factory service and inquiries on

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MODEL 700 Assembly Page 1

### REMINGTON FIELD SERVICE MANUAL

### TRIGGER GUARD (ADL GRADE)

<u>To Disassemble</u> - Unscrew and remove rear and center guard screws and remove trigger guard.

To Replace - Interchange with no factory adjustment required.

To Reassemble - Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

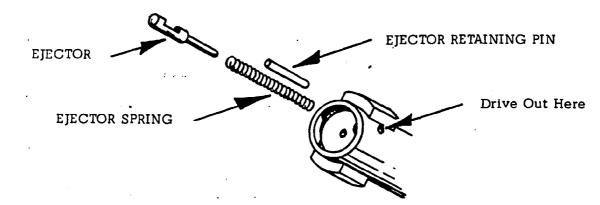
MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

<u>Caution</u>: Before assembling stock to receiver, particularly on ADL Grade, locate magazine fully into magazine recess in bottom of receiver. This will prevent any damage to stock when stock is tightened against receiver.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

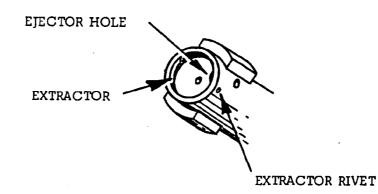
<u>To Disassemble</u> - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

<u>Caution:</u> Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.



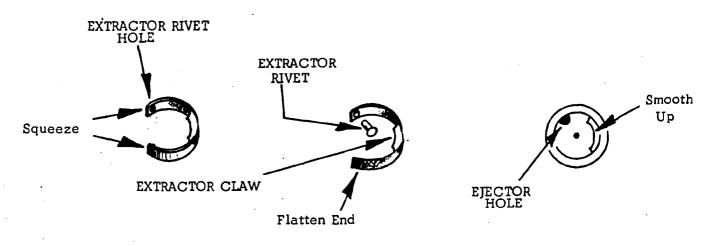
## BOLT FINAL ASSEMBLY Continued

Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)



Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)



Straighten tail of extractor. (See sketch above)

MODEL 700 Assembly Page 3

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### REMINGTON FIELD SERVICE MANUAL

### BOLT FINAL ASSEMBLY Continued

Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Disassemble, if necessary, and rebend extractor as indicated in sketch on preceding page

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch on preceding page)

<u>Note</u>: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

7D:FGH

#### SIGHTS

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REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

<u>To Disassemble</u> - Spread cover slightly and push forward in cover slots on either side of the ramp.

<u>To Replace</u> - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

## FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
- To Replace Interchangeable no factory adjustment required.

To Reassemble - Follow reverse order.

- FRONT SIGHT RAMP (Screw on type, used on the following calibers only: 222, 222 Magnum, 243, 6mm, 7mm Magnum and 264 Magnum)
- <u>To Disassemble</u> Unscrew front sight ramp screw and pry ramp up off ramp pins.

To Replace - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Place ramp pins in holes on top of barrel, align pins with holes in bottom of ramp and tap ramp down on to barrel until seated. Screw in ramp screw.

NOTE: Other calibers (308, 270, 280 and 30-06) have a brazed on front sight ramp which is not easily disassembled.

MODEL 700 Assembly Page 5

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## REMINGTON FIELD SERVICE MANUAL

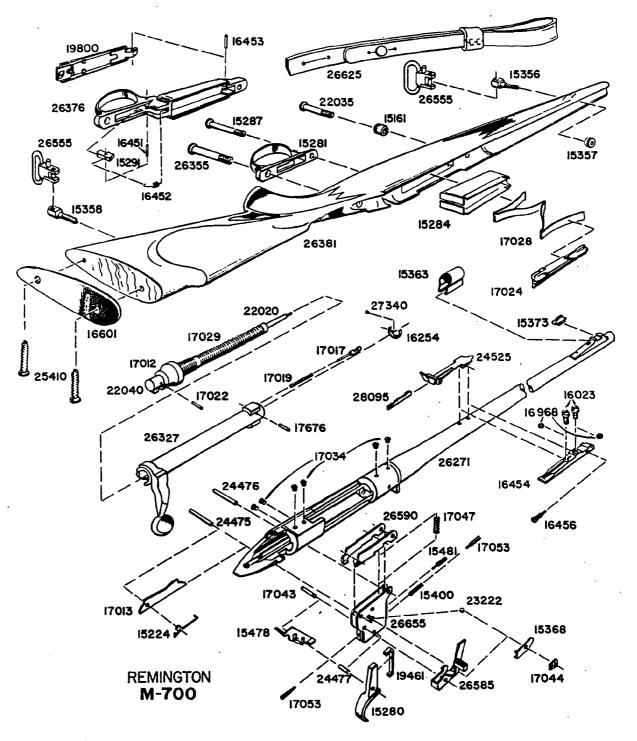
SLING STRAP ASSEMBLY & MOUNTINGS, COMPLETE - A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle --- assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

Slide front keeper band on free end of strap. Then insert strap thru front swivel and double strap back and thru attached front keeper. Insert brass fastener thru matching slots to join strap in desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

R&D:FGH 3-14-63



The Remington Madel 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied — ADL (standard) and BDL. Included in the BDL grade is the model 700 VARMINT — an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.

The instruction folder RD-5461 is packaged with each new rifle. Folders may also be obtained from the retailer or dealer. This folder outlines operating instructions, instructions for care and maintenance of the rifle and a complete parts list.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber.

Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

1969

#### BULL FINAL ASSEMBLE

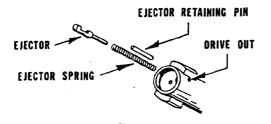
To Disassemble — With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

**To Service** — Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn balt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY — COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR — EJECTOR PIN — EJECTOR SPRING (in bolt assembly)





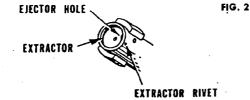
**To Disassemble** — With bolt final assembly removed fram rifle, drive out ejector pin and pull ejector spring from bolt. **See Fig. 1**.

To Reassemble — Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

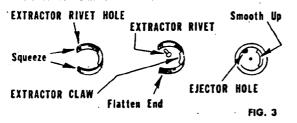
**Note:** Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR ---- EXTRACTOR RIVET (in bolt assembly)

To Disassemble—Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.



to service — Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble—Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly, See Fig. 3. Straighten tail of extractor. See Fig. 3. Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

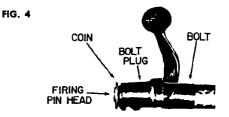
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

Aften tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

#### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble — Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. See Fig. 4. Unscrew and remove firing pin assembly from bolt assembly.

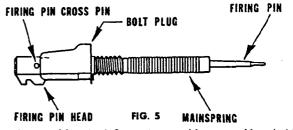


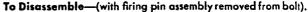
**To Service** — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble — Follow reverse order.

1

FIRING PIN ASSEMBLY — COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.





Caution: main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. See Fig. 5. Release parts carefully and disassemble.

**To Service** – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble — Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (includes rear sight collar, rear sight eyepiece, rear sight leaf, rear sight windage screw).

To Disassemble — Unscrew and remove rear sight screw. Remove rear sight assembly from rear sight base.

To Service — Interchangeable with no factory adjustment required. Replacement as a unit is recommended.

To Reassemble — Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

#### REAR SIGHT STEP

To Disassemble—Grasp and lift rear sight eyepiece and slide rear sight step rearward.

To Service — Interchangeable. Additional steps, marked for size, are available for range purposes.

To Reassemble — Follow reverse order. Large end of step should face forward.

#### REAR SIGHT BASE

To Disassemble — Remove rear sight assembly and rear sight step. Unscrew and remove rear sight base screws, washer and base.

To Reassemble — Follow reverse order.

FRONT SIGHT HOOD (BDL Grade only)

To Disassemble — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base.

To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble — Follow reverse order.

#### FRONT SIGHT

To Disassemble — Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble — Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble --- Follow reverse order.

#### TRIGGER GUARD (ADL Grade)

To Disassemble — Unscrew and remove trigger guard screws and disassemble trigger guard from stock.

To Reassemble -- Follow reverse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble—Remove bolt assembly, Unscrew and remove

front and rear guara screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly.

Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble — Follow reverse order. Tighten screws firmly. TRIGGER GUARD ASSEMBLY—COMPONENTS (BDL Grade) includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

**To Disassemble** — Drive out floor plate pivot pin and remove floor plate from trigger guard.

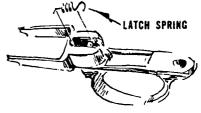
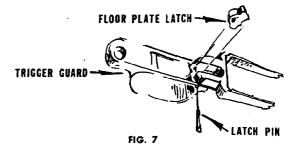


FIG. 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard. See Fig. 6.



Drive out floor plate latch pin — left to right and remove floor plate latch from trigger guard. See Fig. 7.

To Reassemble — Follow reverse order. Floor plate should swing freely and latch properly.

#### MAGAZINE --- MAGAZINE FOLLOWER --- MAGAZINE SPRING

To Disassemble — Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble — Follow reverse order.

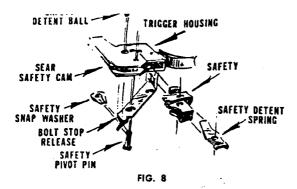
#### BOLT STOP - BOLT STOP SPRING - BOLT STOP PIN

**To Disassemble** — Remove bolt final assembly and stock assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

To Reassemble — Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place bolt stop in slot with contoured edge facing up and hole to rear. Align holes and drive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble — Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove



bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. See Fig. 8.

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

To Reassemble — Follow reverse order. Safety assembly and bolt stop should pivot freely.

#### TRIGGER ASSEMBLY

To Disassemble — Remove bolt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety cam.

To Service — Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connector-sear engagement may be required.

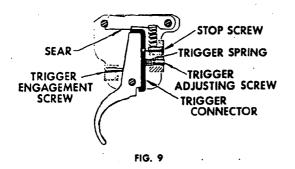
To Reassemble — Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: Includes bolt stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

To Disassemble — Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

**To Service** — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble — Place trigger cannector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring



not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

#### TRIGGER ADJUSTMENT. See Fig. 9.

Remove stock assembly and trigger guard.

IMPORTANT: Adjustment or removal of trigger-engagement screw (behind trigger) is **not recommended** unless for replacement. This screw is factory adjusted to provide correct amount of trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger—is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clackwise for heavier weight of pull and counter clockwise for lighter pull.

Travel of Trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

#### STOCK ASSEMBLY

**To Disassemble** — Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble — Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY — COMPONENTS (ADL Grade) includes butt plate, butt plate screw (2), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble — Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

**To Reassemble**—Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

**STOCK ASSEMBLY** — **COMPONENTS** (BDL Grade) includes ADL grade components plus butt plate spacer, fore end tip, fore end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble — See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble — Follow reverse order.

**BARREL ASSEMBLY**—Includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

#### SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE:

Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q. D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7's" wide. Swivel assemblies are (Q. D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

3

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## CYCLE OF OPERATION

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action —completing the cycle. Each operation is described in sequence below:

#### FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

#### EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 'a" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

#### **EJECTION**

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY

The safety, located at right rear of receiver, is operated by a push and pull action on the safety button. This two-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

## MALFUNCTIONS

#### **Cause and Correction**

#### **Over-Ride**

Cause:	1.	Magazine	Follower	binds.	

- Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.
- Correction: 1. Adjust side angle on Magazine Box.
  - 2. Change Spring.
  - 3. Correct.
  - 4. Straighten or replace Follower.

#### Stems Chamber

- Cause: 1. Sharp or rough Receiver Rails.
  - 2. Sharp edge rear end of Chamber.
  - 3. Rough Ramp in Receiver.
  - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - 2. Remove sharpness.
  - 3. Polish Ramp.
  - 4. Adjust.

#### **Bolt Closes Hard Over Shells**

- Cause: 1. Bolt interferes with shell rim.
  - 2. Extractor interferes with shell rim.
  - 3. Ejector binds or fails to retract far enough.
  - 4. Burr at Ejector Hole on Bolt.
  - 5. Sharp corners on Bolt Lugs.
  - 6. Extractor Rivet loose.

#### Correction: 1. Remove interference or change Bolt.

- Fit new Extractor (grind relief in new Extractor behind Claw).
  - 3. Free up or replace.
  - 4. Deburr.
  - 5. File radius.
  - 6. Tighten or replace Rivet.

#### Fails to Extract

Cause:

- Tight, rough or oversize Chamber.
- Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
  - 4. Height of Claw not correct.
  - 5. Extractor stuck back.

Correction: 1. Ream if tight or rough.

- Change Barrel Assembly if oversize.
- 2. Fit new Extractor.
- 3. Fit new Extractor.
- 4. Fit new Extractor.
- 5. Replace Extractor.

(Continued on page 8)

Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
	0-06 Caliber listed below, See Sectional View for proper of parts. See added page for other caliber part listings.	37	24525	Rear Sight Assembly (includes Rear Sight Collar, Rear Sigh Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw)
26271	Barrel Assembly (includes Barrel, Barrel Bracket, Receiver)	38	16454	Rear Sight Base
26327	Bolt Assembly (includes Bolt Body Assembly and Bolt	39	16023	Rear Sight Pase Screw
2032/	Handle)	40	16456	Rear Sight Screw
26317	Bolt Final Assembly (includes Bolt Assembly, Ejector, Ejector	41	28095	Rear Sight Step (Selected Sizes)
	Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin	42	16968	Rear Sight Washer
	Assembly)	43	15358	Rear Swivel Screw, BDL Grade
17012	Bolt Plug	44	17034	Receiver Plug Screw
17013	Bolt Stop	45	26585	Safety Assembly (includes Safety, Safety Button)
24475	Bolt Stop Pin	46	23222	Safety Detent Ball
15478	Bolt Stop Release	47	15368	Safety Detent Spring
17014	Bolt Stop Spring	48	17043	Safety Pivot Pin
14472	Butt Plate	49	17044	Safety Snap Washer
25410	Butt Plate Screw	50	15666	Sear Safety Cam
15287	Center Guard Screw, ADL Grade	51	24476	Sear fin
17017	Ejector	52	17047	Sear Spring
17676	Ejector Pin	53	30855	Sling Strap Assembly, BDL Grade (includes Sling Strap
17019	Ejector Spring			Fastener, Keeper, Buckle)
16254	Extractor	{	26990	Sling Strap Assembly and Mountings Complete (include
27340	Extractor Rivet	· ·		Sling Strap Assembly, Swivel Assembly, Q. D. (2), Fro Swivel Nut, Front Swivel Screws, Rear Swivel Screw)
15376	Fastener, Sling Strap	54 ·	26381	Stock Assembly, ADL Grade (includes Butt Plate, Butt Pla
22020 22040	Firing Pin Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing			Screw (2), Front Guard Screw Bushing, Stock, Stock Re forcing Screw, Stock Reinforcing Screw Dawel)
11040	Pin Cross Pin, Firing Pin Head, Main Spring)	E i i	26401	Stock Assembly, BDL Grade (includes Butt Plate, Butt Pla
17022	Firing Pin Cross Pin			Screw (2), Fore-end Tip, Fore-end Tip Spacer, Grip Ca
19800	Floor Plate, BDL Grade	f		Grip Cap Spacer, Front Swivel Nut, Stock, Stock Reinfor
15291	Floor Plate Latch, BDL Grade		1010/	ing Screw, Stock Reinforcing Screw Dowel) (not shown)
16451	Floor Plate Latch Pin, BDL Grade		18186 16970	Stock Reinforcing Screw (not shown)
16452	Floor Plate Latch Spring, BDL Grade	55	26555	Stock Reinforcing Screw Dowel (not shown)
16453	Floor Plate Pivot Pin, BDL Grade	56	15280	Swivel Assembly, BDL Grade (Q. D.)
22035	Front Guard Screw	57	17053	Trigger
15161	Front Guard Screw Bushing, ADL Grade	57		Trigger Adjusting Screw
15373	Front Sight	]	26345	Trigger Assembly (includes Bolt Stop Release, Trigger Ho ing Assembly, Safety Assembly, Safety Detent Ba
15719	Front Sight (Low)		1	Safety Detent Spring, Safety Pivat Pin, Safety Sn
28510	Front Sight Ramp			Washer, Sear and Safety Cam Assembly, Sear Sprin
15635	Front Sight Ramp, BDL Grade	1	1	Trigger, Trigger Adjusting Screw, Trigger Connects
28505	Front Sight Ramp Screw		Į –	Trigger Engagement Screw, Trigger Pin, Trigger Sprin Trigger Stop Screw) (not shown)
15363	Front Sight Hood, BDL Grade	57	17053	Trigger Engagement Screw
15357	Front Swivel Nut, BDL Grade	58	19461	Trigger Connector
15356	Front Swivel Screw, BDL Grade	59	15281	Trigger Guard
15331	Grip Cap, BDL Grade (not shown)	60	26376	Trigger Guard, BDL Grade
15332	Grip Cap Spacer, BDL Grade (not shown)	00	26371	Trigger Guard Assembly, BDL Grade (includes Floor Pla
15284 16430	Magazine, ADL Grade		20371	Floor Plate Latch, Floor Plate Latch Pin, Floor Plate Lat Spring, Floor Plate Pivot Pin, Trigger Guard) (not show
17024		61	26655	Trigger Housing Assembly (includes Trigger Housing Spa
15752	Magazine Follower		1 20000	(3), Trigger Side Plate (2)
	Magazine Follower, BDL Grade	62	24477	Trigger Pin
17028	Magazine Spring	63	15400	Trigger Spring
15677	Magazine Spring, BDL Grade	64	15481	Trigger Stop Screw
17029	Main Spring	"		und Bar and Asian
26355	Rear Guard Screw	<u> </u>	<u> </u>	

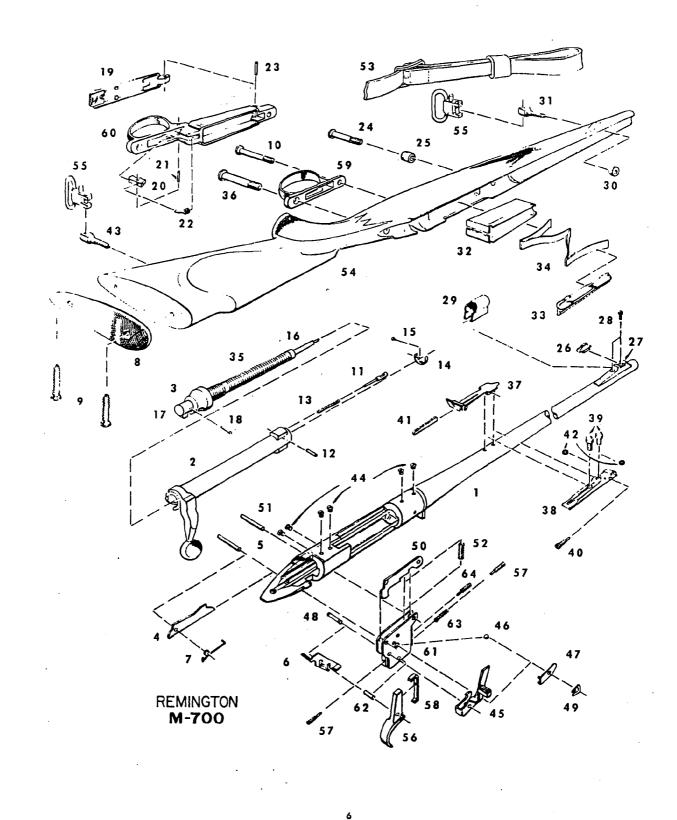
Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

SECTIONAL VIEW

## REMINGTON FIELD SERVICE MANUAL

MODEL 700



# ADDITIONAL CALIBERS (Not Shown in Sectional View) **CLUDES VARMINT MODEL**

## REMINGTON FIELD SERVICE MANUAL

- etc. 1

## Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

o.	NAME OF PART	Part No.	NAME OF PART
2 4	Barrel Assembly, 7mm Rem. Mag.	17891	Magazine Spring, 243 and 308 Win., 6mm Rem., 6.5mm Rem. Mag., 350 Rem. Mag., ADL Grade
3	Barrel Assembly, ómm Rem. Mag.	15698	Magazine Spring, 22-250 Rem.
	Barrel Assembly, 264 Win. Mag.	15699	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade
5	Barrel Assembly, 222 Rem.	17058	Main Spring, 222 Rem., 222 Rem. Mag., 223 Rem., 243 Win., 308
5	Barrel Assembly, 222 Rem. Mag.	}	Win., 6.5mm Rem. Mag., 350 Rem. Mag.
	Barrel Assembly, 243 Win.	18843	Rear Scope Base, Varmint
5	Barrel Assembly, 300 Win. Mag.	24526	Rear Sight Assembly, 7mm Rem. Mag., 264 Win. Mag.
3	Barrel Assembly, 308 Win.	21387	Recoil Pad, 7mm Rem. Mag., 264 and 300 Win. Mag.
2	Barrel Assembly, 270 Win.	25410	Recoil Pad Screw, 7mm Rem. Mag., 264 and 300 Win. Mag.
3	Barrel Assembly, 22-250 Rem.	18842	Scope Base Screw, Rear, Varmint
5	Barrel Assembly, 6.5mm Rem. Mag.	16205	Scope Base Screw Front, Varmint
	Barrel Assembly, 350 Rem. Mag.	26382	Stock Assembly, 7mm Rem. Mag., 264 Win. Mag., ADL Grade (in
)	Barrel Assembly, Varmint, 222 Rem. (includes Barrel, Barrel Bracket, Receiver)	20302	cludes Front Guard Screw Bushing, Recoil Pad, Recoil Pad Screw (2), Stock, Stack Reinforcing Screw, Stock Reinforcing Screw
	Barrel Assembly, Varmint, 22-250 Rem.	]	Dowel)
2	Barrel Assembly, Varmint, 223 Rem.	26380	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win.,
}	Barrel Assembly, Varmint, ómm Rem.	Í	ómm Rem., 22-250 Rem., ADL Grade
1	Barrel Assembly, Varmint, 243 Win.	26415	Stack Assembly, 7mm Rem. Mag., 264-300 Win. Mag., 8DL Grade
3	Bolt Assembly, 7mm Rem. Mag., 264 and 300 Win. Mag.		(includes Fore-End, Fore-End Spacer, Grip Cap, Grip Cap Spacer
>	Bolt Assembly, 6.5mm Rem. Mag., 350 Rem. Mag.	1	Recoil Pad, Recoil Pad Screw (2), Front Swivel Nut, Stock, Stock
5	Bolt Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.	24400	Reinforcing Screw, Stock Reinforcing Screw Dowel)
•	Bolt Assembly, 243 Win., 308 Win., ómm Rem., 22-250 Rem.	26400	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win. 6mm Rem., 22-250 Rem., BDL Grade
1	Bolt Final Assembly, 7mm Rem. Mag., 264 and 300 Win. Mag. (in- cludes same as 30-06)	29585	Stock Assembly, Varmint, BDL Grade (includes Butt Plate, Butt Plate Screw (2), Fore-End, Fore-End Spacer, Grip Cap, Grip Cap
	Bolt Final Assembly, 6.5mm Rem. Mag., 350 Rem. Mag. 🕖	1	Spacer, Front Swivel Nut, Stack, Stock Reinforcing Screw, Stoc
;	Bolt Final Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.		Reinforcing Screw Dowel)
	Bolt Final Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	26402	Stock Assembly, 6.5mm Rem. Mag., 350 Rem. Mag. (includes Fore
} }	Ejector, 222 Rem., 223 Rem., 223 Rem. Mag. Extractor, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag.,		End Spacer, Fore-End Tip, Front Swivel Nut, Grip Cap, Grip Ca Spacer, Recoil Pad, Recoil Pad Screw (2), Stock)
, )	350 Rem. Mag. Extractor, 222 Rem., 223 Rem., 222 Rem. Mag.	26375	Trigger Guard, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem. 243 and 308 Win., 6mm Rem., 22-250 Rem.
1	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 222 Rem. Mag. 223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag. (includes same as 30-06 BDL Grade
2	Extractor Rivet, 222 Rem., 223 Rem., 222 Rem. Mag.		
	Firing Pin, 222 Rem., 222 Rem. Mag., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag., 223 Rem.	27265	CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM Barrel Assembly, 375 H&H Mag.
	Firing Pin Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win.,	27266	Barrel Assembly, 458 Win. Mag.
	6mm Rem., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag., 223	15709	Extractor
	Rem.	16771	Front Sight, 375 H&H Mag.
	Floor Plate, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6mm Rem., 22-250 Rem.	23805	Front Sight, 458 Win. Mag.
,	Front Guard Screw, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6 mm Rem., 22-250 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same a standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used
	Front Scope Base, Varmint		DISCONTINUED or SERVICE PARTS
	Magazine, ADL Grade, 222 Rem., 222 Rem. Mag.	26270	
		26270	Barrei Assembly, 280 Rem. Extractor, 222 Cel
) }	Magazine, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem.	20467	Extractor, 222 Cal. Finance, 222 Cal
	Magazine, ADL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.	17639	Ejector, 222 Cal. Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 22:
; ;	Magazine, BDL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem. Magazine, BDL Grade, 6.5mm Rem. Mag., 350 Rem. Mag.	16717	Rem., 222 Rem. Mag., 243 Win., ADL Grade
	Magazine Follower, 222 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 22
1	Magazine Follower, 222 Rem. Mag.		Rem. Mag., 243 Win., 8DL Grade
5	Magazine Follower, 243 and 308 Win., 6mm Rem., 22-250 Rem., 6.5 mm Rem. Mag., 350 Rem. Mag.	24666 24477	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grad Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag.
i	Magazine Spacer, 222 Rem.		222 Rem., 222 Rem. Mag., 243 Win.
	Magazine Spacer, 222 Rem., BDL Grade	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag
5	Magazine Spacer, 222 Rem. Mag., 223 Rem., BDL Grade	20200	222 Rem., 222 Rem. Mag., 243 Win.
2	Magazine Spacer, 222 Rem. Mag., ADL Grade	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rec Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rec Sight Step, Rear Sight Washer (2)

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Parts Subject to Change Without Notice

## MALFUNCTIONS

## CAUSE and CORRECTION

### (Con't. from Page 4)

#### **Fails to Eject**

Cause: 1, Burr at Ejector Hole in Bolt.

- 2. Ejector binds or fails to retract far enough.
- 3. Extractor Rivet loose,
- 4. Extractor drops shell.

Correction: 1. Deburr.

- 2. Free up or replace.
- 3. Re-stake or replace.
- 4. Replace Extractor.

#### Misfires

- Cause: 1. Short Firing Pin (damaged).
  - 2. Firing Pin binds.
  - 3. Short Firing Pin protrusion.
  - 4. Firing Control out of adjustment.
  - 5. Faulty ammunition.

Correction: 1. Replace.

- 2. Free up or replace.
- 3. Change Firing Pin or Bolt.
- 4. Adjust.

#### **Follows Down**

Cause:

- Trigger Adjusting Screw, rear, out of adjustment (improper horizontal engagement of Sear and Connector).
- 2. Improper vertical engagement of Sear and Connector.
- 3. Trigger doesn't retract.
- 4. Corners on Sear or Connector rounded.
- 5. Trigger binds on Trigger Plate.
- 6. Not enough tension on Weight Screw (light pull).

Correction: 1. Adjust.

- 2. Fit new Fire Control.
- 3. Fit new Fire Control.
- 4. Fit new Fire Control.
- 5. File eliminate interference.
- 6. Adjust.

#### **Bolt Opens Hard**

- Cause: 1. See Fails to Extract.
  - 2. Upset Extraction Cam on Bolt Handle.
  - 3. Burr at Ejector Hole in Bolt.
  - 4. Blown or set back Primer on shell,

Correction: 1. See Fails to Extract.

- 2. Smooth up.
- 3. Deburr.
- Ream Chamber if throat is shallow (ammunition may be at fault).

#### Bolt Pulls Out

Cause:	Bolt Stop or Bolt Release binds. Bolt Stop or Bolt Release broken.
Correction:	Free up. Replace.

#### Safe Works Too Hard or Too Freely

- Cause: 1. Safe binds (works hard).
   2. Safety Snap Washer stretched out (Safe works too freely).
- Correction: 1. Free up.
  - 2. Replace Washer.

#### **Bulges or Blows Cases**

- Cause: 1. Oversize Chamber. 2. Maximum head space.
- **Correction:** 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

### **Bolt Binds**

- Cause: 1. Guard Screws protrude into Bolt track.
  - 2. Scope Screws protrude into Bolt track.
    - 3. Bolt Handle interference on Stock.
  - Step at rear of Bolt Lugs.
- Correction: 1. File ends of Screws.
  - File ends of Screws.
    - 3. Correct Stock or fit new Stock.
    - 4. File to blend.

#### Doesn't Group

- Cause: 1. Crown of Barrel damaged.
  - 2. Leading of Bore.
  - 3. Oversize Bore.
  - 4. Improper bedding of Barrel in Stock.
  - 5. Loose Sights.
- Correction: 1. Recrown.
  - 2. Lead or change Barrel.
  - 3. Change Barrel.
  - 4. Correct bedding.
  - 5. Tighten or replace.

#### **Point of Impact Not Correct**

- Cause: 1. Barrel not straight.
  - 2. Horns, breaks, etc. in Bore.
  - 3. Improper or loose Sights.
- Correction: 1. Straighten.
  - 2. Correct if possible.
    - 3. Tighten or change Sights.
- 8

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied — ADL (standard) and BDL. Included in the BDL grade is the model 700 VARMINT — an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.

The instruction folder RD-5461 is packaged with each new rifle. Folders may also be obtained from the retailer or dealer. This folder outlines operating instructions, instructions for care and maintenance of the rifle and a complete parts list.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber.

Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries an service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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#### BOTT FINAL ASSEMBLY

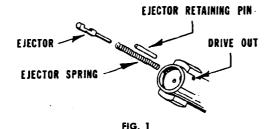
**To Disassemble** — With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

To Service — Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY — COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

#### EJECTOR — EJECTOR PIN — EJECTOR SPRING (in bolt assembly)



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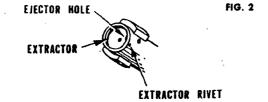
To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. See Fig. 1.

Ta Reassemble — Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

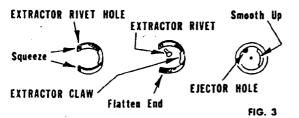
Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR — EXTRACTOR RIVET (in bolt assembly)

To Disassemble—Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.



To Service — Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble—Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. See Fig. 3. Straighten tail of extractor. See Fig. 3. Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

**Note:** If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under balt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

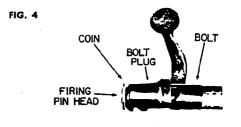
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

Aften tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

#### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble — Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. See Fig. 4. Unscrew and remove firing pin assembly from bolt assembly.

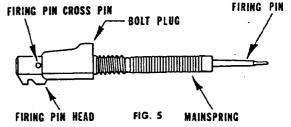


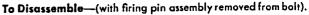
**To Service** — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble — Follow reverse order.

1

FIRING PIN ASSEMBLY --- COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.





this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. See Fig. 5. Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

**To Reassemble** — Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (includes rear sight collar, rear sight eyepiece, rear sight leaf, rear sight windage screw).

To Disassemble — Unscrew and remove rear sight screw. Remove rear sight assembly fram rear sight base.

**To Service** — Interchangeable with no factory adjustment required. Replacement as a unit is recommended.

To Reassemble — Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

#### REAR SIGHT STEP

To Disassemble - Grasp and lift rear sight eyepiece and slide rear sight step rearward.

To Service — Interchangeable. Additional steps, marked for size, are available for range purposes.

To Reassemble — Follow reverse order. Large end of step should face forward.

#### **REAR SIGHT BASE**

To Disassemble — Remove rear sight assembly and rear sight step. Unscrew and remove rear sight base screws, washer and base.

To Reassemble — Follow reverse order.

FRONT SIGHT HOOD (BDL Grade only)

To Disassemble — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base.

To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble --- Follow reverse order.

#### **FRONT SIGHT**

To Disassemble — Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble — Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble --- Follow reverse order.

#### TRIGGER GUARD (ADL Grade)

To Disassemble — Unscrew and remove trigger guard screws and disassemble trigger guard from stock.

To Reassemble — Follow reverse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble-Remove bolt assembly. Unscrew and remove

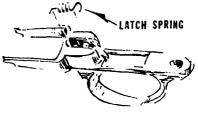
trigger and disassemble trigger guard from stack assembly.

Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble — Follow reverse order. Tighten screws firmly. TRIGGER GUARD ASSEMBLY—COMPONENTS (BDL Grade)

includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

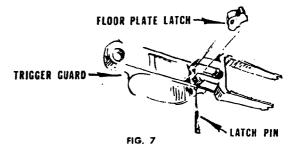
**To Disassemble** — Drive out floor plate pivot pin and remove floor plate from trigger guard.



FIG, 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard. See Fig. 6.



Drive out floor plate latch pin — left to right and remove floor plate latch from trigger guard. See Fig. 7.

To Reassemble — Follow reverse order. Floor plate should swing freely and latch properly.

#### MAGAZINE --- MAGAZINE FOLLOWER --- MAGAZINE SPRING

To Disassemble — Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble — Follow reverse order.

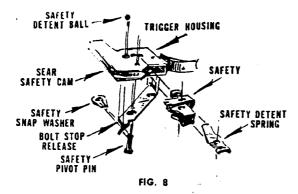
#### BOLT STOP --- BOLT STOP SPRING --- BOLT STOP PIN

**To Disassemble** — Remove bolt final assembly and stock assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

To Reassemble — Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place bolt stop in slot with contoured edge facing up and hole to rear. Align holes and drive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble — Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove



bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. **See Fig. 8.** 

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

To Reassemble — Follow reverse order. Safety assembly and bolt stop should pivot freely.

#### TRIGGER ASSEMBLY

To Disassemble — Remove bolt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety cam.

To Service — Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connector-sear engagement may be required.

To Reassemble — Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: Includes bolt stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

To Disassemble — Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

**To Service** — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble — Place trigger connector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring

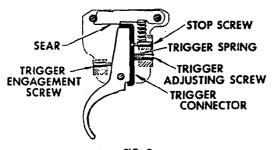


FIG. 9

and war safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

#### TRIGGER ADJUSTMENT. See Fig. 9.

Remove stock assembly and trigger guard.

IMPORTANT: Adjustment or removal of trigger engagement screw (behind trigger) is **not recommended** unless for replacement. This screw is factory adjusted to provide correct amount of trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger—is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clockwise for beavier weight of pull and counter clockwise for lighter pull.

Travel of Trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

#### STOCK ASSEMBLY

To Disassemble — Remove trigger guard or trigger guard assembly and remove stack assembly.

To Reassemble — Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY — COMPONENTS (ADL Grade) includes butt plate, butt plate screw (2), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble — Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

**To Reassemble**—Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

**STOCK ASSEMBLY** — COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore end tip, fore end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble — See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble --- Follow reverse order.

**BARREL ASSEMBLY**—Includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

#### SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE:

Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q. D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7's" wide. Swivel assemblies are (Q. D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

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## **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action —completing the cycle. Each operation is described in sequence below:

#### FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

#### **EXTRACTION**

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately  $\frac{1}{2}a''$  with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY

The safety, located at right rear of receiver, is operated by a push and pull action on the safety button. This two-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

## MALFUNCTIONS

### **Cause and Correction**

#### Over-Ride

Cause:	1.	Magazine	Fo	ollower	bin	ıds.

- 2. Damaged Follower Spring.
- 3. Magazine Spring caught under Guard.
- 4. Tabs on Follower bent.
- Correction: 1. Adjust side angle on Magazine Box.
  - 2. Change Spring.
  - 3. Correct.
  - 4. Straighten or replace Follower.

#### **Stems Chamber**

- Cause: 1. Sharp or rough Receiver Rails.
  - 2. Sharp edge rear end of Chamber.
  - Rough Ramp in Receiver.
  - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - 2. Remove sharpness.
  - 3. Polish Ramp.
  - 4. Adjust.

#### **Bolt Closes Hard Over Shells**

- Cause: 1. Bolt interferes with shell rim.
  - Extractor interferes with shell rim.
    - 3. Ejector binds or fails to retract far enough.
    - 4. Burr at Ejector Hole on Bolt.
      - 5. Sharp corners on Bolt Lugs.
    - 6. Extractor Rivet loose.

#### Correction: 1. Remove interference or change Bolt.

- 2. Fit new Extractor (grind relief in new Extractor behind Claw).
- 3. Free up or replace.
- 4. Deburr.
- 5. File radius.
- 6. Tighten or replace Rivet.

#### **Fails to Extract**

Cause:

4

- Tight, rough or oversize Chamber.
  - Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
  - 4. Height of Claw not correct.
  - 5. Extractor stuck back.

#### Correction: 1. Ream if tight or rough.

- Change Barrel Assembly if oversize.
- 2. Fit new Extractor.
- 3. Fit new Extractor.
- 4. Fit new Extractor.
- 5. Replace Extractor.

(Continued on page 8)

PARTS LIST

MODEL 700

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## REMINGTON FIELD SERVICE MANUAL

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ew Io.	Port No.	NAME OF PART	View No.	Part No.	NAME OF PART
DTE:	Basic 30	-06 Caliber listed below, See Sectional View for proper		15752	Magazine Follower, BDL Grade
	identity	of parts. See added page for other caliber part listings.		15940	Magazine Tab Screw (ADL Grade)
i ł		Barrel Assembly	34	17028	Magazine Spring
		Bult Assembly		15677	Magazine Spring, BDL Grade
		Bult Final Assembly	35	17029	Main Spring
	17012	Bolt Plug	36	26355	Rear Guard Screw
	17013	Bolt Stop	37	32510	Rear Sight Aperture
	24475	Bolt Stop Pin	38	32500	Rear Sight Base
	15478	Bolt Stop Release	39	28505	Rear Sight Base Screw (2)
	15224	Bolt Stop Spring	40	90905	Rear Sight Slide
	14472	Butt Plate	41	90906	Elevation Screw
	25410	Butt Plate Screw	42	90904	Windage Screw
	15287	Center Guard Screw, ADL Grade	43	15358	Rear Swivel Screw, BDL Grade
	17017	Ejector	44	17034	Receiver Plug Screw
	17676	Ejector Pm	45	26585	Safety Assembly
	17019	Ejector Spring	46	23222	Safety Detent Ball
	14669	Extractor	47	15368	Safety Detent Spring
	27340	Extractor Rivel	48	17043	Safety Pivot Pin
	15376	Fastener, Sling Strap	49	17044	Safety Snap Washer
	22020	Firing Pin	50	15666	Sear Safety Cam
	22040	Firing Pin Assembly	51	24476	Sear Pin
	17022	Firing Pin Cross Pin	52	17047	Sear Spring
	19800	Floor Plate, BDL Grade	53	30855	Sling Strap Assembly, BDL Grade
	15291	Floor Plate Latch, BDL Grade		26990	Sling Strap Assembly and Mountings Complete
	16451	Floor Plate Latch Pin, BDL Grade	54	26381	Stock Assembly, ADL Grade
	16452	Floor Plate Latch Spring, BDL Grade		26401	Stock Assembly, BDL Grade
	16453	Floor Plate Pivot Pin, BDL Grade		18186	Stock Reinforcing Screw (not shown)
	22035	Front Guard Screw		16970	Stock Reinforcing Screw Dowel (not shown)
	15161	Front Guard Screw Bushing, ADL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)
; {	15373	Front Sight	56	15280	Trigger
	15719	Front Sight (Low)	57	17053	Trigger Adjusting Screw
	28510	Front Sight Ramp		26345	Trigger Assembly
	15635	Front Sight Ramp, BDL Grade	58	19461	Trigger Connector
	28505	Front Sight Ramp Screw	59	17053	Trigger Engagement Screw
	15363	Front Sight Hood, BDL Grade	60	15281	Trigger. Guard
, }	15357	Front Swivel Nut, BDL Grade	61	26376	Trigger Guard, BDL Grade
	15356	Front Swivel Screw, BDL Grade		26371	Trigger Guard Assembly, BDL Grade
	15331	Grip Cap, BDL Grade (not shown)	62	26655	Trigger Housing Assembly
	30505	Grip Cap Spacer, BDL Grade (not shown)	63	24477	Trigger Pin
	15284	Magazine, ADL Grade	64	15400	Trigger Spring
	16430	Magazine, BDL Grade (not shown)	65	15481	Trigger Stop Screw
- 1	17024	Magazine Follower	l	1	

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Deliveries are F.O.B. Ilion, New York

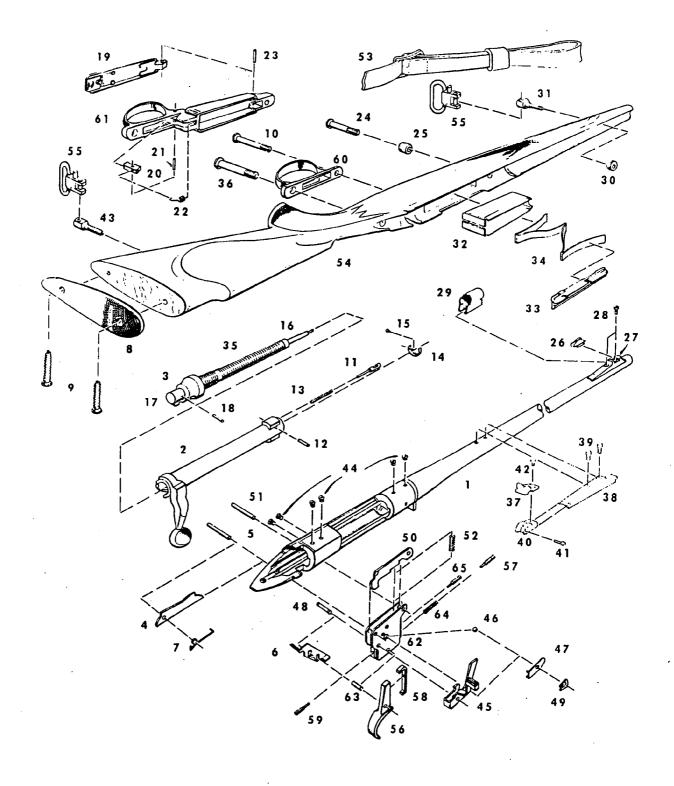
Parts Subject to Change Without Notice

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SECTIONAL VIEW

## REMINGTON FIELD SERVICE MANUAL

MODEL 700



## ADDITIONAL CALIBERS (Not Shown in Sectional View) ICLUDES VARMINT MODEL

## REMINGTON FIELD SERVICE MANUAL

MODEL 700

#### Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

No.	NAME OF PART	Part No.	NAME OF PART
′09	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
150	Extractor, 222-223 Rem., 17 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem.,
:41	Extructor Rivet, 7mm Rem. Mag., 264-300 Win.		243 & 308 Win., 6mm Rem., 22-250 Rem.,
	Mag.	1	17 Rem.
42	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem.,
21	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem.		17 Rem.,223 Rem.,243 Win.,308 Win.,6mm
	Mug., 22-250 Rem., 223 Rem., 17 Rem.		Rem., 22-250 Rem.
ы1	Firing Pin Assembly,222 Rem.17 Rem.243 Win.,		CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
	308 Win.,6mm Rem.,22-250 Rem.223 Rem.	27265	Barrel Assembly, 375 H&H Mag.
134	Floor Plate, BDL Grade, 222 Rem., 223 Rem.	27266	Barrel Assembly, 458 Win. Mag.
	243 & 308 Win., 6mm Rem., 22-250 Rem.,	15709	Extractor
	17 Rem.	16771	Front Sight, 375 H&H Mag.
137	Front Guard Screw, 222 Rem., 223 Rem., 243 &	23805	Front Sight, 458 Win. Mag.
	308 Win.,6mm Rem.,22-250 Rem.,17 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same a
'04 1.0	Front Scope Base, Varmint	· · ·	standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used
-59 -54	Front Sight, 7mm Rem. Mag., 264 Win. Mag.		DISCONTINUED or SERVICE PARTS
-11 192	Front Sight Ramp, ADL Grade Front Sight Ramp, BDL Grade	26270	Barrel Assembly, 280 Rem.
82	Magazine, ADL Grade, 222 Rem.	20467	Extractor, 222 Cal.
16	Magazine, BDL Grade, 222 Rem., 223 Rem.,	17639	Ejector, 222 Cal.
	17 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222
83	Magazine, ADL Grade, 243 & 308 Win., 6mm		Rem., 222 Rem. Mag., 243 Win., ADL Grade
15	Rem 22/250 Rem. Maguzine, BDL Grade, 243 & 308 Win., 6mm	15361	Front Sight Ramp, 7mm Rom. Mag., 264 Win. Mag., 222 Rom., 223 Rem. Mag., 243 Win., BDL Grade
	Rem. 22 250 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grad
56	Magazine, BDL Grade	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag.
18	Magazine Follower, 222 Rem.	10005	222 Rem., 222 Rem. Mag., 243 Win.
82	Magazine Follower, 243 & 308 Win., 6mm Rem. . 22-250 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag. 222 Rem., 222 Rem. Mag., 243 Win.
85	Magazine Spacer, 222 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rea
26	Magazine Spacer, 222 Rem., BDL Grade		Sight Step, Rear Sight Washer (2)
86	Magazine Spacer,223 Rem., BDL Grade, 17 Rem.		•
83	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		
91	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		
98	Magazine Spring, 22-250 Rem.		
99	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade		
58	Main Spring, 222 Rem., 223 Rem., 243 Win., . 308 Win., 17 Rem.		
43	Rear Scope Base, Varmint		
49	Recoil Pad, 7mm Rem.Mag.264 & 300 Win.Mag.		
10	Recoil Pad Screw,7mm Rem.Mag.,264 & 300 Win, Mag.		
42	Scope Base Screw, Rear Varmint		
05	Scope Base Screw, Front Varmint		
80	Stock Assembly, 7mm Rem. Mag., ADL Grade		
65	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade		
85	Stock Assembly,7mm Rem.Mag.,264-300 Win. Mag., BDL Grade		
70	Stock Assembly,222 Rem.,243 Win.,308 Win.	•	
	6mm Rem., 22-250 Rem., BDL Grade, 17 Rem.		
76	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.		

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Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

## MALFUNCTIONS

## **CAUSE and CORRECTION**

### (Con't. from Page 4)

#### **Fails to Eject**

Cause:

Misfires Cause:

Bolt	Pul	S	Ou

Cause:	<ol> <li>Bolt Stop or Bolt Release binds.</li> <li>Bolt Stop or Bolt Release broken.</li> </ol>
Correction:	1. Free up. 2. Replace.
Safe Works	Too Hard or Too Freely
Cause:	<ol> <li>Safe binds (works hard).</li> <li>Safety Snap Washer stretched out (Safe works too freely).</li> </ol>
Correction:	1. Free up. 2. Replace Washer.
Bulges or B	lows Cases
Cause:	<ol> <li>Oversize Chamber.</li> <li>Maximum head space.</li> </ol>
Correction:	<ol> <li>Change Barrel or Barrel and Receiver Assembly.</li> </ol>
	2. Fit new Bolt (ammunition may be at fault).
<b>Bolt Binds</b>	
Cause:	<ol> <li>Guard Screws protrude into Bolt track.</li> <li>Scope Screws protrude into Bolt track.</li> <li>Bolt Handle interference on Stock.</li> </ol>

ause:	<ol> <li>Guard Screws protrude into Bolt track.</li> </ol>
	2. Scope Screws protrude into Bolt track.
	3. Bolt Handle interference on Stock.

4. Step at rear of Bolt Lugs.

Correction: 1. File ends of Screws.

- 2. File ends of Screws.
  - 3. Correct Stock or fit new Stock.
  - 4. File to blend.

#### **Doesn't Group**

Cause:	1.	Crow	n of l	Barrel	damaged.

- 2. Leading of Bore.
- 3. Oversize Bore.
- 4. Improper bedding of Barrel in Stock.
- 5. Loose Sights.
- Correction: 1. Recrown.
  - 2. Lead or change Barrel.
  - 3. Change Barrel,
  - 4. Correct bedding.
  - 5. Tighten or replace.

#### **Point of Impact Not Correct**

use:	1.	Barrel	not	straight.
2030.	••			2 a.g

- 2. Horns, breaks, etc. in Bore.
  - 3. Improper or loose Sights.
- Correction: 1. Straighten.
  - 2. Correct if possible.
  - 3. Tighten or change Sights.
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2. Improper vertical engagement of Sear and Connector.

- 6. Not enough tension on Weight Screw

#### Correction: 1. Adjust.

- 3. Fit new Fire Control.
- 4. Fit new Fire Control.
- 5. File eliminate interference.
- 1. See Fails to Extract.
  - 2. Upset Extraction Cam on Bolt Handle.
  - 3. Burr at Ejector Hole in Bolt.
- Correction: 1. See Fails to Extract.

  - 4. Ream Chamber if throat is shallow (ammunition may be at fault).

#### 3. Short Firing Pin protrusion. 4. Firing Control out of adjustment. 5. Faulty ammunition.

Correction: 1. Deburr.

- Correction: 1. Replace.
  - 2. Free up or replace.

2. Firing Pin binds.

3. Change Firing Pin or Bolt.

1. Short Firing Pin (damaged).

1. Burr at Ejector Hole in Bolt.

3. Extractor Rivet loose. 4. Extractor drops shell.

2. Free up or replace. 3. Re-stake or replace. 4. Replace Extractor.

2. Ejector binds or fails to retract far enough.

4. Adjust.

#### **Follows Down**

- Cause:
- 1. Trigger Adjusting Screw, rear, out of adjustment (improper horizontal engagement of Sear and Connector).
- 3. Trigger doesn't retract.
- 4. Corners on Sear or Connector rounded.
- (light pull),

- 6. Adjust.

**Bolt Opens Hard** 

Cause:

- 4. Blown or set back Primer on shell.

- - 2. Smooth up.
    - 3. Deburr.

- 5. Trigger binds on Trigger Plate.

2. Fit new Fire Control.

## PARTS LIST

## MODEL 700 LEFT HAND MODEL

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## REMINGTON FIELD SERVICE MANUAL

Virw No	Part No	NAME OF PART
NOT	E Base	: 30.06 caliber listed below. For other caliber parts
	and	numbers see additional calibers list.
ļ		Barrel Assembly
.'		Bolt Assembly Bolt Final Assembly
3	17015	Rolt Plug
-1	17013	Bolt Stop Pin
5	.4475	Bolt Stop Pin-
15 /	90555 90554	Bolt Stop Spring
/ 8	14472	Butt Plate
9	25410	Butt Plate Screw
10	1/01/	Epetor
10	1/6/6	Epector Pm
1.2	17019	Ejector Spring-
13	14669	Extractor
14	.17.340	Extractor River
••	15376	Fastener, Sling Strap
15	2.020	Filing Pin
16	22040	Firing Pin Assembly
17	170.2	Linng Pin Crow, Pin
13	14984343	Floor Plate
113	15.294	Hoor Plate Latch
<b>'</b> 0	16451	Floor Plate Latch Pin
11	16452	Floor Plate Latch Spring
Q.	16453	Floor Plate Pivot Pin
1.1	22035	Front Guard Screw
24	1537.1	Front Sight
	15749	Front Sight (Low)
"1	156.35	Front Sight Ramp
<b>'</b> 6	.285695	Front Sight Ramp Screw
•7	15363	Front Sight Hood-
73	15357	Front Swivel Nut-
<b>.</b>	15,856	Front Swivel Screw
	1973331	Сар Сар
	30505	Gop Cap Spacer
s(1	16430	Magazine
11	15752	Magazine Follower
1. <b>*</b>	15677	Magazine Spring Main Spring
1,1 	17029	Main Spring Rear Guard Screw
3-1	26,355	Rear Guard Screw Rear Sight Aperture
2.) 	3.9510	Rear Sight Aperture
ii •	3.4500	Rear Sight Base
17	.8505	Rear Sight Side
44 4 1	90905	Elevation Screw
89 	SOSOG	
10 11	90904	Windage Screw
1.*	15358	
1.3	17034 32900	Receiver Plug Screw
10 14	23222	Safety Detent Balt
en Po	90557	Salety Detent Spring
1.	17043	Safety Pivot Pin-
17	17044	Safety Shap Washer
13	15666	Sear Safety Can-
1.1	24476	Sear Pin
d)	17047	Sear Spring
		· · · · · · · · · · · · · · · · · · ·

View No.	Part No.	NAME OF PART
51	30855	Sling Strap Assembly
	26990	Sling Strap Assembly and Mountings Complete
52	32890	Stock Assembly
	18186	Stock Reinforcing Screw
	16970	Stock-Reinforcing Screw Dowel
53	26555	Swivel Assembly (Q. D.)
54	15280	Trigger
55	17053	Trigger Adjusting Screw
	32895	Trigger Assembly
56	19461	Trigger Connector
57	17053	Trigger Engagement Screw
58	26376	Trigger Guard
	26371	Trigger Guard Assembly
59	32905	Trigger Housing Assembly
60	24477	Trigger Pin
61	15400	Trigger Spring
62	15481	Trigger Stop Screw

### ADDITIONAL CALIBERS

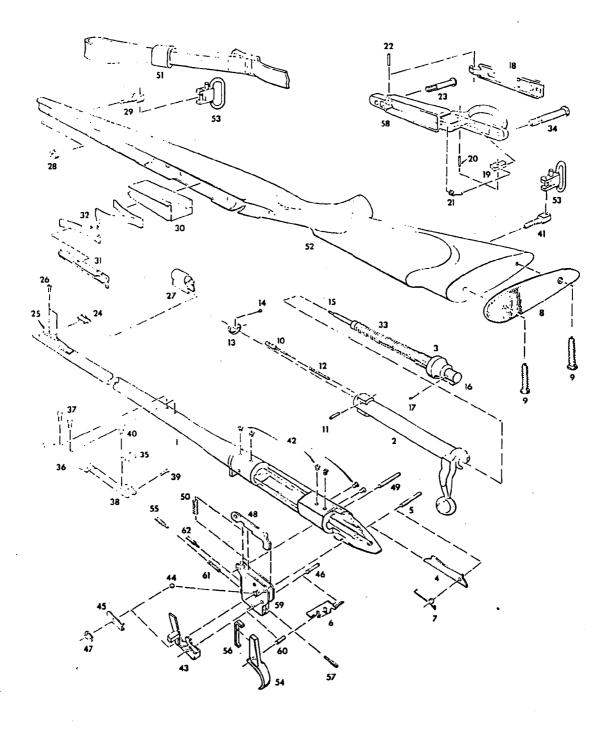
NOTE: Part not listed same as 30-06 Caliber

	Barrel Assembly, 7mm Rem. Mag
	Barrel Assembly, 270 Win
32862	Bolt Assembly, 7mm Rem. Mag
15709	Extractor, 7mm Rem. Mag
27341	Extractor Rivet, 7mm Rem. Mag
14659	Front Sight, 7mm Rem. Mag
21387	Recoil Pad, 7mm Rem. Mag
25410	Recoil Pad Screw, 7mm Rem. Mag
32880	Stock Assembly, 7mm Rem. Mag

EXPLODED VIEW

## REMINGTON FIELD SERVICE MANUAL

MODEL 700 LEFT HAND MODEL



The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725.

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Therefore, the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.



The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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MODEL 700 Index

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## REMINGTON FIELD SERVICE MANUAL

		Page
Trigger Guard (ADL Grade)	#15281	1
Center Guard Screw	#15287	1
Rear Guard Screw	#26355	1
Trigger Guard Assembly (BDL Grade) (See 725 Manual)	#26371	1
Magazine (ADL Grade)	#15284	1
Bolt Final Assembly (ADL Grade)	#26317	1,2&3
Bolt	#26327	1,2&3
Ejector	#17017	1,2&3
Ejector Pin	#17676	1,2&3
Ejector Spring	#17019	1,2&3
Extractor	#16254	1,2&3
Extractor Rivet	#27340	1,2&3
Bolt Stop	#17013	3
Bolt Stop Pin	#24475	3
Bolt Stop Spring	#15224	3
Sights		4
Rear Sight Assembly (See 725 Manual)		4
Front Sight	#15373	4
Front Sight Hood	#15363 •	4
Front Sight Ramp	#16717	4
Front Sight Ramp Pin (2)	#24477	<b>4</b> ·
Front Sight Ramp Screw	#19025	4

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· Page

Sling Strap Assembly & Mountings,	Complete	#26990	5
Sling Strap Assembly	#26625		5
Swivel Assembly (2)	#26555		5
Front Swivel Nut	#15357		5
Front Swivel Screw	#15356		5
Rear Swivel Screw	#15358		5
Sectional View			6

Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut MODEL 700 Assembly Page 1

### REMINGTON FIELD SERVICE MANUAL

### TRIGGER GUARD (ADL GRADE)

<u>To Disassemble</u> - Unscrew and remove rear and center guard screws and remove trigger guard.

To Replace - Interchange with no factory adjustment required.

To Reassemble - Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

<u>Caution</u>: Before assembling stock to receiver, particularly on ADL Crade, locate magazine fully into magazine recess in bottom of receiver. This will prevent any damage to stock when stock is tightened against receiver.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

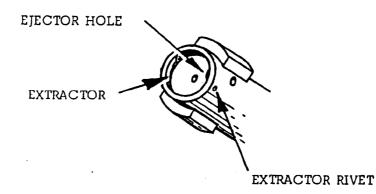
<u>To Disassemble</u> - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

<u>Caution:</u> Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

ETECTOR RETAINING PIN ETECTOR Drive Out Here EJECTOR SPRING

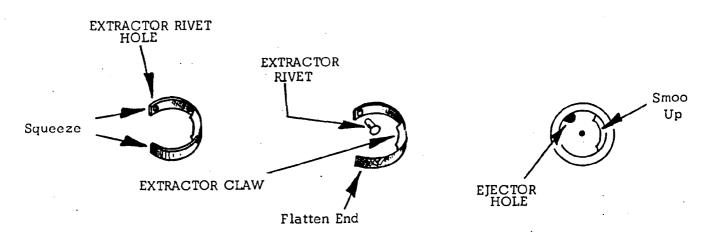
### BOLT FINAL ASSEMBLY Continued

Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)



Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)



Straighten tail of extractor. (See sketch above)

MODEL 700 Assembly Page 3

### REMINGTON FIELD SERVICE MANUAL

### BOLT FINAL ASSEMBLY Continued

Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Disassemble, if necessary, and rebend extractor as indicated in sketch on preceding page

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch on preceding page)

<u>Note</u>: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

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### REMINGTON FIELD SERVICE MANUAL

### SIGHTS

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

<u>To Disassemble</u> - Spread cover slightly and push forward in cover slots on either side of the ramp.

To Replace - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

### FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
- <u>To Replace</u> Interchangeable no factory adjustment required.

To Reassemble - Follow reverse order.

- FRONT SIGHT RAMP (Screw on type, used on the following calibers only: 222, 222 Magnum, 243, 6mm, 7mm Magnum and 264 Magnum)
- <u>To Disassemble</u> Unscrew front sight ramp screw and pry ramp up off ramp pins.
- To Replace Interchangeable no factory adjustment required.
- <u>To Reassemble</u> Place ramp pins in holes on top of barrel, align pins with holes in bottom of ramp and tap ramp down on to barrel until seated. Screw in ramp screw.

NOTE: Other calibers (308, 270, 280 and 30-06) have a brazed on front sight ramp which is not easily disassembled.

## REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY & MOUNTINGS, COMPLETE - A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle --- assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

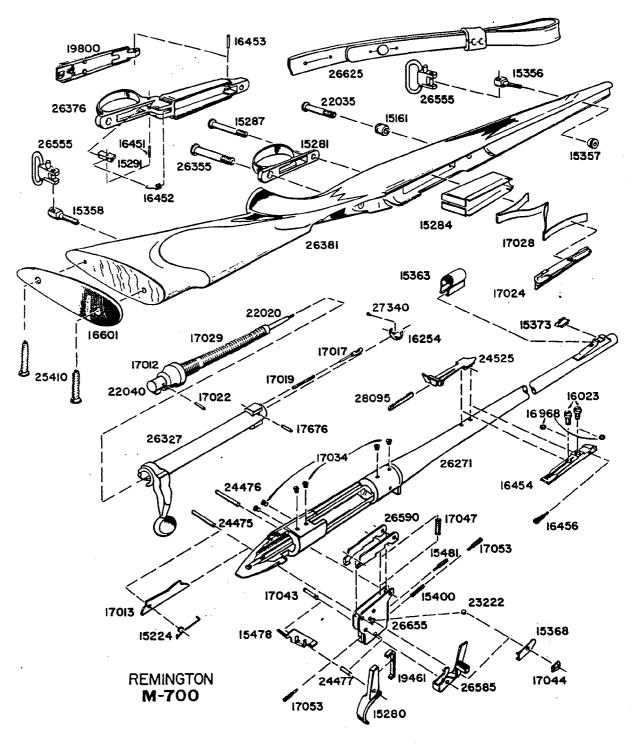
Slide front keeper band on free end of strap. Then insert strap thru front swivel and double strap back and thru attached front keeper. Insert brass fastener thru matching slots to join strap in desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

R&D:FGH 3-14-63

# REMINGTON FIELD SERVICE MANUAL

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# REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied - ADL (standard) and BDL. Included in the BDL grade is the Model 700 VARMINT - an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.

The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602 Page

Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble – Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

REAR SIGHT ASSEMBLY (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

#### FRONT SIGHT HOOD (BDL Grade only)

To Disassemble – Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service – Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### **FRONT SIGHT**

To Disassemble – Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble - Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble – Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

#### TRIGGER GUARD (ADL Grade)

To Disassemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow reverse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble – Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

TRIGGER GUARD ASSEMBLY – COMPONENTS (BDL Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. To Disassemble – Drive out floor plate pivot pin and remove floor plate from trigger guard.

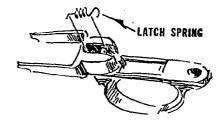
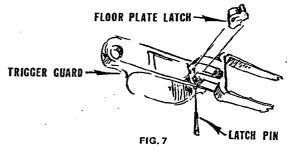


FIG.6

Caution: Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin - left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble – Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble – Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

#### STOCK ASSEMBLY

To Disassemble- Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble- Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY – COMPONENTS (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble – Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement, if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble- Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

Stems Chan	nber	Follows [
Cause: ,	<ol> <li>Sharp or rough Receiver Rails.</li> <li>Sharp edge - rear end of Chamber.</li> <li>Rough Ramp in Receiver.</li> <li>Magazine Box loose in Receiver.</li> </ol>	Cause:
Correction:	1. Polish or file.	
	2. Remove sharpness.	
	3. Polish Ramp.	
	4. Adjust.	Correctio
Bolt Closes	Hard Over Shells	Conectio
Cause:	1. Bolt interferes with shell rim.	
	2. Extractor interferes with shell rim.	
	3. Ejector binds or fails to retract far enough.	
	4. Burr at Ejector Hole on Bolt.	
	5. Sharp corners on Bolt Lugs.	Bolt Oper
	6. Extractor Rivet loose.	-
Compation.	1. Remove interference or change Bolt.	Cause:
Correction:	<ol> <li>Remove Interference of change Bott.</li> <li>Fit new Extractor (grind relief in new Extractor behind Claw).</li> </ol>	
	3. Free up or replace.	
	4. Deburr.	Correctio
	5. File radius.	Correctio
	6. Tighten or replace Rivet.	
Fails to Ext	ract	
Cause:	1. Tight, rough or oversize Chamber.	Bolt Pulls
	2. Extractor broken or damaged.	DOILFUIS
	3. Not enough Hook space on Extractor.	Cause:
	4. Height of Claw not correct.	Oddic.
	5. Extractor stuck back.	
		Correctio
Correction:	1. Ream if tight or rough.	
	Change Barrel Assembly if oversize.	
	2. Fit new Extractor.	Safety Sw
	3. Fit new Extractor.	
	<ol> <li>Fit new Extractor.</li> <li>Replace Extractor.</li> </ol>	Cause:
Fails To Eje		
Causar	1. Burr at Ejector Hole in Bolt.	Correctio
	2. Ejector binds or fails to retract far enough.	
	3. Extractor Rivet loose.	
	J. LAUALUI MIVELIUUSE.	

Extractor drops shell.

Correction: 1. Deburr.

- 2. Free up or replace.
- 3. Re-stake or replace.
- 4. Replace Extractor.

#### Misfires

- 1. Short Firing Pin (damaged). Cause:
  - 2. Firing Pin binds.
    - 3. Short Firing Pin protrusion.
    - 4. Firing Control out of adjustment.
    - 5. Faulty ammunition.

## Correction: 1. Replace.

- 2. Free up or replace.
- 3. Change Firing Pin or Bolt.
- Return the firearm to the factory.
- 5. Replace ammunition.

#### Down

- 1. Trigger out of adjustment.
  - 2. Improper vertical engagement of Sear and Connector.
    - 3. Trigger doesn't retract.
    - 4. Corners on Sear or Connector rounded.
    - 5. Trigger binds on Trigger Guard. 6. Not enough tension on Weight Screw (light
- n: 1. Return the firearm to the factory.
  - 2. Return the firearm to the factory.
  - 3. Return the firearm to the factory.
  - 4. Return the firearm to the factory.
  - 5. File Trigger Guard eliminate interference.
  - 6. Return the firearm to the factory.

### ns Hard

1. See Fails to Extract.

outt).

- 2. Upset Extraction Cam on Bolt Handle.
- 3. Burr at Ejector Hole in Bolt.
- 4. Blown or set back Primer on shell.
- n: 1. See Fails to Extract.
  - 2. Smooth up.
  - 3. Deburr.
  - 4. Ream Chamber if throat is shallow (ammunition may be at fault).

#### Out

- 1. Bolt Stop or Bolt Release binds. 2. Bolt Stop or Bolt Release broken.
- n: 1. Return the firearm to the factory. 2. Return the firearm to the factory.

vitch Works Too Hard or Too Freely

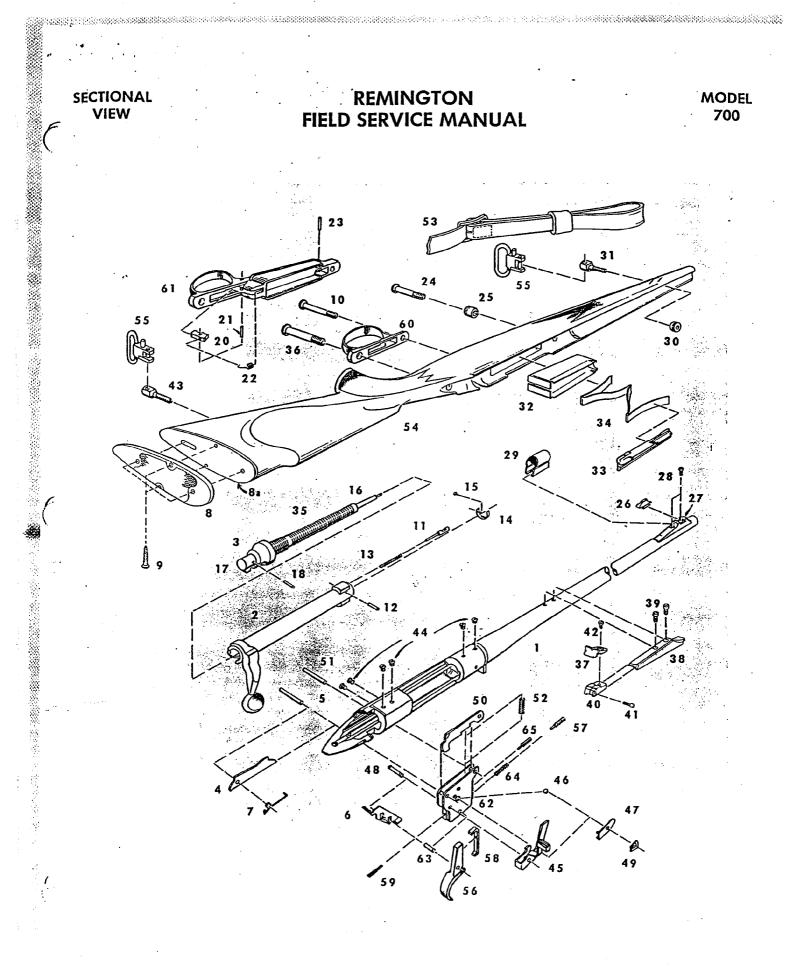
- 1. Safety switch binds (works hard). 2. Safety switch Snap Washer stretched out (Safety Switch works too freely.)
- n: 1. Return the firearm to the factory. 2. Return the firearm to the factory.

#### **Bulges or Blows Cases**

- 1. Oversize Chamber. Cause:
  - 2. Maximum head space.
- Correction: 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

#### **Bolt Binds**

- 1. Guard Screws protrude into Bolt track. Cause:
  - 2. Scope Screws protrude into Bolt track.
    - 3. Bolt Handle interference on Stock.
  - 4. Step at rear of Bolt Lugs.
- Correction: 1. File ends of Screws.
  - 2. File ends of Screws.
    - 3. Correct Stock or fit new Stock.
    - 4. File to blend.



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# MALFUNCTIONS

MODEL 700

# **CAUSE and CORRECTION**

# (Con't. from Page 4)

8

#### Doesn't Group

- Cause: 1. Crown of Barrel damaged.
  - 2. Leading of Bore.
  - 3. Oversize Bore.
  - 4. Improper bedding of Barrel in Stock.
  - 5. Loose Sights.

Correction: 1. Recrown.

- 2. Lead or change Barrel.
- 3. Change Barrel.
- 4. Correct bedding.
  - 5. Tighten or replace.

Point of Impact Not Correct

1. Barrel not straight.

1. Straighten.

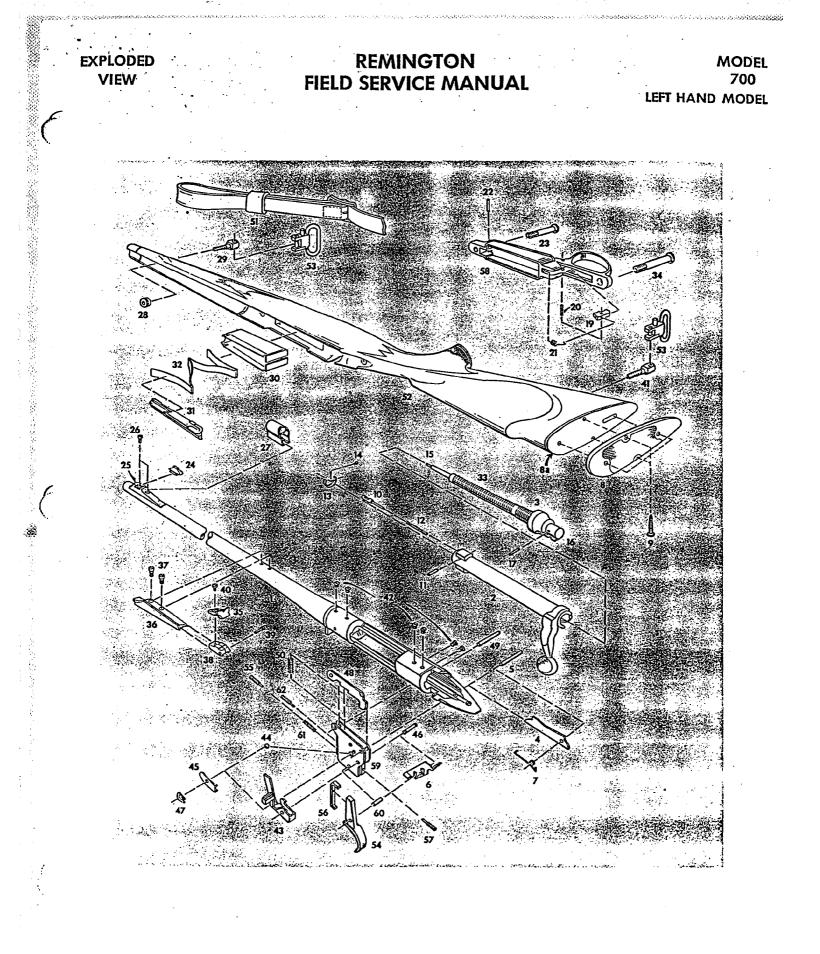
- 2. Horns, breaks, etc. in Bore.
- 3. Improper or loose Sights.

Correction:

Cause:

- 2. Correct if possible.
- 3. Tighten or change Sights.

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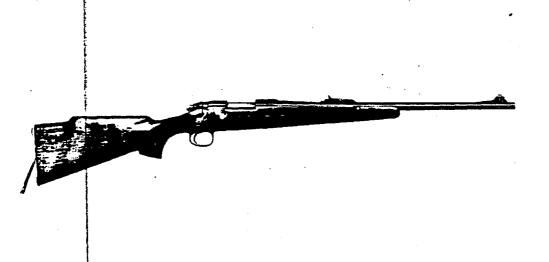
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MODEL 700 Introduction

### REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725.

Therefore the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.



The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

MODEL 700

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d all guns for factory service and inquiries an service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division ilion, New York

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REMINGTON FIELD SERVICE MANUAL

TRIGGER GUARD (ADL GRADE)

Unscrew and remove rear and center guard screws and <u>To Disassemble</u> remove trigger guard.

To Replace - Interchange with no factory adjustment required.

To Reassemble -Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

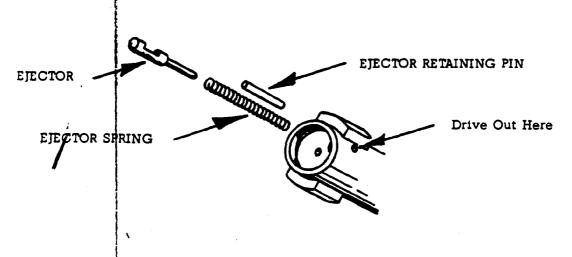
MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

Caution: Before assembling stock to receiver, particularly on ADL Grade, logate magazine fully into magazine recess in bottom of redeiver. This will prevent any damage to stock when stock is tightened against receiver.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

<u>To Disassemble</u> Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

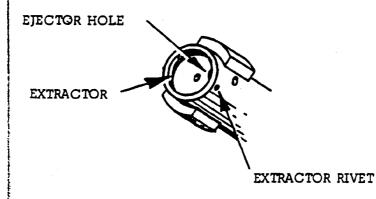
Hold ejector with forefinger to prevent ejector from Caution: springing free of bolt during disassembly.



### REMINGTON FIELD SERVICE MANUAL

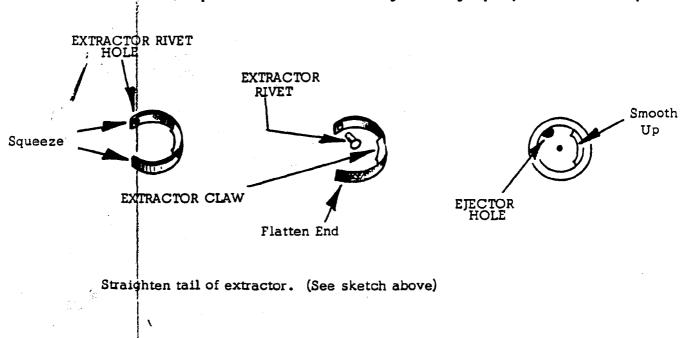
### BOLT FINAL ASSEMBLY Continued

Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)



Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)



### REMINGTON FIELD SERVICE MANUAL

### BOLT FINAL ASSEMBLY Continued

Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Disassemble, if necessary, and rebend extractor as indicated in sketch on preceding page

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch on preceding page)

<u>Note</u>: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

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To Disassemble - See Model 725 manual and disassemble in the same manner.

<u>To Replace</u> - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

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# REMINGTON FIELD SERVICE MANUAL

### SIGHTS

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

<u>To Disassemble</u> - Spread cover slightly and push forward in cover slots on either side of the ramp.

<u>To Replace</u> - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
- <u>To Replace</u> Interchangeable no factory adjustment required.
- To Reassemble Follow reverse order.
- FRONT SIGHT RAMP (Screw on type, used on the following calibers only: 222, 222 Magnum, 243, 6mm, 7mm Magnum and 264 Magnum)
- <u>To Disassemble</u> Unscrew front sight ramp screw and pry ramp up off ramp pins.

<u>To Replace</u> - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Place ramp pins in holes on top of barrel, align pins with holes in bottom of ramp and tap ramp down on to barrel until seated. Screw in ramp screw.

NOTE: Other calibers (308, 270, 280 and 30-06) have a brazed on front sight ramp which is not easily disassembled.

# REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY & MOUNTINGS, COMPLETE - A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle --- assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

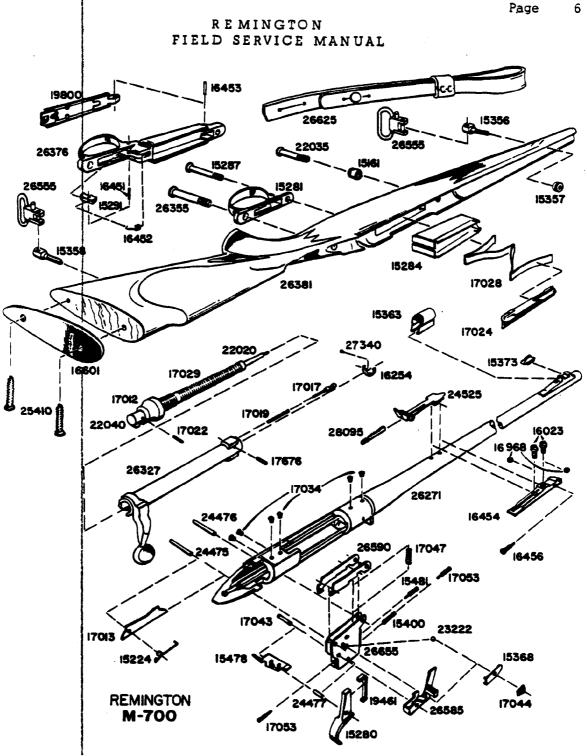
To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

Slide front keeper band on free end of strap. Then insert strap thru front swivel and double strap back and thru attached front keeper. Insert brass fastemer thru matching slots to join strap in desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

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MODEL 700 Sectional View Page 6



# REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied – ADL (standard) and BDL. Included in the BDL grade is the Model 700 VARMINT – an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The owner's manuals RD 5461 and RD 6664 (L.H.) are packaged with each new rifle. Manuals may also be obtained from the retailer or dealer. These manuals outline operating instructions, instructions for care and maintenance of the rifle and complete parts lists and exploded views.

When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Bolt Stop

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#### BOLT FINAL ASSEMBLY

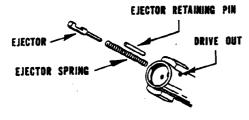
To Disassemble — With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

To Service – Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY - COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

EJECTOR – EJECTOR PIN – EJECTOR SPRING (in bolt assembly)





To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. (See Fig. 1).

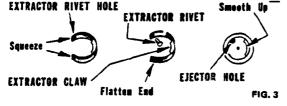
To Reassemble – Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR - EXTRACTOR RIVET (in bolt assembly) To Disassemble - Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.



To service — Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble – Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See Fig. 3). Straighten tail of extractor. (See Fig. 3). Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

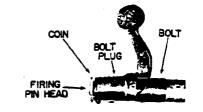
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breach bolt rim. (See Fig. 3).

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

#### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disessemble – Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. (See Fig. 4). Unscrew and remove firing pin assembly from bolt assembly.

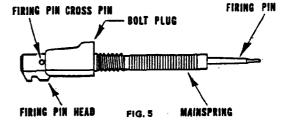
FIG. 4



To Service — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

FIRING PIN ASSEMBLY - COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



To Disassemble - (with firing pin assembly removed from bolt).

**Caution:** Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and / or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. (See Fig. 5). Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble - Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

REAR SIGHT ASSEMBLY (Includes rear sight aperture, rear sight base, rear sight base screw (2), rear sight slide, elevation screw, windage screw).

To Disassemble – Unscrew windage and elevation screws and remove rear sight aperture and rear sight slide from base. Unscrew and remove rear sight base screws and rear sight base. To Reassemble – Follow reverse order. All parts are interchangeable.

#### FRONT SIGHT HOOD (BDL Grade only)

To Disassemble — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base. To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble - Follow reverse order.

#### FRONT SIGHT

To Disassemble — Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble - Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble - Follow reverse order.

#### TRIGGER GUARD (ADL Grade)

To Disessemble – Unscrew and remove trigger guard screws and disassemble trigger guard from stock. To Reassemble – Follow reverse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble — Remove bolt assembly. Unscrew and remove front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble - Follow reverse order. Tighten screws firmly.

TRIGGER GUARD ASSEMBLY – COMPONENTS (BDL Grade) Includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard. To Disassemble – Drive out floor plate pivot pin and remove floor plate from trigger guard.

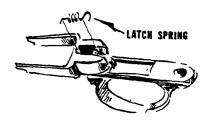
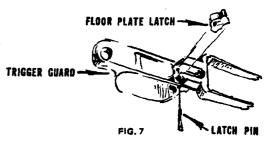


FIG. 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard (See Fig. 6)



Drive out floor plate latch pin — left to right and remove floor plate latch from trigger guard. (See Fig. 7).

To Reassemble — Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE - MAGAZINE FOLLOWER - MAGAZINE SPRING

To Disassemble — Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

To Reassemble - Follow reverse order.

BOLT STOP - BOLT STOP SPRING - BOLT STOP PIN To Disassemble - Remove bolt final assembly and stock assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

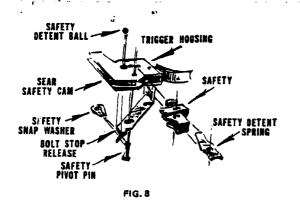
To Reassemble — Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place bolt stop in slot with contoured edge facing up and hole to rear. Align holes and drive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble – Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. (See Fig. 8).

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

To Reassemble — Follow reverse order. Safety assembly and bolt stop should pivot freely.



#### TRIGGER ASSEMBLY

To Disassemble – Remove bolt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety cam.

To Service — Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connectorsear engagement may be required.

To Reassemble - Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: Includes bolt stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

To Disassemble — Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

To Service — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble — Place trigger connector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring

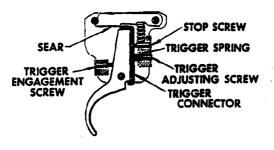


FIG. 9

and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

### TRIGGER ADJUSTMENT (See Fig. 9)

Remove stock assembly and trigger guard.

**IMPORTANT:** Adjustment or removal of trigger engagement screw (behind trigger) is **not recommended** unless for replacement. This screw is factory adjusted to provide correct amount of trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger – is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clockwise for heavier weight of pull and counter clockwise for lighter pull. Travel of Trigger – is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

#### STOCK ASSEMBLY

To Disassemble – Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble - Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY - COMPONENTS (ADL Grade) includes butt plate, butt plate screw (4), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble - Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble - Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

**STOCK ASSEMBLY – COMPONENTS** (BDL Grade) includes ADL grade components plus butt plate spacer, fore-end tip, fore-end tip spacer, grip cap, grip cap spacer, front swivel nut. **To Disassemble** – See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble - Follow reverse order.

BARREL ASSEMBLY – Includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE: Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q.D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7/8" wide. Swivel assemblies are (Q.D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels – insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

NOTE: After all reassembling and / or adjustments see safety performance check.

FGH-RES. 3-76

# **CYCLE OF OPERATION**

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action - completing the cycle. Each operation is described in sequence below:

#### FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A carn at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

#### EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately 1/8" with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear — completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY

The safety, located at right rear of receiver is operated by a push and pull action on the safety button. This two-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position "F" marking) nullifies above conditions and rifle may be fired.

#### Over-Ride

- Cause: 1. Magazine Follower binds.
  - 2. Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.

Correction: 1. Adjust side angle on Magazine Box.

- 2. Change Spring.
  - 3. Correct.
  - 4. Straighten or replace Follower.

#### Stems Chamber

Cause:

- Cause: 1. Sharp or rough Receiver Rails.
  - Sharp edge rear end of Chamber.
  - 3. Rough Ramp in Receiver.
  - 4. Magazine Box loose in Receiver.

Correction: 1. Polish or file.

- 2. Remove sharpness.
  - 3. Polish Ramp.
  - 4. Adjust.

#### Bolt Closes Hard Over Shells

- 1. Bolt interferes with shell rim.
- 2. Extractor interferes with shell rim.
- 3. Ejector binds or fails to retract far enough.
- 4. Burr at Ejector Hole on Bolt.
- 5. Sharp corners on Bolt Lugs.
- 6. Extractor Rivet loose.

#### Correction: 1. Remove interference or change Bolt. 2. Fit new Extractor (grind relief in new Extractor

- behind Claw).
- 3. Free up or replace.
- 4. Deburr.
- 5. File radius.
- 6. Tighten or replace Rivet.

#### Fails to Extract

- Cause: 1. Tight, rough or oversize Chamber.
  - 2. Extractor broken or damaged.
    - 3. Not enough Hook space on Extractor.
    - 4. Height of Claw not correct.
    - 5. Extractor stuck back.

#### Correction: 1. Ream if tight or rough.

Change Barrel Assembly if oversize,

- 2. Fit new Extractor.
- 3. Fit new Extractor.
- 4. Fit new Extractor.
- 5. Replace Extractor.

MODEL 700

# REMINGTON FIELD SERVICE MANUAL

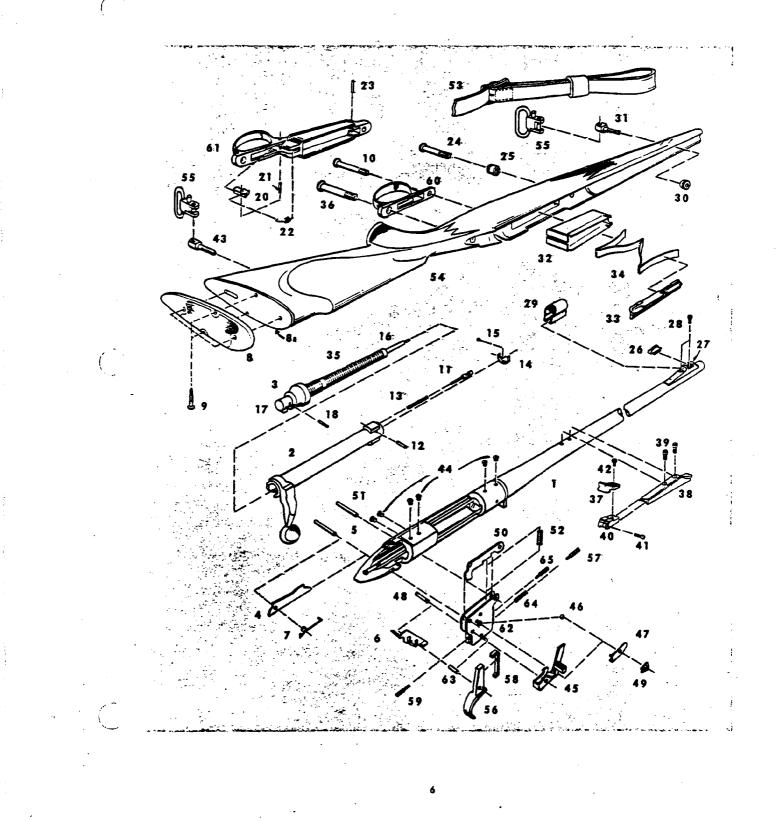
PARTS LIST

/iew Ne.	Pert No.	NAME OF PART	View Ne.	Pert Ne.	NAME OF PART	
	Reality	20.08 Calibar listed kalaw San Santianat View des assess				
JIE:		30-06 Caliber listed below. See Sectional View for proper y of parts, See added page for other caliber part listings.		91017	Magazine Follower, BDL Grade	
			{	15940	Magazine Tab Screw, ADL Grade	
		Barrel Assembly	34	17028	Magazine Spring	
		Bolt Assembly	1	15677	Magazine Spring, BDL Grade	
		Bolt Final Assembly	35	17029	Main Spring	
1	7012	Bolt Plug	36	26355	Rear Guard Screw	
. 1	7013	Bolt Stop	37	32510	Reer Sight Aperture	
1	4475	Bolt Stop Pin	38	32500	Rear Sight Base	
1	5478	Boit Stop Release	39	28505	Rear Sight Base Screw (2)	
1	5224	Bolt Stop Spring	40	90905	Rear Sight Slide	
5	0953	Butt Plate	41	90906	Elevation Screw	
• •	0954	Butt Plate Spacer, BDL	42	90904	Windage Screw	
2	5380	Butt Plate Screw	43	15358	Rear Swivel Screw, BDL Grade	
1	5287	Center Guard Screw, ADL Grade	44	17034	Receiver Plug Screw	
1	7017	Ejector	45	26585	Safety Assembly	
1	7676	Ejector Pin	46	23222	Sefety Detent Ball	
1	7019	Ejector Spring	47	15368	Sefety Detent Spring	
1	4669	Extractor	48	17043	Sefety Pivot Pin	
2	7340	Extractor Rivet	49	17044	Safety Snap Washer	
1	5376	Fastener, Sling Strap	50	15666	Sear Safety Cam	
2	2020	Firing Pin	51	24476	Seer Pin	
2	2040	Firing Pin Assembly	52	17047	Seer Spring	
1	7022	Firing Pin Cross Pin	53	30655	Sling Strap Assembly, BDL Grade	
1	5291	Floor Plate Latch, BDL Grade		26990	Sling Strap Assembly and Mountings Complete	
1	6451	Floor Plate Latch Pin, BDL Grade	54	33366	Stock Assembly, ADL Grade	
1	6452	Floor Plate Latch Spring, BDL Grade		33371	Stock Assembly, BDL. Grade	
1	6453	Floor Plate Pivot Pin, BDL Grade		18186	Stock Reinforcing Screw (not shown)	
2	2035	Front Guard Screw		16970	Stock Reinforcing Screw Dowel (not shown)	
1	5161	Front Guard Screw Bushing, ADL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)	
1	5373	Front Sight	56	15280	Trigger	
1	5719	Frant Sight (Low)	57	17053	Trigger Adjusting Screw	
2	8510	Front Sight Ramp		26345	Trigger Assembly	
1	5635	Front Sight Ramp, BDL Grade	58	19461	Trigger Connector	
2	8505	Front Sight Ramp Screw	59	91128	Trigger Engagement Screw	
1	5363	Front Sight Hoad, BDL Grade	60	15281	Trigger Guard	
1	5357	Front Swivel Nut, BDL Grade	61	26376	Trigger Guard, BDL Grade	
1	5356 .	Front Swivel Screw, BDL Grade		26371	Trigger Guard Assembly, BDL Grade	
9	0957	Grip Cap, BDL Grade (not shown)	62	26655	Trigger Housing Assembly	
2	5380	Grip Cap Screw	63	24477	Trigger Pin	
9	0958	Grip Cap Spacer, BDL Grade (not shown)	64	15400	Trigger Spring	
1	5284	Magazine, ADL Grade	85	15481	Trigger Stop Screw	
1	6430	Magazine, BDL Grade (not shown)				
	0952	Magazine Follower				

SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



### ADDITIONAL CALIBERS (Not Shown in Sectional View) INCLUDES VARMINT MODEL

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2. 4

# REMINGTON FIELD SERVICE MANUAL

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MODEL 700

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#### Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

art No.	NAME OF PART	Part No.	NAME OF FART
15709	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm
15850	Extractor, 222-223 Rem., 17 Rem.		Rem., 22-250 Rem., BDL Grade, 17 Rem.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223
27342	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.		Rem., 243 Win., 6mm Rem., 22-250 Rem.
22021	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-	33375	Stock Assembly, Varmint, BDL Grade, 25-06
42021	250 Rem., 223 Rem., 17 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 &
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308		308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
22041	Win., 6mm Rem., 22-250 Rem. 223 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.,
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308		223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.
10434	Win., 6mm Rem., 22-250 Rem., 17 Rem.		
22037	Front Guard Scraw, 222 Rem., 223 Rem., 243 & 308		CALIBERS: 375 H & H Magnum, 458 WIN. MAGNUM
2203/	Win., 6mm Rem., 22-250 Rem., 17 Rem.	27265	Barrel Assembly, 375 H & H Mag.
	Front Scope Base, Varmint	27266	Barrel Assembly, 458 Win. Mag.
16204	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	15709	Extractor
14659		16771	Front Sight, 375 H & H Mag.
28511	Front Sight Ramp, ADL Grade	23805	Front Sight, 458 Win. Mag.
15992 15282	Front Sight Ramp, BDL Grade Magazine, ADL Grade, 222 Rem.	27270	Stock Assembly, 375 H & H Mag., 458 Win. Mag. (In-
16716	Magazine, ADL Grade, 222 Rem., 223 Rem., 17 Rem.		cludes same as standard Magnum except Stock Bolt (2),
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem.		Nut (2), Cover (4) used)
19463	22-250 Rem.		
16715	Magazine, BDL, Grade, 243 & 308 Win., 6mm Rem.		DISCONTINUED or SERVICE PARTS
10/13	22-250 Rem.	26270	Sarrei Assembly, 280 Rem.
14756	Magazine, BDL Grade	20467	Extractor, 222 Cal.
90951	Magazine Follower, 222 Rem., 223 & 17 Rem.	17639	Ejector, 222 Cal.
90951	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264
50302	Rem.		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL
15742	Magazine Spacer, 222 Rem.		Grade
15286	Magazine Spacer, 222 Rem., BDL Grade	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.		Rem., 222 Rem. Meg., 243 Win., BDL Grade
91133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win.,
	Magazine Spring, 222 Rein, 223 Rein, 17 Rein. Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		ADL Grade
17891		24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264
15698	Magazine Spring, 22-250 Rem.		Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
15699	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win.,	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem.,
	BDL Grade		264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win.,	28200	Rear Sight Assembly, Complete (includes Rear Sight
	17 Rem.		Assembly, Rear Sight Base, Rear Sight Base Screw (2),
18843	Rear Scope Base, Vermint		Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2)
90949	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag.		
25410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		,
18842	Scope Base Screw, Rear Varmint		
16205	Scope Base Screw, Front Vermint		
33380	Stock Assembly, 7mm Rem. Mag., ADL Grade		
33365	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm		
	Rem., 22-250 Rem., ADL Grade		
33385	Stock Assembly, 7mm Rem. Mag., 264 & 300 Win. Mag.,		
	BDL Grade	1	

Deliveries are F.O.B. Ilion, New York

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Parts Subject to Change Without Notice

# MALFUNCTIONS

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# CAUSE and CORRECTION

# (Con't. from Page 4)

Fails to Eject	· ·	Boit Pulis Ou	ıt
Cause:	<ol> <li>Burr at Ejector Hole in Bolt.</li> <li>Ejector binds or fails to retract far enough.</li> <li>Extractor Rivet loose.</li> </ol>	Cause:	<ol> <li>Bolt Stop or Bolt Release binds.</li> <li>Bolt Stop or Bolt Release broken.</li> </ol>
	4. Extractor drops shell.	Correction:	1. Free up. 2. Replace.
Correction:	1. Deburr. 2. Free up or replace.		
	3. Re-stake or replace.	Safe Works T	oo Hard or Too Freely
	4. Replace Extractor.	Cause:	<ol> <li>Safe binds (works hard).</li> <li>Safety Snap Washer stretched out (Satworks too freely).</li> </ol>
Misfires			
Cause:	<ol> <li>Short Firing Pin (damaged).</li> <li>Firing Pin binds.</li> <li>Short Firing Pin protrusion.</li> <li>Firing Control out of adjustment.</li> </ol>	Correction:	1. Free up. 2. Replace Washer.
	5. Faulty ammunition.	Buiges or Blo	
Correction:	1. Replace. 2. Free up or replace.	Cause:	1. Oversize Chamber. 2. Maximum head space.
•	<ol> <li>Change Firing Pin or Bolt.</li> <li>Adjust.</li> </ol>	Correction:	1. Change Barrel or Barrel and Receive Assembly. 2. Fit new Bolt (ammunition may be at fault).
Follows Down	n		
Cause:	1. Trigger Adjusting Screw, rear, out of adjust-	Bolt Binds	
	ment (improper horizontal engagement of Sear and Connector).	Cause:	1. Guard Screws protrude into Bolt track.
	<ol> <li>Improper vertical engagement of Sear and Connector.</li> <li>Trigger doesn't retract.</li> </ol>		<ol> <li>Scope Screws protrude into Bolt track.</li> <li>Bolt Handle interference on Stock.</li> <li>Step at rear of Bolt Lugs.</li> </ol>
	<ol> <li>Corners on Sear or Connector rounded.</li> <li>Trigger binds on Trigger Plate.</li> </ol>	Correction:	1. File ends of Screws.
	<ul> <li>6. Not enough tension on Weight Screw (light pull).</li> </ul>		<ol> <li>File ends of Screws.</li> <li>Correct Stock or fit new Stock.</li> <li>File to blend.</li> </ol>
Correction:	1. Adjust.		
	2. Fit new Fire Control. 3. Fit new Fire Control.	Doesn't Grou	up
	4. Fit new Fire Control.	Cause:	1. Crown of Barrel damaged.
	5. File – eliminate interference.		2. Leading of Bore. 3. Oversize Bore.
	6. Adjust.		4. Improper bedding of Barrel in Stock.
			5. Loose Sights.
Bolt Opens H		Correction:	1. Recrown
Cause:	1. See Fails to Extract. 2. Upset Extraction Cam on Bolt Handle.		2. Lead or change Barrel.
	3. Burr at Elector Hole in Bolt.		3. Change Barrel.
	4. Blown or set back Primer on shell.		4. Correct bedding. 5. Tighten or replace.
Correction:	1. See Fails to Extract.		
	2. Smooth up.	Point of Imp	act Not Correct
	3. Deburr. 4. Ream Chamber if throat is shallow (am-	Cause:	1. Barrel not straight.
	munition may be at fault).		<ol> <li>Horns, breaks, etc. in Bore.</li> <li>Improper or loose Sights.</li> </ol>
		Correction:	1. Straighten.
			<ol> <li>Correct if possible.</li> <li>Tighten or change Sights.</li> </ol>

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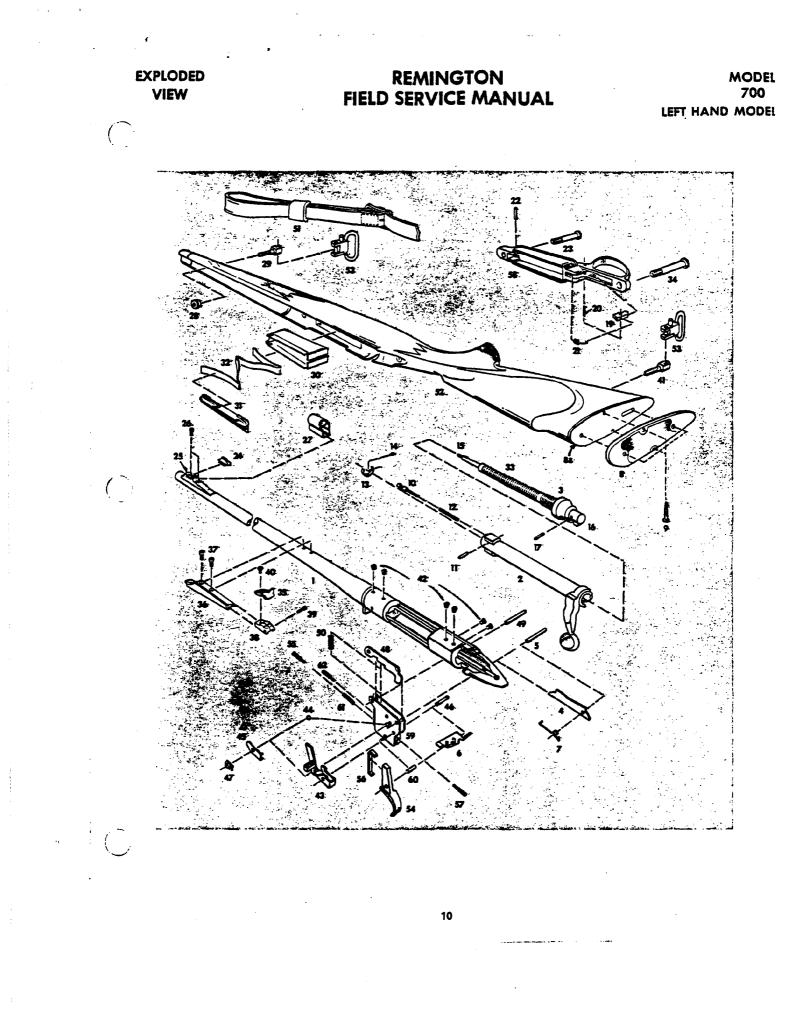
# MODEL 700 LEFT HAND MODEL

# REMINGTON FIELD SERVICE MANUAL

)W 8.	Part No.	NAME OF PART	View Ne.	Pert Ne.	NAME OF PART
NOT	: Basic	30-06 caliber listed below. For other caliber parts	41	15358	Rear Swivel Screw
	and n	umbers see additional calibers list.	42	17034	Receiver Plug Screw
			43	32900	Safety Assembly
1		Sarrei Assembly	44	23222	Safety Detent Ball
2		Bolt Assembly	45	90557	Safety Detent Spring
		Boit Final Assembly	46	17043	Safety Pivot Pin
3	17012	Boit Plug	47	17044	Safety Snap Washer
4	17013	Boit Stop	48	15666	Seer Safety Cam
5	24475	Bolt Stop Pin	49	24476	Seer Pin
6	90555	Bolt Stop Release	50	17047	Seer Spring
7	90554	Bolt Stop Spring	51	30855	Sling Strap Assembly
8	90953	Sutt Plate	1	26990	Sling Strap Assembly and Mountings Complete
8a	90954	Butt Plate Spacer	52	33391	Stock Assembly
9	25380	Butt Plate Screw		18186	Stock Reinforcing Screw
0	17017	Ejector		16970	Stock Reinforcing Screw Dowel
1	17 <b>676</b>	Ejector Pin	53	26555	Swivel Assembly (Q.D.)
2	17019	Ejector Spring	54	15280	Trigger
3	14669	Extractor	55	17053	Trigger Adjusting Screw
4	27340	Extractor Rivet		32895	Trigger Assembly
	15376	Fastener, Sling Strap	56	19461	Trigger Connector
5	22020	Firing Pin	57	91128	Trigger Engagement Screw
6	22040	Firing Pin Assembly	58	26376	Trigger Guard
7	17022	Firing Pin Cross Pin		26371	Trigger Guard Assembly
9	15291	Figor Plate Latch	59	32905	Trigger Housing Assembly
0	16451	Floor Plate Latch Pin	60	24477	Trigger Pin
1	16452	Floor Plate Latch Spring	61	15400	Trigger Spring
22	16453	Floor Plate Pivot Pin	62	15481	Trigger Stop Screw
3	22035	Front Guard Screw	-		
24	15373	Front Sight			
	15719	Front Sight (Low)	1		
5	15635	Front Sight Ramp			÷
6	28505	Front Sight Ramp Screw			
27	15363	Front Sight Hood			
8	15357	Front Swivel Nut			ADDITIONAL CALIBERS
9	15356	Front Swivel Screw			
-	90957	Grip Cap			NOTE: Part not listed same as 30-06 Caliber
	90958	Grip Cap Specer			
	25380	Grip Cap Specer Screw	1		Barrel Assembly, 7mm Rem. Mag.
0	16430	Magazine	1		Barrel Assembly, 270 Win.
11	91017	Magazine Follower	ł		Bolt Assembly, 7mm Rem. Mag
2	15677	Magazine Spring	1	15709	Extractor, 7mm Rem. Mag.
3	17029	Main Spring	1	27341	Extractor Rivet, 7mm Rem. Mag.
4	26355	Reer Guard Screw	1	14659	Front Sight, 7mm Rem. Mag
5	23510	Rear Sight Aperture	1	90949	Recoil Pad, 7mm Rem. Mag.
6	32500	Rear Sight Base	1	25410	Recoil Pad Screw, 7mm Rem. Mag.
17	28505	Rear Sight Screw	1	33395	Stock Assembly, 7mm Rem. Mag.
8	90905	Reer Sight Slide			· · · ·
19	90906	Elevation Screw	1		
10	90904	Windage Screw	1		

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# MODELS 725-721-722-700-600

### SAFETY PERFORMANCE CHECK

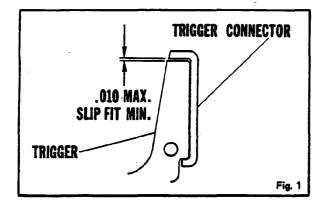
After reassembly, the following checks for proper function of the safety should be made.

Close bolt. Put safety ON SAFE. Lift bolt handle. (Bolt handle should not raise). Pull trigger (firing pin should not fail). Action of trigger pull should be smooth (no bind, drag, click or catch). Release trigger (trigger should return to former position). Put safety ON FIRE position (firing pin should not fall). Pull trigger (firing pin should fall). Repeat test at least three (3) times.

Safety should function on two (2) positive stop positions (ON SAFE – FIRE). If positions are not positive, check parts. Inspect detent holes, retainer, retainer pin, detent, detent spring and related parts for possible cause. Replace any worn or damaged parts and lubricate with a dry lubricant. Reassemble and check. If stop positions are not positive replace complete trigger housing assembly.

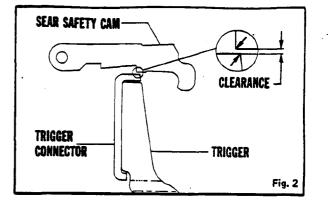
NOTE: Lubrication should not be used as a remedy for trigger housing assembly problems. The cause should be positively located and corrected.

When repairing trigger housing assembly wash parts thoroughly with a petroleum solvent. An accumulation of gun oil or dried oil can build a film that may cause malfunctions. Relubricate with a dry lubricant and reassemble. Check clearance between trigger and trigger connector .010 MAX. slip fit (MIN.) with feeler gage (see Fig. 1). Check trigger connector for straightness and cracks at trigger stop screw hole. Make sure there is no bind or catch in trigger, sear safety cam or safety lever about pivots.

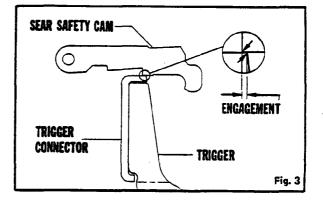


When replacing trigger housing assembly, take care not to bend or spring the housing. Sear safety cam should pivot freely. To check, remove bolt, move safety to OFF SAFE, pull trigger and press down on rear of sear safety cam and release.

For proper safety function there must be clearance between trigger connector and sear safety cam. To check close bolt and put safety ON SAFE. Visually inspect through hole in side of trigger housing (see Fig. 2). If there is no clearance, replace safety assembly, or trigger housing assembly. Corners must be sharp. (Arrows).



Sear safety cam and trigger connector engagement of .015'' - .020'' on field rifles and .010'' - .015'' on target rifles is critical (see Fig. 3). Replace any worn or damaged parts. To adjust, close bolt and place safety OFF SAFE. Turn trigger engagement screw clockwise until rifle fires. Turn screw counterclockwise 't turn (90°) and check engagement. (see note A). Corners must be sharp. (Arrows).



To adjust trigger stop screw, close bolt and put safety OFF SAFE. Turn trigger stop screw clockwise until it touches trigger. Pull and hold trigger rearward. Turn trigger stop screw counter clockwise until rifle fires. Turn an additional 1/8 turn for clearance. (see note A).

Trigger pull adjustment on any field rifle should never be adjusted below three (3) pounds. (see note A).

Trigger pull adjustment on any target rifle should never be adjusted below two (2) pounds. (see note A).

NOTE A: After any adjustments to trigger housing assembly screws, repeat all safety checks. Check for "follow down." See malfunctions. Restake or reseal screws with DuPont Duco cement.

When replacing stock assembly, check for clearance between following parts: Safety Lever - Stock; Trigger - Trigger Guard; Trigger - Stock.

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# MODELS 725-721-722-700-600

#### MALFUNCTIONS

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- "Follow Down." After reassembling rifle, check for "follow down" condition. (Firing pin moves to uncocked position as bolt is closed). Put safety OFF SAFE. Close bolt smartly. Firing pin should remain cocked (dry fire to check). "Follow down" may be caused by improper sear safety cam - trigger connector engagement or by trigger being held back by interference between trigger and stock, trigger and trigger guard, and / or trigger housing. "Follow down" can also be caused by sear safety cam binding, by missing parts and / or broken connector. (see note B).
- 2. "Firing Pin Falls." If firing pin falls when rifle is jarred or when bolt handle is lifted check following:

Firing pin head binds in guide slot in receiver. Firing pin head and slot should align. To check, remove firing pin assembly from bolt. Reassemble bolt to receiver. Small cocking notch on rear edge of bolt should align with slot in receiver.

Guide slot in receiver should be free of burrs. Remove trigger housing and clean any burrs from slot.

This malfunction may also be caused by improper sear safety cam - trigger connector engagement. Adjust engagement as previously described. (see note B).

3. "Firing Pin Fails to Fall." If firing pin fails to fall when trigger is pulled or trigger has to be pulled more than once. See firing pin falls for possible cause and corrections. (see note B).

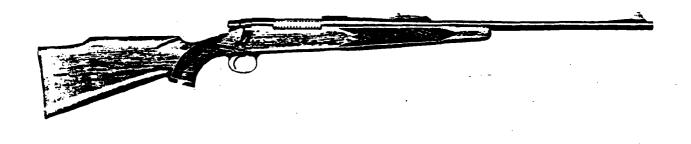
NOTE B: Correct malfunction 100% or return rifle to factory.

For smooth operation, a good quality gun grease should be applied to threads on bolt plug, firing pin head cocking cam at rear of bolt and on locking lug engagement area.

JPL-RES. 3-76

# REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied — ADL (standard) and BDL. Included in the BDL grade is the model 700 VARMINT — an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The instruction folder RD-5461 is packaged with each new rifle. Folders may also be obtained from the retailer or dealer. This folder outlines operating instructions, instructions for care and maintenance of the rifle and a complete parts list. When handling rifle for servicing or shipping make certain rifle is empty with no rounds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS. COMPANY, INC. Arms Service Division Illian, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602 Page

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#### BOLT FINAL ASSEMBLY

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To Disassemble — With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

**To Service** — Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as passible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY — COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

#### EJECTOR — EJECTOR PIN — EJECTOR SPRING (in bolt assembly)

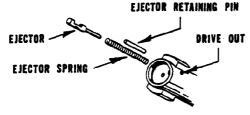


FIG. 1

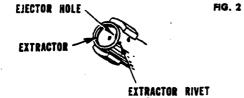
To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. See Fig. 1.

To Reassemble — Insert ejector spring and ejector into bolt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

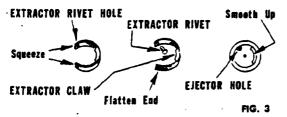
Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR --- EXTRACTOR RIVET (in bolt assembly)

To Disassemble—Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.



To Service — Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble—Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. See Fig. 3. Straighten tail of extractor. See Fig. 3. Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

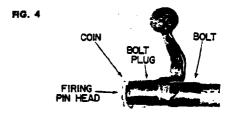
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

Aften tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

#### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

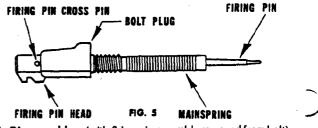
**To Disassemble** — Remove bolt final assembly from rifle. Pull firing pin head rearward until coin or washer can be inserted into slot near back edge of firing pin head. See Fig. 4. Unscrew and remove firing pin assembly from bolt assembly.



**To Service** — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble — Follow reverse order.

FIRING PIN ASSEMBLY — COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.



To Disassemble-(with firing pin assembly removed from bolt).

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Caution: Main spring is under compression. Disassembly of this unit is not recommended unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. See Fig. 5. Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble — Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

REAR SIGHT ASSEMBLY (includes rear sight collar, rear sight eyepiece, rear sight leaf, rear sight windage screw).

To Disassemble — Unscrew and remove rear sight screw. Remove rear sight assembly from rear sight base.

To Service — Interchangeable with no factory adjustment required. Replacement as a unit is recommended.

To Reassemble — Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

#### **REAR SIGHT STEP**

To Disassemble—Grasp and lift rear sight eyepiece and slide rear sight step rearward.

To Service — Interchangeable. Additional steps, marked for size, are available for range purposes.

To Reassemble — Follow reverse order. Large end of step should face forward.

#### REAR SIGHT BASE

To Disassemble — Remove rear sight assembly and rear sight step. Unscrew and remove rear sight base screws, washer and base.

To Reassemble — Follow reverse order.

FRONT SIGHT HOOD (BDL Grade only)

To Disassemble — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base.

To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble — Follow reverse order.

#### FRONT SIGHT

To Disassemble — Drive front sight out of front sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble --- Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble --- Follow reverse order.

#### TRIGGER GUARD (ADL Grade)

To Disassemble — Unscrew and remove trigger guard screws and disassemble trigger guard from stock.

To Reassemble --- Follow reverse order.

#### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble --- Remove bolt assembly. Unscrew and remove

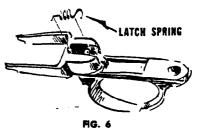
front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly. Note: To remove magazine follower and spring (assembled

Note: To remove magazine follower and spring (assembled to floor plate), unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble --- Follow reverse order. Tighten screws firmly.

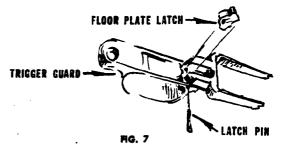
TRIGGER GUARD ASSEMBLY—COMPONENTS (BDL Grade) includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

**To Disassemble** — Drive out floor plate pivot pin and remove floor plate from trigger guard.



**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to front section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard. See Fig. 6.



Drive out floor plate latch pin — left to right and remove floor plate latch from trigger guard. See Fig. 7.

To Reassemble — Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE — MAGAZINE FOLLOWER — MAGAZINE SPRING

To Disassemble — Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stock assembly. Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting from receiver.

#### To Reassemble — Follow reverse order.

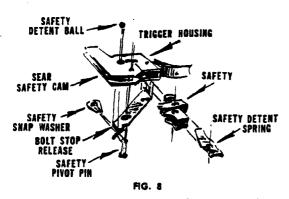
BOLT STOP --- BOLT STOP SPRING --- BOLT STOP PIN

To Disassemble — Remove bolt final assembly and stack assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

To Reassemble — Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place balt stop in slot with contoured edge facing up and hole to rear. Align holes and arive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble — Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove



bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. See Fig. 8.

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

To Reassemble — Follow reverse order. Safety assembly and boit stop should pivot freely.

#### TRIGGER ASSEMBLY

To Disassemble — Remove bolt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety cam.

To Service — Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connector-sear engagement may be required.

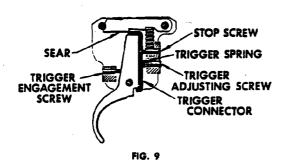
To Reassemble — Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: includes bolt stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

To Disassemble — Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

To Service — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble — Place trigger connector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring



and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

#### TRIGGER ADJUSTMENT. See Fig. 9.

Remove stock assembly and trigger guard.

IMPORTANT: Adjustment or removal of trigger engagement screw (behind trigger) is **not recommended** unless for replacement. This screw is factory adjusted to provide correct amount af trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger—is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clockwise for heavier weight of pull and counter clockwise for lighter pull.

Travel of Trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

#### STOCK ASSEMBLY

To Disassemble — Remove trigger guard or trigger guard assembly and remove stock assembly.

To Reassemble — Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY — COMPONENTS (ADL Grade) includes butt plate, butt plate screw (2), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble.— Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

**To Reassemble**—Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

STOCK ASSEMBLY — COMPONENTS (BDL Grade) includes ADL grade components plus butt plate spacer, fore end tip, fare end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble — See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble — Follow reverse order.

**BARREL ASSEMBLY**—Includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE:

Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q. D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7's" wide. Swivel assemblies are (Q. D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and front swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

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# CYCLE OF OPERATION

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action —completing the cycle. Each operation is described in sequence below:

#### FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

#### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

#### EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately  $V_8$ " with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

#### EJECTION

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with apposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the action, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY

The safety, located at right rear of receiver, is operated by a push and pull action on the safety button. This two-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

# MALFUNCTIONS

### **Cause and Correction**

#### Over-Ride

- Cause: 1. Magazine Follower binds.
  - Damaged Follower Spring.
    - 3. Magazine Spring caught under Guard.
    - 4. Tabs on Follower bent.
- Correction: 1. Adjust side angle on Magazine Box.
  - 2. Change Spring.
    - 3. Correct.
    - 4. Straighten or replace Follower.

#### Stems Chamber

Cause:	1.	Sharp	or	rough	Receiver	Rails.	

- Sharp edge rear end of Chamber.
- 3. Rough Ramp in Receiver.
  - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - Remove sharpness.
    - 3. Polish Ramp.
    - 4. Adjust.

#### **Boit Closes Hard Over Shells**

- Cause: 1. Bolt interferes with shell rim.
  - 2. Extractor interferes with shell rim.
    - 3. Ejector binds or fails to retract far enough.
    - 4. Burr at Ejector Hole on Bolt,
    - 5. Sharp corners on Bolt Lugs.
    - 6. Extractor Rivet loose.
- Correction: 1. Remove interference or change Bolt.
  - Fit new Extractor (grind relief in new Extractor behind Claw).
    - 3. Free up or replace.
  - 4. Deburr.
  - File radius.
  - 6. Tighten or replace Rivet.

#### **Fails to Extract**

- Cause: 1. Tight, rough or oversize Chamber.
  - Extractor broken or damaged.
    - 3. Not enough Hook space on Extractor.
    - 4. Height of Claw not correct.
    - 5. Extractor stuck back.

Correction: 1. Ream if tight or rough.

- Change Barrel Assembly if oversize.
- 2. Fit new Extractor.
- 3. Fit new Extractor.
- 4. Fit new Extractor.
- 5. Replace Extractor. (Continued on page 8)

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# REMINGTON FIELD SERVICE MANUAL

PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART	
IOTE:	Basic 30	-06 Caliber listed below, See Sectional View for proper		15752	Magazine Follower, BDL Grade	
	identity	of parts. See added page for other caliber part listings.		15940	Magazine Tab Screw (ADL Grade)	
1 }		Barrel Assembly	34	17028	Magazine Spring	
2		Bolt Assembly		15677	Magazine Spring, BDL Grade	
-		Bolt Final Assembly	35	17029	Main Spring	
3	17012	Boit Plug	36	26355	Rear Guard Screw	
4	17013	Bolt Stop	37	32510	Rear Sight Aperture	
5	24475	Boit Stop Pin	38	32500	Rear Sight Base -	
6	15478	Boit Stop Release	39	28505	Rear Sight Base Screw (2)	
7	15224	Bolt Stop Spring	40	90905	Rear Sight Slide	
8	14472	Butt Plate	41	90906	Elevation Screw	
9	25410	Butt Plate Screw	42	90904	Windage Screw	
10	15287	Center Guard Screw, ADL Grade	43	15358	Rear Swivel Screw, BDL Grade	
11	17017	Elector	44	17034	Réceiver Plug Screw	
12	17676	Ejector Pin	45	26585	Safety Assembly	
13	17019	Ejector Spring	46	23222	Safety Detent Ball	
14	14669	Extractor	47	15368	Safety Detent Spring	
15	27340	Extractor Rivet	48	17043	Safety Pivot Pin	
-	15376	Fastener, Sling Strap	49	17044	Safety Snap Washer	
16	22020	Firing Pin	50	15666	Sear Safety Cam	
17	22040	Firing Pin Assembly	51	24476	Sear Pin	
18	17022	Firing Pin Cross Pin	52	17047	Sear Spring	
19	19800	Floor Plate, BDL Grade	53	30855	Sling Strap Assembly, BDL Grade	
20	15291	Floor Plate Latch, BDL Grade		26990	Sling Strap Assembly and Mountings Complete	
21	16451	Floor Plate Latch Pin, BDL Grade	54	26381	Stock Assembly, ADL Grade	
22	16452	Floor Plate Latch Spring, BDL Grade		26401	Stock Assembly, BDL Grade	
23	16453	Floor Plate Pivot Pin, BDL Grade		18186	Stock Reinforcing Screw (not shown)	
24	22035	Front Guard Screw	i	16970	Stock Reinforcing Screw Dowel (not shown)	
25	15161	Front Guard Screw Bushing, ADL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)	
26	15373	Front Sight	56	15280	Trigger	
	15719	Front Sight (Low)	57	17053	Trigger Adjusting Screw	
27	28510	Front Sight Ramp		26345	Trigger Assembly	
~	15635	Front Sight Ramp, BDL Grade	58	19461	Trigger Connector	
28	28505	Front Sight Ramp Screw	59	17053	Trigger Engagement Screw	
29	15363	Front Sight Hood, BDL Grade	60	15281	Trigger Guard	
30	15353	Front Signt Hood, BDL Grade	61	26376	Trigger Guard, BDL Grade	
31	15356	Front Swivel Screw, BDL Grade		26371	Trigger Guard Assembly, BDL Grade	
.	15331	Grip Cap, BDL Grade (not shown)	62	26655	Trigger Housing Assembly	
	30505	Grip Cap Spacer, BDL Grade (not shown)	63	24477		
32	15284	Magazine, ADL Grade	64	15400	Trigger Spring	
~	16430	Magazine, BDL Grade (not shown)	65	15481	Trigger Stop Screw	
33	17024	Magazine, BDL Grade (not shown) Magazine Follower		1		

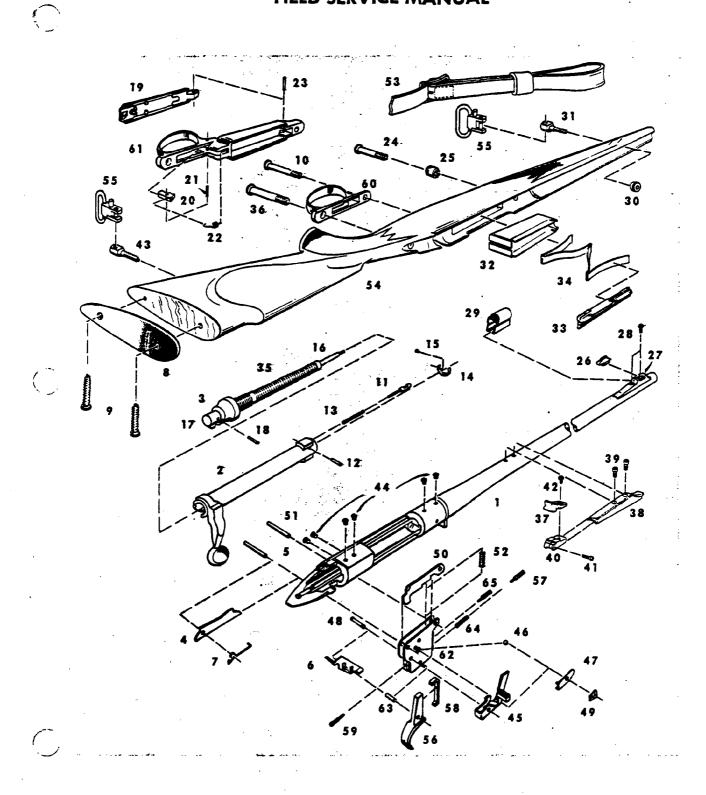
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Parts Subject to Change Without Notice

SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



# ADDITIONAL CALIBERS (Not Shown in Sectional View) INCLUDES VARMINT MODEL

# REMINGTON FIELD SERVICE MANUAL

MODEL 700

#### Note: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

5850 7341 7342 2021 2041 6434 2037 6204	Extractor, 7mm Rem., Mag., 264-300 Win, Mag. Extractor, 222-223 Rem., 17 Rem. Extractor Rivet, 7mm Rem. Mag., 264-300 Win, Mag. Extractor Rivet, 222 Rem., 223 Rem., 17 Rem. Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem. Firing Pin Assembly, 222 Rem., 17 Rem. Fior Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem. Front Guard Screw, 222 Rem., 223 Rem., 243 &	33375 26375 26370 26370 27265 27265 15709	Stock Assembly, Varmint, BDL Grade, 25-06 Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem. Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.,223 Rem.,243 Win.,308 Win.,6mm Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM Batrel Assembly, 375 H&H Mag.
5850 7341 7342 2021 2041 6434 2037 6204	<ul> <li>Extractor, 222-223 Rem., 17 Rem.</li> <li>Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.</li> <li>Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.</li> <li>Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.</li> <li>Firing Pin Assembly,222 Rem., 17 Rem.243 Win., 308 Win.,6mm Rem., 22-250 Rem., 223 Rem.</li> <li>Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 &amp; 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.</li> </ul>	26370 27265 27266	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem. Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem.,223 Rem.,243 Win.,308 Win.,6mm Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
7341 7342 2021 2041 6434 2037 6204	<ul> <li>Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.</li> <li>Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.</li> <li>Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.</li> <li>Firing Pin Assembly,222 Rem., 17 Rem.243 Win., 308 Win.,6mm Rem.,22-250 Rem., 223 Rem.</li> <li>Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 &amp; 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.</li> </ul>	27265 27266	17 Rem. Trigger Guard Assembly, 8DL Grade, 222 Rem., 17 Rem.,223 Rem.,243 Win.,308 Win.,6mm Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
7342 2021 2041 6434 2037 6204	Mag. Extractor Rivet, 222 Rem., 223 Rem., 17 Rem. Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem. Firing Pin Assembly,222 Rem., 17 Rem.243 Win., 308 Win.,6mm Rem.,22-250 Rem.,223 Rem. Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27265 27266	Trigger Guard Assembly, 8DL Grade, 222 Rem., 17 Rem.,223 Rem.,243 Win.,308 Win.,6mm Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
2021 2041 6434 2037 6204	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem. Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem. Firing Pin Assembly,222 Rem.17 Rem.243 Win., 308 Win.,6mm Rem.,22-250 Rem.223 Rem. Fioor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27265 27266	17 Rem.,223 Rem.,243 Win.,308 Win.,6mm Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
2021 2041 6434 2037 6204	<ul> <li>Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.</li> <li>Firing Pin Assembly,222 Rem.17 Rem.243 Win., 308 Win.,6mm Rem.,22-250 Rem.223 Rem.</li> <li>Fioor Plate, BDL Grade, 222 Rem., 223 Rem. 243 &amp; 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.</li> </ul>	27266	17 Rem.,223 Rem.,243 Win.,308 Win.,6mm Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
2041 6434 2037 6204	Mag., 22-250 Rem., 223 Rem., 17 Rem. Firing Pin Assembly,222 Rem.17 Rem.243 Win., 308 Win.,6mm Rem.,22-250 Rem.223 Rem. Fioor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27266	Rem., 22-250 Rem. CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
6434 2037 6204	Firing Pin Assembly,222 Rem.17 Rem.243 Win., 308 Win.,6mm Rem.,22-250 Rem.223 Rem. Fioor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27266	CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
6434 2037 6204	308 Win.,6mm Rem.,22-250 Rem.223 Rem. Fioor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27266	
2037 6204	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27266	barrel Assembly, 373 han Mag.
2037 6204	243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.		
6204	17 Rem.	1 13/09	Barrel Assembly, 458 Win. Mag.
6204	•	1 _	Extractor
6204	Front Guard Screw, 222 Nem., 223 Nem., 243 de	16771	Frant Sight, 375 H&H Mag.
		23805	Front Sight, 458 Win. Mag.
	308 Win.,6mm Rem.,22-250 Rem.,17 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as
	Front Scope Base, Varmint		standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used
	Front Sight, 7mm Rem. Mag., 264 Win. Mag.		DISCONTINUED or SERVICE PARTS
	Front Sight Ramp, ADL Grade Front Sight Ramp, BDL Grade	26270	Barrel Assembly, 280 Rem.
	Magazine, ADL Grade, 222 Rem.	20467	Extractor, 222 Cal.
	Magazine, BDL Grade, 222 Rem., 223 Rem.,	17639	Ejector, 222 Cal.
	17 Rem.	16717	• •
5283	Magazine, ADL Grade, 243 & 308 Win., 6mm		Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
	Rem. 22-250 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win. BDt Grado
5715	Magazine, BDL Grade, 243 & 308 Win., 6mm	94444	Rem. Mag., 243 Win., BDL Grade
	Rem. 22-250 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
4756	Magazine, BDL Grade	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag.,
1018	Magazine Follower, 222 Rem.	19025	222 Rem., 222 Rem. Mag., 243 Win.
0982	Magazine Follower, 243 & 308 Win., 6mm Rem.	19023	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
	22-250 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear
	Magazine Spacer, 222 Rem.		Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear
	Magazine Spacer, 222 Rem., BDL Grade		Sight Step, Rear Sight Washer (2)
	Magazine Spacer,223 Rem., BDL Grade, 17 Rem.		
	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		
7891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		
5698	Magazine Spring, 22-250 Rem.		
5699	Magazine Spring, 22-250 Rem., 6mm Rem., 243	ļ	
	Win., BDL Grade	}	
7058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win., 17 Rem.		
8843	Rear Scope Base, Varmint	ļ	
	Recoil Pad, 7mm Rem.Mag.264 & 300 Win.Meg.	1	
5410	Recoil Pad Screw,7mm Rem.Mag.,264 & 300 Win, Mag,		
3842 3	Scope Base Screw, Rear Vermint		
	Scope Base Screw, Front Varmint		
	Stock Assembly, 7mm Rem. Mag., ADL Grade		
	Stock Assembly, 222 Rem., 243 Win., 308 Win.,		
	6mm Rem., 22-250 Rem., ADL Grade		
3385	Stock Assembly,7mm, Rem.Mag.,264–300 Win.		
	Mag., BDL Grade		
3370	Stock Assembly,222 Rem.,243 Win.,308 Win.		
	6mm Rem.,22-250 Rem.,8DL Grade,17 Rem.	1	
3376	· · · ·	j	
570 3	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.	1	
	229 Actor,249 Min.0080 Actor,22.490 ACM.	ļ	

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Parts Subject to Change Without Notice

# **MALFUNCTIONS**

## CAUSE and CORRECTION

## (Con't. from Page 4)

#### **Fails to Eject**

Cause:

1. Burr at Ejector Hole in Bolt.

- 2. Ejector binds or fails to retract far enough.
  - 3. Extractor Rivet loose.
- 4. Extractor drops shell.

#### Correction: 1. Deburr.

- 2. Free up or replace.
- 3. Re-stake or replace.
- 4. Replace Extractor.

## Misfires Cause:

- 1. Short Firing Pin (damaged).
  - 2. Firing Pin binds.
  - 3. Short Firing Pin protrusion.
  - 4. Firing Control out of adjustment.
  - 5. Faulty ammunition.

#### Correction: 1. Replace.

- 2. Free up or replace.
- 3. Change Firing Pin or Bolt.
- 4. Adjust.

#### **Follows Down**

- Cause:
- Trigger Adjusting Screw, rear, out of adjustment (improper horizontal engagement of Sear and Connector).
- 2. Improper vertical engagement of Sear and Connector.
- 3. Trigger doesn't retract.
- 4. Corners on Sear or Connector rounded.
- 5. Trigger binds on Trigger Plate.
- 6. Not enough tension on Weight Screw (light pull).

### Correction: 1. Adjust.

- 2. Fit new Fire Control.
- 3. Fit new Fire Control,
- 4. Fit new Fire Control.
- 5. File eliminate interference.
- 6. Adjust.

#### Bolt Opens Hard

- Cause: 1. See Fails to Extract.
  - 2. Upset Extraction Cam on Bolt Handle,
  - 3. Burr at Ejector Hole in Bolt.
  - 4. Blown or set back Primer on shell.
- Correction: 1. See Fails to Extract.
  - 2. Smooth up.
  - 3. Deburr.
  - 4. Ream Chamber if throat is shallow (ammunition may be at fault).

### **Bolt Pulls Out**

Cause:	1.	Bolt Stop or Bolt Release binds.
		Bolt Stop or Bolt Release broken.

- Correction: 1. Free up.
  - 2. Replace.

### Safe Works Too Hard or Too Freely

- Cause: 1. Safe binds (works hard).
  - Safety Snap Washer stretched out (Safe works too freely).
- Correction: 1. Free up.
  - 2. Replace Washer.

#### Buiges or Blows Cases

- Cause: 1. Oversize Chamber.
  - Maximum head space.
- Correction: 1. Change Barrel or Barrel and Receiver Assembly.
  - 2. Fit new Bolt (ammunition may be at fault).

#### **Bolt Binds**

- Cause: 1. Guard Screws protrude into Bolt track.
  - Scope Screws protrude into Bolt track.
    - 3. Bolt Handle interference on Stock.
  - Step at rear of Solt Lugs.
- Correction: 1. File ends of Screws.
  - 2. File ends of Screws.
  - 3. Correct Stock or fit new Stock.
  - File to blend.

#### **Doesn't Group**

- Cause: 1. Crown of Barrel damaged.
  - Leading of Bore.
  - 3. Oversize Bore.
  - 4. Improper bedding of Barrel in Stock.
  - 5. Loose Sights.
- Correction: 1. Recrown.
  - 2. Lead or change Barrel.
  - 3. Change Barrel,
  - 4. Correct bedding
  - 5. Tighten or replace.

### **Point of Impact Not Correct**

Cause:

1. Barrel not straight.

- 2. Horns, breaks, etc. in Bore.
- 3. Improper or loose Sights.
- Correction: 1. Straighten.
  - 2. Correct if possible.
    - 3. Tighten or change Sights.

# PARTS LIST

# MODEL 700 LEFT HAND MODEL

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# REMINGTON FIELD SERVICE MANUAL

View No.	Pert No.	NAME OF PART
NOT	E: Basic	30-06 caliber listed below. For other caliber parts
	and	numbers see additional calibers list.
1		Barrel Assembly
2		Bolt Assembly
		Bolt Final Assembly
3	17012	Boit Plug
4	17013	Boit Stop
5	24475	Bolt Stop Pin
-6	90555	Bolt Stop Release
7	90554	Bolt Stop Spring
8	14472	Butt Plate
9	25410	Butt Plate Screw
10	17017	Ejector
11	17676	Ejector Pin
12	17019	Ejector Spring
13	14669	Extractor
14	27340	Extractor River
	15376	Fastener, Sling Strap
15 16	22020 22040	Firing Pin Assembly
17	17022	Firing Pin Cross Pin-
18	19800	Floor Plate
19	15291	Floor Plate Latch
20	16451	Floor Plate Latch Pin-
21	16452	Floor Plate Latch Spring
22	16453	Floor Plate Pivot Pin-
23	22035	Front Guard Scraw
24	15373	Front Sight-
	157 19	Front Sight (Low)
25	15635	Front Sight Ramp
26	28505	Front Sight Ramp Screw
27	15363	Front Sight Hood
28	15357	Front Swivel Nut-
29	15356	Front Swivel Screw
	15331	Grip Cap
	30505	Grip Cap Spacer
30	16430	Magazine Follower
31 32	15752 15677	Magazine Follower
33	17029	Magazine Spring
34	25355	Rear Guard Screw
35	32510	Rear Sight Aperture
36	32500	Rear Sight Base
37	28505	Rear Sight Screw
38	90905	Rear Sight Slide
39	90906	Elevation Screw
40	90904	Windage Screw
41	15358	Rear Swivel Screw
42	17034	Receiver Plug Screw
43	32900	Safety Assembly
44	23222	Safety Detent Ball-
45	90557	Safety Detent Spring
46	17043	Safety Pivot Pin-
47	17044	Safety Snap Washer
48	15666	Sear Safety Cam
49	24476	Sear Pin
50	17047	Sear Spring

	View Ne.	Part No.	NAME OF PART
	51	30655	Sling Strep Assembly-
ļ		26990	Sling Strap Assembly and Mountings Complete
	52	32890	Stock Assembly
		18186	Stock Reinforcing Screw
		16970	Stock Reinforcing Screw Dowel
i	53	26555	Swivel Assembly (Q. D.)
	54	15280	Trigger
	55	17053	Trigger Adjusting Screw
		32895	Trigger Assembly
ļ	56	19461	Trigger Connector
	57	17053	Trigger Engagement Screw-
	58	26376	Trigger Guard
		26371	Trigger Guard Assembly
	<del>59</del>	32905	Trigger Housing Assembly
ļ	60	24477	Trigger Pin-
	61	15400	Trigger Spring
ļ	62	15481	Trigger Stop Screw
	l		

### ADDITIONAL CALIBERS

NOTE: Part not listed same as 30-06 Caliber

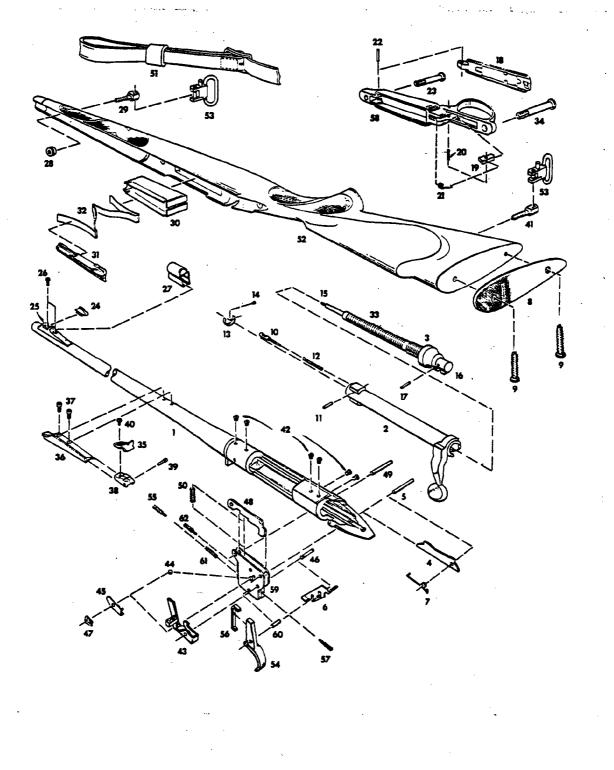
	Barrel Assembly, 7mm Rem. Mag
	Barrel Assembly, 270 Win.
32862	Bolt Assembly, 7mm Rem, Mag
15709	Extractor, 7mm Rem. Mag
27341	Extractor Rivet, 7mm Rem. Mag.
14659	Front Sight, 7mm Rem. Mag.
21387	Recoil Pad, 7mm Rem, Mag.
25410	Recoil Pad Screw, 7mm Rem. Mag.
32880	Stock Assembly, 7mm Rem. Mag.

EXPLODED VIEW

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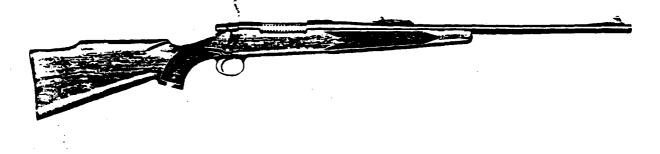
# REMINGTON FIELD SERVICE MANUAL

MODEL 700 LEFT HAND MODEL



# REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power bolt action repeater available in a wide variety of center fire calibers. Two grades are supplied — ADL (standard) and BDL. Included in the BDL grade is the model 700 VARMINT — an extremely accurate rifle expressly designed for the high velocity "varmint" calibers.



The instruction folder RD-5461 is packaged with each new rifle. Folders may also be obtained from the retailer or dealer. This folder outlines operating instructions, instructions for care and maintenance of the rifle and a complete parts list. When handling rifle for servicing or shipping make certain rifle is empty with no raunds in magazine or chamber. Unless described otherwise, parts are interchangeable with no factory adjustment required.

## INDEX

P	,ađe
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Front Sight Ramp	
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Send all guns for factory service and inquiries an service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

### SOLT FINAL ASSEMBLY

To Disassemble — With safety forward on FIRE position, lift bolt handle and pull rearward until action is halted by bolt stop. Press upward on bolt stop release — located in front of trigger and remove bolt final assembly from rifle.

To Service — Selective assembly at factory is required for replacement of bolt assemblies. However, firing, cocking, extractor and ejection parts are interchangeable and may be replaced with no factory adjustment required.

To Reassemble — With safety forward, insert bolt final assembly into rifle, push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

BOLT FINAL ASSEMBLY — COMPONENTS: Includes bolt assembly, ejector, ejector pin, ejector spring, extractor, extractor rivet, firing pin assembly. Firing pin assembly includes bolt plug, firing pin, firing pin cross pin, firing pin head and main spring.

#### EJECTOR — EJECTOR PIN — EJECTOR SPRING (in bolt assembly)

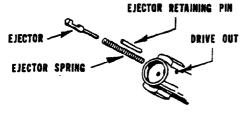


FIG. 1

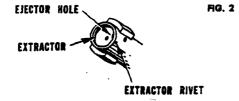
To Disassemble — With bolt final assembly removed from rifle, drive out ejector pin and pull ejector spring from bolt. See Fig. 1.

To Reassemble — Insert ejector spring and ejector into balt. Push ejector and hold against tension of ejector spring. Align ejector pin slot in ejector to pin hole in bolt and drive in ejector pin.

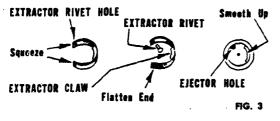
Note: Assembled ejector must work freely in bolt for proper ejection.

EXTRACTOR --- EXTRACTOR RIVET (in bolt assembly)

To Disassemble—Disassemble ejector and ejector spring from bolt.



Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.



To Service — Parts are interchangeable. Extractor rivet will most likely be damaged when driven from bolt and replacement rivet should be used in reassembly.

To Reassemble—Adjust replacement extractor for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. See Fig. 3. Straighten tail of extractor. See Fig. 3. Place extractor inside rim in bolt face. Align hole in extractor with rivet hole in bolt. Insert extractor rivet.

Note: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary.

Place support inside of bolt rim and against head of rivet. Peen over protruding end of rivet to tighten extractor in bolt. Reassemble ejector. Smooth up peening to blend with outside of bolt. Check extractor for proper tension using a fired case. Extractor must grip case firmly and hold case when breech is held face downwards.

If fired case is gripped too tightly (case snaps free with difficulty) tap extractor back under bolt rim using a soft metal punch. Test with fired case. Repeat, if necessary, until gripping pressure of extractor is satisfactory.

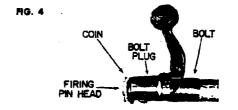
If fired case is gripped too loosely (case falls away when bolt is held face downward) extractor must be pulled from under rim to increase tension against case. Disassemble, if necessary, and rebend extractor as indicated in Fig. 3.

Aften tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breach bolt rim. See Fig. 3.

Note: An earlier design, in 222 caliber, incorporated a "snap in" type extractor requiring no rivet. These may easily be disassembled and reassembled by inserting pointed tweezers into holes provided in ends of extractor and compressing ends together. When reassembling, hook on extractor should face bolt.

### FIRING PIN ASSEMBLY FROM BOLT ASSEMBLY

To Disassemble — Remove bolt final assembly from rifle. Pull firing pin head rearward until cain ar washer can be inserted into slot near back edge of firing pin head. See Fig. 4. Unscrew and remove firing pin assembly from bolt assembly.

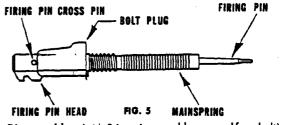


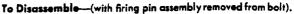
To Service — Firing pin assembly is interchangeable and may be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

To Reassemble - Follow reverse order.

1

FIRING PIN ASSEMBLY — COMPONENTS: Includes bolt plug, firing pin, firing pin cross pin, firing pin head, main spring.





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**Caution:** Main spring is under compression. Disassembly of this unit is **not recommended** unless necessary for replacement of damaged parts. Suitable holding means must be used to prevent firing pin and/or firing pin head from flying free when cross pin is driven out.

Compress mainspring until firing pin cross pin is exposed. Hold firing pin and firing pin head securely and drive out cross pin. See Fig. 5. Release parts carefully and disassemble.

To Service – All parts in firing pin assembly are interchangeable with no factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093).

Assemble shank of replacement firing pin into firing pin head. Make sure recess in head is clean and free of any obstructions. Seat shank of firing pin firmly onto firing pin head. Align drill through cross pin hole in firing pin head. Drill through firing pin shank.

To Reassemble — Reassemble all parts of firing pin assembly. Hold bolt plug against tension of reassembled main spring. Insert firing pin cross pin through firing pin head and shank of firing pin. Release tension on bolt plug.

**REAR SIGHT ASSEMBLY** (includes rear sight collar, rear sight eyepiece, rear sight leaf, rear sight windage screw).

To Disassemble — Unscrew and remove rear sight screw. Remove rear sight assembly from rear sight base.

To Service — Interchangeable with no factory adjustment required. Replacement as a unit is recommended.

To Reassemble — Place bent tabs on bottom of rear sight assembly into slot in rear sight base. Align holes, assemble and tighten rear sight screw.

### **REAR SIGHT STEP**

To Disassemble—Grasp and lift rear sight eyepiece and slide rear sight step rearward.

To Service — Interchangeable. Additional steps, marked for size, are available for range purposes.

To Reassemble — Follow reverse order. Large end of step should face forward.

#### **REAR SIGHT BASE**

To Disassemble — Remove rear sight assembly and rear sight step. Unscrew and remove rear sight base screws, washer and base.

To Reassemble --- Follow reverse order.

FRONT SIGHT HOOD (BDL Grade only)

**Te Disassemble** — Pry bottom ears of hood apart slightly until hood can be slid forward and away from front sight base.

To Service — Interchangeable on all BDL grade front sight ramps. No factory adjustment required.

To Reassemble — Follow reverse order.

#### FRONT SIGHT

To Disassemble — Drive front sight out of frant sight ramp from left to right. To prevent damage to sight a soft metal punch should be used.

To Reassemble — Follow reverse order.

#### FRONT SIGHT RAMP

To Disassemble — Unscrew and remove front sight ramp screws and front sight ramp.

To Reassemble --- Follow reverse order.

TRIGGER GUARD (ADL Grade)

To Disassemble — Unscrew and remove trigger guard screws and disassemble trigger guard from stock.

To Reassemble — Follow reverse order.

### TRIGGER GUARD ASSEMBLY (BDL Grade)

To Disassemble—Remove bolt assembly. Unscrew and remove

front and rear guard screws. Lift loosened stock assembly from trigger and disassemble trigger guard from stock assembly.

Note: To remove magazine follower and spring (assembled to floor plate) unlatch floor plate. Lift folded end of spring upward, pull back and disassemble from floor plate.

To Reassemble — Follow reverse order. Tighten screws firmly.

TRIGGER GUARD ASSEMBLY—COMPONENTS (BOL Grade) includes floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

**To Disassemble** — Drive out floor plate pivot pin and remove floor plate from trigger guard.

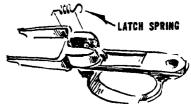
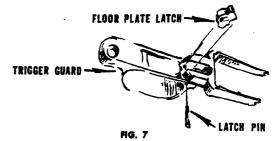


FIG. 6

**Caution:** Pivot pin is tight fitting. Support trigger guard properly to prevent damage to frant section.

Unhook rear of floor plate latch spring from floor plate latch and front end of spring from trigger guard. Remove spring from guard. See Fig. 6.



Drive out floor plate latch pin — left to right and remove floor plate latch from trigger guard. See Fig. 7.

**To Reassemble** — Follow reverse order. Floor plate should swing freely and latch properly.

# MAGAZINE — MAGAZINE FOLLOWER — MAGAZINE SPRING

To Disassemble — Remove bolt final assembly. Remove trigger guard or (in BDL grade) trigger guard assembly. Remove stack assembly, Remove magazine follower and spring. Unscrew magazine tab screw (ADL grade only) and remove magazine. BDL grade magazines are disassembled by simply lifting fram receiver.

To Reassemble — Follow reverse order.

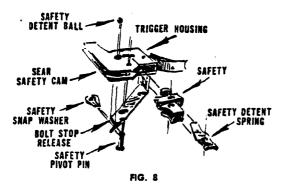
#### BOLT STOP - BOLT STOP SPRING - BOLT STOP PIN

**To Disassemble** — Remove bolt final assembly and stock assembly. Drive out bolt stop pin and remove bolt stop and bolt stop spring.

To Reassemble — Place bolt stop spring in recess in bottom left side of receiver. Long end of spring should face forward with bent end facing outward. Place bolt stop in slot with contoured edge facing up and hole to rear. Align holes and drive in bolt stop pin. When bolt stop release is pressed bolt stop should pivot freely.

#### SAFETY ASSEMBLY

To Disassemble — Remove bolt final assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower and spring. Drive out bolt stop pin and remove



bolt stop and spring. Disassemble safety snap washer and safety detent spring. Drive out safety pivot pin and remove safety assembly and safety detent ball. See Fig. 8.

Note: Trigger housing will pivot on sear pin when bolt stop pin is removed. Take care that sear spring (beneath sear safety cam) is not lost. Bolt stop release may also be removed at this time.

**Te Reassemble** — Follow reverse order. Safety assembly and bolt stop should pivot freely.

#### TRIGGER ASSEMBLY

To Disassemble — Remove balt stop pin, bolt stop and spring. Drive out sear pin and remove trigger assembly, sear spring and sear safety cam.

To Service — Trigger assembly may be replaced as a complete unit with no factory adjustment required (see trigger assembly components for listing). Readjustment of trigger connector-sear engagement may be required.

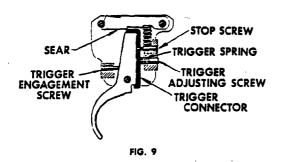
To Reassemble — Follow reverse order. Make sure sear spring is reassembled to function properly beneath sear safety cam.

TRIGGER ASSEMBLY COMPONENTS: includes boit stop release, trigger housing assembly, safety assembly, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear safety cam, sear spring, trigger, trigger adjusting screw, trigger connector, trigger engagement screw, trigger pin, trigger spring, trigger stop screw.

To Disassemble — Remove trigger assembly. Disassemble sear safety cam, sear spring, safety assembly and bolt stop release. Unscrew and remove trigger engagement screw, trigger stop screw, trigger adjusting screw and trigger spring. Drive out trigger pin and remove trigger and trigger connector.

To Service — All parts of trigger assembly are interchangeable. However, readjustment of trigger connector-sear engagement may be required (see trigger adjustment).

To Reassemble — Place trigger connector on trigger (longer tab on top). Place assembled trigger and connector into housing, align holes and tap trigger pin into housing until flush with right side. Reassemble trigger spring, trigger adjusting screw, trigger engagement screw, and trigger stop screw. Replace safety assembly and bolt stop release. Reassemble sear spring



and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseal or stake adjusting screws in place.

# TRIGGER ADJUSTMENT. See Fig. 9.

Remove stock assembly and trigger guard.

IMPORTANT: Adjustment or removal of trigger engagement screw (behind trigger) is not recommended unless for replacement. This screw is factory adjusted to provide correct amount of trigger connector-sear engagement. This engagement can be seen through hole in housing when safety is forward in FIRE position.

Note: All adjusting screws are factory sealed with cement. Pull of Trigger—is adjusted to desired weight by turning front trigger adjusting screw. Turn screw clockwise for heavier weight of pull and counter clockwise for lighter pull.

Travel of Trigger — is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver and cock action. Turn trigger stop screw clockwise until firing pin will not fall or fire rifle when trigger is pulled. Re-cock rifle and back off screw counter clockwise until firing pin will fall or fire rifle. This method of adjustment will allow least amount of trigger over travel.

#### STOCK ASSEMBLY

To Disassemble — Remove trigger guard or trigger guard assembly and remove stack assembly.

To Reassemble — Follow reverse order. Tighten screws securely.

STOCK ASSEMBLY — COMPONENTS (ADL Grade) includes butt plate, butt plate screw (2), front guard screw bushing, stock, stock reinforcing screw, stock reinforcing screw dowel. To Disassemble — Unscrew and remove butt plate screws and butt plate. Front guard screw bushing may be removed for replacement if necessary, by driving out with a tool from inside of stock. Tap against inner edge of bushing until it comes free from stock. Avoid damage to stock.

To Reassemble—Follow reverse order. Replacement butt plate may require edge sanding to match stock outline.

**STOCK ASSEMBLY** — **COMPONENTS** (BDL Grade) includes ADL grade components plus butt plate spacer, fore end tip, fore end tip spacer, grip cap, grip cap spacer, front swivel nut.

To Disassemble — See disassembly of ADL grade. Front swivel nut may be disassembled for replacement by carefully driving out from inside of stock.

To Reassemble --- Follow reverse order.

BARREL ASSEMBLY—Includes barrel, barrel bracket, receiver. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as a unit.

#### SLING STRAP ASSEMBLY AND MOUNTINGS, COMPLETE:

Includes front swivel nut, front swivel screw, rear swivel screw, sling strap assembly, swivel assembly, Q. D. (2).

Note: Sling Strap Assembly includes sling strap, fastener, keeper and buckle. Strap is 7s'' wide. Swivel assemblies are (Q. D.) type.

A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle — assemble both quick detachable (Q. D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

To attach strap to swivels — insert tongue of strap into rear swivel. Loop strap back and through attached keeper band. Insert strap into and through buckle and frant swivel. Loop back and secure with brass fastener. Adjust strap to desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

FGH - RES. 569

# CYCLE OF OPERATION

The operation cycle of the Model 700 follows the basic pattern of bolt action rifles. After firing, raising of bolt handle will unlock action. Pulling bolt rearward will open action and extract and eject any fired case or round that may be in chamber. Pushing bolt handle forward and down closes and locks action —completing the cycle. Each operation is described in sequence below:

#### FIRING

With action closed and locked and safety in forward or FIRE position, rifle can be fired by pulling trigger. Pulling or squeezing trigger moves trigger connector forward, leaving sear unsupported against cocked firing pin head. With support removed, sear is cammed down by pressure of spring-loaded firing pin and firing pin is driven forward to strike primer.

#### UNLOCKING

Raising of bolt handle unseats locking lugs on bolt head from recoil shoulders in receiver.

### COCKING

Cocking takes place as bolt handle is raised. A cam at rear of rotating bolt forces firing pin assembly rearward, compressing main spring, and holding assembly in cocked position in a notch at rear of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

#### EXTRACTION

This phase of operation cycle consists of two parts referred to as (1) primary extraction, and (2) secondary extraction. Primary extraction occurs simultaneously with unlocking. The rim of case, being completely encased by bolt head, is gripped by a circular recessed claw-type extractor. During final upward throw of bolt handle, a primary extraction cam retracts bolt approximately  $V_{\alpha}$ " with a mechanical advantage of about 8 to 1, completing primary portion of this phase. Bolt lugs are now free of locking shoulders in receiver and bolt may now be moved to rear completing second phase of extraction.

#### **EJECTION**

Within the bolt face, maintaining constant pressure on head of cartridge, is a spring-loaded ejector. As bolt is retracted and front edge of cartridge reaches ejection port, pressure, along with opposing grip of extractor, ejects cartridge from port. Rearward motion of bolt is arrested by bolt stop.

#### FEEDING

With bolt stopped in rearward position, topmost cartridge in magazine will be urged upwards by magazine spring. It is held in position until carried forward by bolt into loading cycle.

#### LOADING

In closing the actian, bolt pushes cartridge from magazine into barrel chamber. Feeding lips on top of magazine guide cartridge until bullet enters chamber.

#### LOCKING

Rotating bolt handle downward locks cartridge in barrel chamber. Four engagements are made in this cycle: (1) Locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head, depressing ejector while extractor claw is snapped over rim of cartridge. (3) Sear engages and locks firing pin in a cocked position by action of (4) Sear being supported from beneath by connector. Rifle is now ready for firing by release of trigger.

#### SAFETY

The safety, located at right rear of receiver, is operated by a push and pull action on the safety button. This twa-position safety has two internal functions. When safety is rotated rearward, a cam is brought into position beneath sear safety cam. This locks cam against firing pin and prevents rifle from firing. Second function of safety in SAFE position ("S" marking) brings an arm into slot in bolt preventing bolt from being opened. Pushing safety forward to FIRE position ("F" marking) nullifies above conditions and rifle may be fired.

# MALFUNCTIONS

### **Cause and Correction**

### Over-Ride Cause:

- Magazine Follower binds.
- 2. Damaged Follower Spring.
  - 3. Magazine Spring caught under Guard.
  - 4. Tabs on Follower bent.
- Correction: 1. Adjust side angle on Magazine Box.
  - 2. Change Spring.
    - 3. Correct.
    - 4. Straighten or replace Follower.

#### Stems Chamber

- Cause: 1. Sharp or rough Receiver Rails.
  - 2. Sharp edge rear end of Chamber.
  - 3. Rough Ramp in Receiver.
    - 4. Magazine Box loose in Receiver.
- Correction: 1. Polish or file.
  - Remove sharpness.
    - 3. Polish Ramp.
    - 4. Adjust.

#### **Boit Closes Hard Over Shells**

- Bolt interferes with shell rim.
- 2. Extractor interferes with shell rim.
  - 3. Ejector binds or fails to retract far enough.
  - 4. Burr at Ejector Hole on Bolt.
  - 5. Sharp corners on Boit Lugs.
  - 6. Extractor Rivet loose.
- Correction: 1. Remove interference or change Bolt.
  - Fit new Extractor (grind relief in new Extractor behind Claw).
    - 3. Free up or replace.
    - 4. Deburr.
    - 5. File radius.
    - 6. Tighten or replace Rivet.

### **Fails to Extract**

Cause

- Cause: 1. Tight, rough or oversize Chamber.
  - 2. Extractor broken or damaged.
  - 3. Not enough Hook space on Extractor.
  - 4. Height of Claw not correct.
  - 5. Extractor stuck back,

Correction: 1. Ream if tight or rough. Change Barrel Assembly if oversize.

- 2. Fit new Extractor.
- 3. Fit new Extractor.
  - 4. Fit new Extractor.
- 5. Replace Extractor.

(Continued on page 8)

# REMINGTON FIELD SERVICE MANUAL

PARTS LIST

identity of parts. See added page for other calibler part listings.       Image: Comparison of the set	View Ne.	Part No.	NAME OF PART	View. No.	Part No.	- NAME OF PART
1       24277       Borrel Assembly (includes Barrel, Barrel Backer, Rectiver)       38       16424       Reer Sight Base         2       2527       Bolt Assembly (includes Barrel, Barrel Backer, Rectiver)       10022       Reer Sight Stare (Seeve Mathematics)         2       2017       Bolt Rine Mitty (includes Barrel, Barrel Backer, Rectiver)       128097       Reer Sight Stare (Seeve Mathematics)         2       2017       Balt Rine Mitty (includes Barrel, Barrel Backer, Rectiver)       128097       Reer Sight Stare (Seeve Mathematics)         3       17012       Balt Stare, Sight Stare (Seeve Mathematics)       128097       Reer Sight Stare, Staremby (includes Safery, Safery Burton)         3       17012       Balt Stare, Felance       44       17034       Rees Sight Stare, Sameh Ball         6       15527       Balt Stare, Felance       46       17043       Safery Paren Ball         7       17014       Balt Stare, Fing       15464       Saer Safer, Came Mathematics         10       12287       Center Gueral Screw, ADL Grade       17043       Safery Paren Ball         11       17017       Safery Paren Ball       Mathematics       15124/66         12       Balt Stare, Fing Pin Heed, Main Spring       Stare Safer, Came Ball       15124/66         12       Saerre Safer, Came Ball	NOTE:			37	24525	Rear Sight Assembly (includes Rear Sight Collar, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw)
2     25327     Boit Assembly (includes Boit Bady Assembly and Boit Handle)     10023     Alter Sight Screet Bars Screet Bars Sight Screet	. 1		•	38	16454	Rear Sight Base
Hendie)         1943         Rear Sight Ster Case           2817         Bait Final Asambly (includes Boit Asambly, Ejector, Eircord Fin, Ejector Spring, Etroactor, Extractor River, Fining Pin Asambly)         1202         Rear Sight San Ster Sterw, SD Cande           3         17012         Boit Final Asambly         Boit Step         1338         Rear Sight San Sterw, SD Cande           3         17012         Boit Step         44         17038         Rear Sight San Sterw, SD Cande           5         24475         Boit Step Fin         44         17034         Rear Sight San Sterw, SD Cande           7         17014         Boit Step Spring         44         17033         Safety Potent Spring           8         14472         But Picte Screw         50         15666         Sear Spring           10         15287         Center Guard Screw, ADL Grade         51         24476         Safety Potent Science           11         17017         Ejector Spring         53         30855         Sing Strap Asambly, NDL Grade (includes Sing Strap           12         17047         Ejector Spring         53         30855         Sing Strap Asambly, NDL Grade (includes Sing Strap           13         17017         Ejector Spring         53         30855         Sing Strap Asambly, NDL Grade (includes				39	16023	Rear Sight Base Screw
26317     Bolt Find Assembly (includes Bolt Assembly, Firing Pin, Assembly)     1     20095     Reor Sight Yacher       1     10906     Reor Sight Yacher     1       1     10712     Bolt Stop Spring, Extractor, Extractor River, Firing Pin, Assembly)     1     13338     Reor Sight Yacher       1     107013     Bolt Stop Spring, Extractor, Extractor River, Firing Pin, Assembly     1     13338     Reor Sight Yacher       1     107013     Bolt Stop Pin     45     224525     Safety Assembly (includes Sofety, Safety Button)       2     12472     Bolt Stop Pin     46     13242     Safety Pines Fining       1     10717     Bolt Stop Spring     47     13366     Safety Pines Fining       1     10717     Exert Store     50     13646     Safety Pines       1     17017     Elector Fin     51     24476     Saer Pin       1     17017     Elector Fin     51     24476     Saer Pin       1     17017     Elector Fin     51     24476     Saer Pin       1     17024     Elector Fin     51     24476     Saer Pin       1     17025     Elector Fin     52     24476     Saer Pin       1     17026     Finds Fin Assembly (includes Saing Sarand Assembly, BDL Grade     2	2	26327		40	16456	Rear Sight Screw
Pin. Better Spring. Extractor. Extractor River, Firing Pin. Assembly421978Reor Swirel Screw, BDL Grade317012Bolt Rug4417034Recisew, BDL Grade524475Bolt Stop Pin4623252Safety Detent Ball615475Bolt Stop Palesce4713648Safety Poeten Ball717014Bolt Stop Spring4617034Safety Poeten Sell814472Burt Plote4713648Safety Poeten Sell924410Burt Plote Screw5015646Sear Safety Cam1013287Center Guard Screw, ADL Grade5124476Sear Safety Cam1117017Elector Pin5330855Sling Strop Assembly, BDL Grade Includes Sling Str Surra Assembly, BDL Grade Includes Burt Plote, Burth1117017Elector Spring5426381Stock Assembly, ADL Grade Includes Burt Plote, Burth1217027Elector Spring5426381Stock Assembly, ADL Grade Includes Burt Plote, Burth1317012Entractor5426381Stock Assembly, ADL Grade Includes Burt Plote, Burth1620200Fring Fin Assembly (includes Balt Plug, Fring Pin, Fring Ploter Plane, Bult BDL Grade5426381Stock Reinforcing Screw Dowel (not shown)1817022Feare Plane Inch, BDL Grade16770Stock Reinforcing Screw Dowel (not shown)1817022Fring Fin Cace In, Fring Pin Mead, Mon Spring)5426401Stock Reinforcing Screw Dowel (not shown)<	[	0/017		41	28095	Rear Sight Step (Selected Sizes)
Assembly4315358Reer Swirel Screw, BU Grade4117013Sah Plag4417024Reesiver Nug Screw, Softery, Softery Burton)5124475Sah Stop Fin452555Softery Assembly (Includes Saftery, Softery Burton)6115478Bolt Stop Release4715368Softery Desent Spring717014Bolt Stop Spring4917043Safery Prover Pin814472Burt Plots Screw5015464Sear Softery Cam711117017Elector Pin5124476Sear Pin1217027Elector Spring17047Sear Spring20001317017Elector Pin5330835Sling Strop Assembly, BDL Grade (Includes Sling Strop1317019Elector Rive2000Sing Strop Assembly, BDL Grade (Includes Burt Plotes, Burt Plote Strew, Sbut Stafter, Stock, Stock Reinforcing Strew Dowel)1412254Extractor2000Stock Asaembly, BDL Grade (Includes Burt Plotes, Burt Plote Strew, Sbut Stafter, Stock, Stock Reinforcing Strew Dowel)1527240Fining Pin Crase In, Firing Pin, Firing Pin, Firing Pin, Firing Pin Crase In, Firing Pin Crade2401117017Floor Plete, BDL Grade25Stock Reinforcing Strew Dowel)17018Floor Plete, BDL Grade25Stock Reinforcing Strew Dowel)17019Floor Plete, BDL Grade25Stock Reinforcing Strew Note Note Note Note17019Floor Plete, BDL Grade2515327Front Sight Romp17019Front		2031/		42	16968	Rear Sight Washer
3       17012       Sub Flug       44       17014       Receiver Plug Screw         4       17013       Soli Stop Pin       45       2352       Sofery Assembly (include Safery, Safery Button)         5       24475       Bohl Stop Release       47       13536       Sofery Oteant Ball         6       13478       Bohl Stop Release       47       13536       Sofery Oteant Ball         8       14472       Butt Plote Screw       50       13666       Sear Sofery Cam         10       13287       Center Guard Screw, ADL Grade       51       24476       Seer Pin         11       17071       Ejector Spring       30       30855       Sling Strap Assembly, BDL Grade (includes Sling Strap         12       17676       Ejector Spring       30       30857       Sling Strap Assembly, Swite Assembly, BDL Grade (includes Sling Strap         13       17019       Ejector Spring       54       22370       Strack Assembly, BDL Grade (includes Sling Strap         14       16234       Estractor River       2690       Strack Assembly, BDL Grade (includes Sling Strap         1722246       Fining Pin Creas Pin       Strack Assembly, BDL Grade (includes Sling Strap       Strack Assembly, BDL Grade (includes Sling Strap         172204       Fining Pin Creas Pin </td <td>1</td> <td></td> <td></td> <td>43</td> <td>15358</td> <td>Rear Swivel Screw, BDL Grade</td>	1			43	15358	Rear Swivel Screw, BDL Grade
4       17013       Behl Stop       45       2455       Sofery Assembly (Includes Safery, Safery Button)         5       24475       Behl Stop Release       47       13568       Sofery Derent Spring         7       17014       Behl Stop Release       47       13568       Sofery Derent Spring         8       14472       Behl Stop Spring       48       17043       Sofery Derent Spring         9       25410       Butt Plote Screw, ADL Grade       51       24447       Sofery Derent Spring         10       15287       Center Guard Screw, ADL Grade       51       24476       Seer Pin         11       17017       Ejector Fin       53       30855       Sling Strop Assembly, BDL Grade (Includes Sling Strop         12       17475       Ejector Spring       22040       Fining Pin Assembly (Includes Balt Plug, Fring Pin, Fring Pin, Fring Pin Fing Pin Spring, Strop Assembly, ADL Grade (Includes Butt Plens, Butt P)         17       120204       Fining Pin Assembly (Includes Balt Plug, Fring Pin, Fring Pin Fing Pin Spring, BDL Grade       26401       Strok Assembly, ADL Grade (Includes Butt Plens, Butt P)         17       12040       Fining Pin Assembly (Includes Balt Plug, Fring Pin, Fring Pin, Fring Pin, Fring Pin, Fring Pin, Strok Xie Assembly, BDL Grade (Includes Balt Plug, Fring Pin, Fring Pin Spring, BDL Grade (Includes Balt Plug, Fring Pin Gras Fring Strop Piens	3	17012	•	- 44	17034	Receiver Plug Screw
5     24475     Self Stop Pin     44     2322     Serfey Desen Spring       6     15478     Bolt Stop Pin     47     15368     Safety Desen Spring       8     14472     Burt Plate     49     17043     Safety Desen Spring       10     15287     Center Guard Screw, ADL Grade     51     24476     Sear Safety Can       11     17017     Elector Spring     53     30855     Sing Strop Assembly, BDL Grade (includes Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop Assembly, Q. D. (2), Frastener, Sing Strop, Grave Mathing, Stack, Stack Reforcing Strew Owell (not Mathing Strew), Stack Stack Reforcing Strew Owell (not Mathing Strew), Stack Reforcing Strew Owell (not Mathing Strew), Stack Reforcing Strew Owell (not Mathing Strew), Stack Reforcing Strew Owell (not Mathing Strew), Stack Reforcing Strew Owell (not Mathing Strew), Stack Reforcing Strew Owell (not Mathing Strew), Stack Reforcing Strew Owell (not Mathing Strew, Stack Reforcing Strew, Stack Reforcing Strew Owell (not Mathing Strew, Stack Reforcing Strew, Strew, Stack Reforcing Strew, Stack Reforcing S		17013	•	45	26585	Safety Assembly (includes Safety, Safety Button)
6     15478     Suft Stop Release     47     15468     Serkey Deven Spring       7     17014     Serkey Deven Spring     48     17043     Serkey Deven Spring       9     25410     Burt Plate Screw, ADL Grade     50     15663     Sear Plin       10     15287     Center Guard Screw, ADL Grade     51     24476     Sear Plin       11     17017     Ejector Plin     53     30825     Sling Strap Assembly, BDL Grade (Includes Sling Strap Assembly, G. D. (2), Fr       13     17019     Ejector Plin     53     Sling Strap Assembly, ADL Grade (Includes Sling Strap Assembly, G. D. (2), Fr       14     16234     Extractor     26970     Sling Strap Assembly, ADL Grade (Includes Wassenbly, G. D. (2), Fr       15     27340     Extractor     26970     Sling Strap Assembly, ADL Grade (Includes Int Plan, Burt Plan, Straw, Rev Devel)       17     17022     Fring Plin Gross Plin     Frind Grade     Stock Assembly, ADL Grade (Includes Int Plan, Burt Plan, Burt Plan, Burt Plan, Straw, Stock Reinforcing Strew Dowel)       18     17022     Fring Plin Gross Plin, BDL Grade     16453     Foor Plene Latch Sping, BDL Grade       19     19800     Floor Plene Latch Sping, BDL Grade     16453     Stock Reinforcing Strew Dowel)       19     Floor Plene Latch Sping, BDL Grade     57     17033     Trigger Adjusting Strew, As	1		·	46	23222	Safety Detent Ball
7     17014     Selfs Spa Spring     48     17043     Serfey Floor Plin       8     14472     Butr Plans Screw     50     15666     Sear Safety Cam       9     1310     Tortal Ejector Plin     50     15666     Sear Safety Cam       10     15287     Center Guard Screw, ADL Grade     51     12473     Sear Safety Cam       11     17017     Ejector Plin     53     30825     Sing Strap Assembly, BDL Grade (Includes Sling Strap       14     16254     Extractor     Sing Strap Assembly, Role Grade (Includes Sling Strap       16     22020     Fring Plin Cross Plin, Firing Plin, Firing Plin, Firing Plin, Firing Plin Cross Plin, Firing Plin Cross Plin, Firing Plin Cross Plin, Slin Grade     54       17     17021     Floor Plets, BDL Grade     55     Stock Assembly, BDL Grade (Includes Butr Plets, Butr Plins, But Plats, BDL Grade       18     Floor Plets Latch Sping, BDL Grade     55     Stock Assembly, BDL Grade (Includes Butr Plats, Butr Plats	-	_	•	47	15368	Safety Detent Spring
8     1472     1477     Start Plane     49     17044     Serier Sing Vicinity       9     25410     Burt Plane Screw, ADL Grade     50     15666     Sear Safety Cam       11     17017     Ejector Pin     53     17044     Sear Pin       12     17676     Sear Safety Cam     53     17047     Sear Safety Cam       13     17017     Ejector Pin     53     30825     Sing Strap Assembly, BDL Grade (includes Sing Strap       14     16254     Extractor Rivet     53     30825     Sing Strap Assembly, ADL Grade (includes Strew Dowel)       15     27340     Erroctor Rivet     2690     Sing Strap Assembly, ADL Grade Strew Nowel     2690       17     22040     Fining Pin Assembly (includes Bait Plug, Fining Pin, Fining Pin     54     2631     Stock Reinforcing Strew Dowel) (not shown)       18     17022     Fining Pin Crose Pin     BU Grade     16970     Stock Reinforcing Strew Dowel) (not shown)       18     17022     Fining Pin Rin, BDL Grade     16970     Stock Reinforcing Strew Towel (not shown)       18     16451     Floor Plate Latch, Pin, BDL Grade     16970     Stock Reinforcing Strew Towel (not shown)       21     16453     Front Guard Strew Store     16970     Stock Reinforcing Strew Towel (not shown)       22     16453	-		•	48	17043	Safety Pivot Pin
9     25410     But Plats Screw     50     15645     Sear Safety Cam       10     15287     Center Guard Screw, ADL Grade     51     24476     Sear Spring       11     17017     Ejector Pin     52     17047     Sear Spring       12     17676     Ejector Pin     53     30855     Sing Strap Assembly, BDL Grade (includes Sling Strap       14     16254     Extractor     Strap Assembly, RDL Grade (includes Sling Strap       15     27340     Extractor Rivet     Strap Assembly, RDL Grade (includes Sling Strap       16     20200     Fining Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Fining Pin Croas Pin, Firing Pin Head, Main Spring)     54     26381     Steck Assembly, BDL Grade Strew Davel Inters Burt Pin Screw (2), Foren Guard Screw Boweline; Strew Stock Reinforcing Screw Dovel Inters Burt Pin Screw (2), Foren Guard Screw Boweling Strew Daveling       18     17022     Floor Plate Latch, BDL Grade     16451     Floor Plate Latch, Spring, BDL Grade     16451       19     19800     Floor Plate Latch, Spring, BDL Grade     55     15280     Trigger Assembly, BDL Grade (Q. D.)       12     16452     Floor Plate Latch, Spring, BDL Grade     16705     Stock Reinforcing Screw Dovel Inters Burt Pin, Firing Pin Tenn Sight Inters Burt Pin       13     16435     Froor Guard Screw Wall, Grade     55     15616     Stock Reinforcing Screw Dovel				49	17044	Safety Snap Washer
10     12327     Center Guord Screw, ADL Grade     51     24/36     Sear Pin       11     17017     Ejector     52     17047     Sear Spring       13     17019     Ejector Spring     53     30825     Sling Strap Assembly, BDL Grade (includes Sling Strap       14     16224     Extractor     53     30825     Sling Strap Assembly, CD. C2, Fr.       15     27340     Extractor Rivet     54     26970     Sling Strap Assembly, ADL Grade (includes But Place, Burt Place, B	- 1			50	15666	Sear Safety Cam
11       17017       Ejector       52       17047       Sear Spring         12       17676       Ejector Pin       53       30855       Sing Strap Asambly, BDL Grade (includes Sing Strap Asambly, BDL Grade (includes Sing Strap Asambly, Stock, Stock Reinfording Screw, Namely, Stock, Stock Reinfording Screw, Stock Reinfording Screw, Stock Reinfording Screw, Stock Reinfording Screw Dowell         14       16254       Extractor       54       26390       Sing Strap Asambly, Stock Reinfording Screw, Stock Reinfording Screw, Stock Reinfording Screw, Stock Reinfording Screw Dowell       26401       Stock Asambly, ADL Grade (includes But Plate, But Stock, Reinfording Screw Dowell (not shown)         16432       Floor Plate Eatch, BDL Grade       55       Stock Reinforcing Screw, Stock Reinfording Screw Dowell (not shown)       16970         17939       Front Sight Remp, BDL Grade       55       Stock Reinforcing Screw, Store Screw, Store Store Screw, Trigger Plate Ing Reinger Adjusting Screw, Trigger Plate, Trigger M				51	24476	Sear Pin
12       17676       Ejector Prin       53       30855       Sling Strap Assembly, BDL Grade (Includes Sling Strap Assembly, Sure Assembly, Sure Assembly, Sure Assembly, GL C. (2), Fr         13       17019       Ejector Spring       26990       Sling Strap Assembly, Sure Assembly, GL C. (2), Fr         13       27340       Extractor Rivet       Sing Strap Assembly, Sure Assembly, GL Crade (Includes But Plate,				52	17047	Sear Spring
1000       Fister Spring         14       16254       Extractor Spring         14       16254       Extractor River         15       27340       Extractor River         16       22020       Firing Pin         17       2040       Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin         17       20204       Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin         18       17022       Firing Pin Cross Pin       Stock Assembly, ADL Grade (includes Butt Plans, Burt Stats, Burt Stats, Burt Plans, Burt Stats, Burt Plans, Stats, Stats, Stats, St				53	30855	Sling Strap Assembly, BDL Grade (includes Sling Strap
14       14214       Extractor         15       27340       Extractor Rivet         15       27340       Extractor Rivet         15372       Fastenes, Sing Strop       54         16       2000       Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Aesambly, BUG Grade       54         17       2040       Firing Pin Cross Pin, Firing Pin Mead, Main Spring)       54         18       17022       Firing Pin Cross Pin, Firing Pin Aesambly, BDL Grade       54         18       17022       Firing Pin Cross Pin, Firing Pin, Boll Grade       57         19000       Floor Plate Latch, BDL Grade       57         116431       Floor Plate Latch, BDL Grade       55         123       16453       Floor Plate Latch Spring, BDL Grade       55         1331       Front Sight Ramp, SDL Grade       57         13533       Front Sight Ramp, SDL Grade       57         135	- 1		•			
15       27340       Extractor Rivet       Sting Strop Assembly, Survet Assembly, Varvet Assembly, Cu. D. (2), Frint Strop Assembly, Cu. D. (2), Frint Strop Assembly, Cu. D. (2), Frint Strop Assembly, Cu. D. (2), Frint Strop Assembly, Cu. D. (2), Frint Strop Assembly, ADL Grade Strew Davel Strew Davel Strew Davel Strew Davel Strew Davel Strew Davel Strew Davel Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Stock Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distribution, Strew Stock Reinforcing Strew Davel Distre Strew,	· -				26990	Sling Strap Assembly and Mountings Complete (include
13376Fastener, Sling Strap542638Strack Asambly, Roll Grade (includes Burt Plate, Burt					<u>۱</u>	
16       22020       Firing Pin	<b>`</b>			-		•
1722040Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross PinFiring Pin Assembly, Encludes Burt Plate, Main Spring)1817022Firing Pin Cross PinStock Assembly, BDL Grade Burt Plate, BUL Grade1919800Flaor Plate, BDL GradeStock Assembly, BDL Grade Stock Reinforcing Screw Dowell2015291Floor Plate Latch, BDL GradeStock Reinforcing Screw Dowell (not shown)2116451Floor Plate Latch, BDL Grade1697022Stock Reinforcing Screw Dowell (not shown)265352316453Floor Plate Plate, BDL Grade552422035Front Guard Screw Bushing, ADL Grade562515161Front Guard Screw Bushing, ADL Grade572615373Front SightStock Reinforcing Screw Dowell (not shown)26355Front Sight Ramp, BDL Grade5728505Front Sight Ramp, BDL Grade5728515Front Sight Ramp, BDL Grade5728515Front Sight Ramp, BDL Grade5728515Front Sight Ramp, BDL Grade5728525Front Sight Ramp, BDL Grade5728535Front Sight Ramp, BDL Grade5728535Front Sight Ramp, BDL Grade5728535Front Sight Ramp, B	14		· •	34	20381	
1817022Firing Pin Cross PinScrew (2), Fore-end Tip, Fore-end Tip, Socer, Grip CG1919800Floor Plate, BDL GradeGrip Cap Spacer, Front Swivel Nut, Stock, Nock Reinfor2116451Floor Plate Latch, BDL Grade18186Stock Reinforcing Screw Dowel (not shown)2216452Floor Plate Latch Spring, BDL Grade16970Stock Reinforcing Screw (not shown)2316453Floor Plate Plate Datch Pin, BDL Grade5526355Stock Reinforcing Screw Dowel (not shown)242035Front Guard Screw5615280Trigger Adjusting Screw2515161Front Guard Screw Bushing, ADL Grade5717053Trigger Adjusting Screw2615373Front Sight Ramp5615280Trigger Adjusting Screw2715635Front Sight Ramp, BDL Grade5717053Trigger Adjusting Screw2828505Front Sight Ramp, BDL Grade5717053Trigger Adjusting Screw, Trigger Connector2815333Front Sight Ramp, Screw5717053Trigger Engagement Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Trigger Screw, Screw, Trigger S	17		Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing		26401	forcing Screw, Stock Reinforcing Screw Dowel)
19800Floor Plate, BDL GradeGrip Cap Spacer, Front Swivel Nut, Stock, Stock Reinforcing Screw Dowel) (not shown)15291Floor Plate Latch, BDL GradeStock Reinforcing Screw Dowel) (not shown)16451Floor Plate Latch Spring, BDL GradeStock Reinforcing Screw Dowel (not shown)16453Floor Plate Latch Spring, BDL GradeStock Reinforcing Screw Dowel (not shown)16453Floor Plate Latch Spring, BDL GradeStock Reinforcing Screw Dowel (not shown)2316453Floor Plate Latch Spring, BDL GradeStock Reinforcing Screw Dowel (not shown)2422035Front Guard ScrewStock Reinforcing Screw Dowel (not shown)2515161Front Guard Screw Bushing, ADL GradeStock Reinforcing, Screw Dowel (not shown)2615373Front Sight RampStock Reinforcing Screw Dowel (not shown)2728510Front Sight RampStock Reinforcing, Screw Pliver Pin, Safery Detert Spring, Safery Pliver Pin, Safery Sa Washer, Sear and Safety Cam Assembly, Safery Datern Bi Safery Detent Spring, Safery Pliver Pin, Safery Sa Washer, Sear and Safety Cam Assembly, Sear Spring2815335Front Sight Ramp, BDL GradeStock Reinforcing Screw2915363Front Sight RampStock Reinforcing Screw2915363Front Sight RampStock Reinforcing Screw2915363Front Sight RampStock Reinforcing Screw2915335Front Sight RampStock Reinforcing Screw3115356Front Sight RampStock Reinforcing Screw3215284Agagzine, BDL Grade (not shown) <td>18</td> <td>17099</td> <td></td> <td></td> <td>20401</td> <td></td>	18	17099			20401	
2013291Floor Plate Latch, BDL Gradeing ScrewStock Reinforcing Screw (not shown)2116451Floor Plate Latch Spring, BDL Grade18186Stock Reinforcing Screw (not shown)2216452Floor Plate Latch Spring, BDL Grade5526555Swivel Assembly, BDL Grade (Q. D.)2422035Front Guard Screw5615280Trigger Adjusting Screw2515161Front Guard Screw Bushing, ADL Grade57170532615373Front Sight Romp5615280Trigger Adjusting Screw, Diver Plote Plot Plote2728510Front Sight Romp26355Swivel Assembly, Safety Assembly, Safety Detent Br Safety Plote Plin, Safety SarewSafety Plote Plin, Safety Sarew2815335Front Sight Romp15356Front Sight Romp, BDL Grade57170532915363Front Sight Romp, BDL Grade5717053Trigger Adjusting Screw, Trigger Connec2915363Front Sight Romp, BDL Grade5717053Trigger Connector3015357Front Swivel Nut, BDL Grade5819461Trigger Guard3115326Grip Cap, BDL Grade (not shown)6026376Trigger Guard3215284Magazine, BDL Grade (not shown)6026455Trigger Guard, BDL Grade (includes Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch,	· - 1		-		1	Grip Cap Spacer, Front Swivel Nut, Stock, Stock Reinford
2116451Floor Plate Latch Pin, 8DL Grade18180Stock Reinforcing Screw (not shown)2216453Floor Plate Latch Spring, 8DL Grade552555Swivel Assembly, 8DL Grade (Q. D.)2316453Floor Plate Pivat Pin, 8DL Grade5615280Trigger Adjusting Screw242023Front Guard Screw Bushing, ADL Grade5615280Trigger Adjusting Screw2515161Front Guard Screw Bushing, ADL Grade5717053Trigger Adjusting Screw2615373Front Sight Romp5615280Trigger Adjusting Screw2728510Front Sight RompStock Reinforcing Screw (not shown)Safety Petent Spring, Safety Pivot Pin, Safety Serey Detent Bring, Safety Pivot Pin, Safety Serey Detent Bring, Safety Can Assembly, Safety Pivot Pin, Safety Serey Cannee2828505Front Sight Romp Screw5717053Trigger Engagement Screw, Trigger Connee2915335Front Sight Romp Strew, BDL Grade5717053Trigger Connector2115326Grip Cap, BDL Grade5915281Trigger Guard2315327Grip Cap, BDL Grade5915281Trigger Guard2415328Grip Cap, BDL Grade5915281Trigger Guard2515328Magazine, ADL Grade5915281Trigger Guard Assembly, BDL Grade (includes Floor Plate Latch Pin, Floor Plate Latch Pin, Floor Plate Latch Pin, Floor Plate Latch Pin, Floor Plate Latch Pin, Floor Plate Latc					ł	ing Screw, Stock Reinforcing Screw Dowel) (not shown)
22       16452       Floar Plate Latch Spring, BDL Grade       16970       Stock Keinforcing Screw Dowel (not shown)         23       16453       Floar Plate Pivot Pin, BDL Grade       55       26555       Swivel Assembly, BDL Grade (Q. D.)         24       22035       Front Guard Screw       57       17053       Trigger Adjusting Screw         25       15161       Front Sight       15719       Front Sight Ramp       26345       Trigger Adjusting Screw         27       28510       Front Sight Ramp, BDL Grade       57       17053       Trigger Adjusting Screw, Trigger Pivor Pin, Safety Detent Buscher Spring, Safety Pivor Pin, Safety Detent Buscher Screw, Trigger Connector         28       28505       Front Sight Ramp, BDL Grade       57       17053       Trigger Engagement Screw, Trigger Pin, Trigger Stop Screw, Trigger Pin, Trigger Stop Screw, Trigger Pin, Trigger Stop Screw         28       28505       Front Sight Ramp, SDL Grade       57       17053       Trigger Engagement Screw, Trigger Pin, Trigger Stop Screw, Trigger Pin, Trigger Stop Screw, Trigger Pin, Trigger Stop Screw         30       15357       Front Swivel Nut, BDL Grade       57       15281       Trigger Guard         31       15328       Grip Cap Spacer, BDL Grade       57       15281       Trigger Guard         32       15284       Magazine, BDL Grade       57<			-		1	Stock Reinforcing Screw (not shown)
2316453Floor Plate Pivat Pin, BDL Grade3520353Swive Assembly, BDL Grade (G. D.)2422035Front Guard Screw5615280Trigger2515161Front Guard Screw Bushing, ADL Grade5615280Trigger Adjusting Screw2615373Front Sight (Low)26345Trigger Adjusting Screw2728510Front Sight Ramp26345Trigger Adjusting Screw, Ingger Connector15635Front Sight Ramp Screw7717633Trigger Connector2828505Front Sight Mod, BDL Grade5717053Trigger Engagement Screw, Ingger Connector2915357Front Sight Mod, BDL Grade5717053Trigger Connector3115356Front Swivel Nut, BDL Grade (not shown)5915281Trigger Guard3215322Grip Cap Spacer, BDL Grade (not shown)6026376Trigger Guard Assembly, BDL Grade (includes Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Pl						Stock Reinforcing Screw Dowel (not shown)
2422035Front Guard Screw5615280Trigger2515161Front Guard Screw Bushing, ADL Grade5717053Trigger Adjusting Screw2615373Front Sight (Low)26345Trigger Adjusting Screw263452728510Front Sight Ramp, BDL Grade26355Front Sight Ramp, BDL Grade72815357Front Sight Ramp, SDL Grade5717053Trigger Adjusting Screw2828505Front Sight Ramp, BDL Grade5717053Trigger Connector2915363Front Swiel Nut, BDL Grade5717053Trigger Engagement Screw3015357Front Swiel Nut, BDL Grade5819461Trigger Guard3115356Front Swiel Screw, BDL Grade (not shown)6026376Trigger Guard ABL Grade3215284Magazine, ADL Grade (not shown)6026376Trigger Guard Assembly, BL Grade (includes Floor Plate3317024Magazine Follower, BDL Grade6126455Trigger Fin3417028Magazine Spring, BDL Grade6224477Trigger Fin3517029Main Spring6224477Trigger Spring3517029Main Spring6415481Trigger Stop Screw						Swivel Assembly, BDL Grade (Q. D.)
2515161Front Guard Screw Bushing, ADL Grade5717033Ingger Adjusting Screw2615373Front Sight26375Trigger Adjusting Screw2728510Front Sight Ramp2028505Front Sight Ramp, BDL Grade2828505Front Sight Ramp, BDL Grade5717053Trigger Adjusting Screw2915363Front Sight Ramp ScrewTrigger CanadaTrigger Adjusting Screw, Trigger Canada2915357Front Sight Ramp Screw, BDL Grade5717053Trigger Engagement Screw, Trigger Pin, Trigger Stop Screw) (not shown)3015357Front Swivel Nut, BDL Grade5819461Trigger Guard, BDL Grade3115356Front Swivel Screw, BDL Grade (not shown)5915281Trigger Guard, BDL Grade3215284Magazine, BDL Grade (not shown)6026376Trigger Guard, BDL Grade (includes Floor Plate Latch Pin, Floor Plate Pinot Pin, Trigger Sing (3), Trigger Fin <td></td> <td></td> <td></td> <td>-</td> <td>-</td> <td>Trigger</td>				-	-	Trigger
2615373Front Sight26343Trigger Assembly (includes Bolt Stop Release, Trigger Assembly, Safety Assembly, Safety Assembly, Safety Detent Bolt Stop Release, Trigger Assembly, Safety Assembly, Safety Detent Bolt Stop Release, Trigger Assembly, Safety Assembly, Safety Detent Bolt Stop Release, Trigger Assembly, Safety Assembly, Safety Detent Bolt Stop Release, Trigger Assembly, Safety Assembly, Safety Detent Bolt Stop Release, Trigger Assembly, Safety Assembly, Safety Detent Bolt Stop Release, Trigger Assembly, Safety Detent Bolt Stop Release, Trigger Adjusting Screw, Trigger Connector2728505Front Sight RampWasher, Sear and Safety Cam Assembly, Safety Connector2828505Front Sight Ramp ScrewTrigger Engagement Screw, Trigger Connector2915335Front Swivel Nut, BDL Grade573015357Front Swivel Nut, BDL Grade583115356Front Swivel Screw, BDL Grade593215284Magazine, ADL Grade (not shown)603317024Magazine, ADL Grade513417028Magazine Follower, BDL Grade613517029Main Spring623615400Trigger Pin3715481Trigger Pin3815497Magazine Spring, BDL Grade3915297Magazine Spring3015477Magazine Spring, BDL Grade3317028Magazine Spring, BDL Grade3417028Magazine Spring, BDL Grade3517029Main Spring3617029Main Spring3715481Trigger Spring<				57		Trigger Adjusting Screw
15719Front Sight (Low)Safety Piver Assembly, Safety Piver Pin, Safet			÷-		26345	Trigger Assembly (includes Bolt Stop Release, Trigger Hou
27       28510       Front Sight Ramp       Washer, Sear and Safety Cam Assembly, Sear Spring         15635       Front Sight Ramp, BDL Grade       Trigger Engagement Screw, Trigger Pin, Trigger Stop Screw) (not shown)         28       28505       Front Sight Ramp Screw       Trigger Stop Screw) (not shown)         29       15335       Front Swiph Hood, BDL Grade       57         30       15357       Front Swivel Nut, BDL Grade       58         31       15356       Front Swivel Screw, BDL Grade       58         31       15352       Grip Cap, BDL Grade (not shown)       59         15332       Grip Cap Spacer, 8DL Grade (not shown)       59         32       15284       Magazine, ADL Grade (not shown)         33       17024       Magazine Follower, 8DL Grade         34       17028       Magazine Follower, 8DL Grade         35       17029       Main Spring         35       17029       Main Spring	20		-		}	
15635Front Sight Ramp, BDL GradeTrigger, Trigger Adjusting Screw, Trigger Connect Trigger Stop Screw) (not shown)2828505Front Sight Ramp ScrewTrigger Stop Screw) (not shown)2915363Front Sight Hood, BDL Grade57170533015357Front Swivel Nut, BDL Grade5717053Trigger Engagement Screw3115356Front Swivel Screw, BDL Grade5819461Trigger Connector331Grip Cap, BDL Grade (not shown)5915281Trigger Guard3215284Magazine, ADL Grade (not shown)6026376Trigger Guard, BDL Grade (includes Floor Plate Latch, Floor Plate Lat	27	-	-		1	
10000Tringer Engagement Screw, Trigger Pin, Trigger Spri Trigger Stop Screw, (not shown)2815363Front Sight Ramp Screw2915363Front Sight Rood, BDL Grade3015357Front Swivel Nut, BDL Grade3115356Front Swivel Screw, BDL Grade3115352Grip Cap, BDL Grade (not shown)15332Grip Cap, BDL Grade (not shown)15333Grip Cap, BDL Grade (not shown)153341528415335Magazine, ADL Grade (not shown)321528416430Magazine, BDL Grade (not shown)331702417572Magazine Follower, BDL Grade341702815677Magazine Spring,3517029351702940Spring361548137Trigger Stop Screw	~		•		1	
29       15363       Front Sight Hood, BDL Grade       57       Trigger Engagement Screw         30       15357       Front Swivel Nut, BDL Grade       58       19461       Trigger Connector         31       15336       Front Swivel Screw, BDL Grade       58       19461       Trigger Connector         32       15332       Grip Cap, BDL Grade (not shown)       60       26376       Trigger Guard, BDL Grade (includes Floor Plate Latch, Floor Fl	20				1	Trigger Engagement Screw, Trigger Pin, Trigger Spring
30       15357       Front Swivel Nut, BDL Grade       57       17033       Trigger Engagement Strew         31       15356       Front Swivel Screw, BDL Grade       58       19461       Trigger Connector         31       15356       Front Swivel Screw, BDL Grade       59       15281       Trigger Guard         32       15332       Grip Cap Spacer, BDL Grade (not shown)       60       26376       Trigger Guard, BDL Grade         32       15284       Magazine, BDL Grade (not shown)       60       26371       Trigger Guard, Assembly, BDL Grade (includes Flaor Plate Latch, Floor Plate Latch, Spring, Floor Plate Followsr, BDL Grade         33       17024       Magazine Followsr, BDL Grade       61       26655       Trigger Pin         34       17028       Magazine Spring, BDL Grade       62       24477       Trigger Pin         35       17029       Main Spring       63       15400       Trigger Spring         35       17029       Main Spring       64       15481       Trigger Stop Screw					{	
31       1336       Front Swivel Screw, BDL Grade       59       17401       Trigger Connector         331       15356       Front Swivel Screw, BDL Grade       59       15281       Trigger Guard, BDL Grade         15331       Grip Cap, BDL Grade (not shown)       59       15281       Trigger Guard, BDL Grade         15332       Grip Cap Spacer, 8DL Grade (not shown)       60       26376       Trigger Guard, BDL Grade         12       15284       Magazine, BDL Grade (not shown)       60       26371       Trigger Guard, ASEmbly, BDL Grade (includes Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Floor Plate Latch, Spring, Floor Plate Follower, BDL Grade         133       17024       Magazine Follower, BDL Grade       61       26655       Trigger Pin         15757       Magazine Spring       62       24477       Trigger Spring       15400       Trigger Spring         15677       Magazine Spring, BDL Grade       63       15400       Trigger Spring       15481       Trigger Stop Screw         35       17029       Main Spring       64       15481       Trigger Stop Screw	- 1			-	1 .	
15331       Grip Cap, BDL Grade (not shown)       57       1521       Trigger Guard         15332       Grip Cap Spacer, BDL Grade (not shown)       50       760       26376       Trigger Guard, BDL Grade         15332       Grip Cap Spacer, BDL Grade (not shown)       60       26376       Trigger Guard, BDL Grade         12       15284       Magazine, ADL Grade       26376       Trigger Guard, BDL Grade         16430       Magazine, BDL Grade (not shown)       26376       Trigger Guard, Assembly, BDL Grade (includes Flaor Plate Latch, Floor Plate	(		-		-	
15332       Grip Cap Spacer, 8DL Grade (not shown)       500       26375       Trigger Guard, 5DL Grade         32       15284       Magazine, ADL Grade       26371       Trigger Guard, 5DL Grade (includes Floor Plate Latch, Ploor Plate Latch, P	. (					
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16430       Magazine, BDL Grade (not shown)       Spring, Floor Plate Pivot Pin, Trigger Guard) (not shown)         33       17024       Magazine Follower       61       26655       Trigger Housing Assembly (includes Trigger Housing Spatial Spring), Floor Plate Pivot Pin, Trigger Housing Spatial Spring, BDL Grade         34       17028       Magazine Spring, BDL Grade       62       24477       Trigger Pin         35       17029       Main Spring       63       15481       Trigger Stop Screw		-			26371	Trigger Guard Assembly, BDL Grade (includes Floor Plate
33       17024       Magazine Follower       61       26655       Trigger Housing Assembly (includes Trigger Housing Spatial Spatia Spatial Spatial Spatial Spatia Spatial Spatial Spatial	عد	-	-		]	
15752       Magazine Follower, BDL Grade       (3), Trigger Side Plate (2)         34       17028       Magazine Spring       62       24477       Trigger Pin         15677       Magazine Spring, BDL Grade       63       15400       Trigger Spring         35       17029       Main Spring       64       15481       Trigger Stop Screw	<u>,</u> ,		•	<b>4</b> 1	26488	
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JJ 1/027 Multi Spring			• • •			<b>10</b>
36 26355 Rear Guard Screw					10-01	InAAst stop sciaw
	30	26355	Rear Guard Screw	L	1	

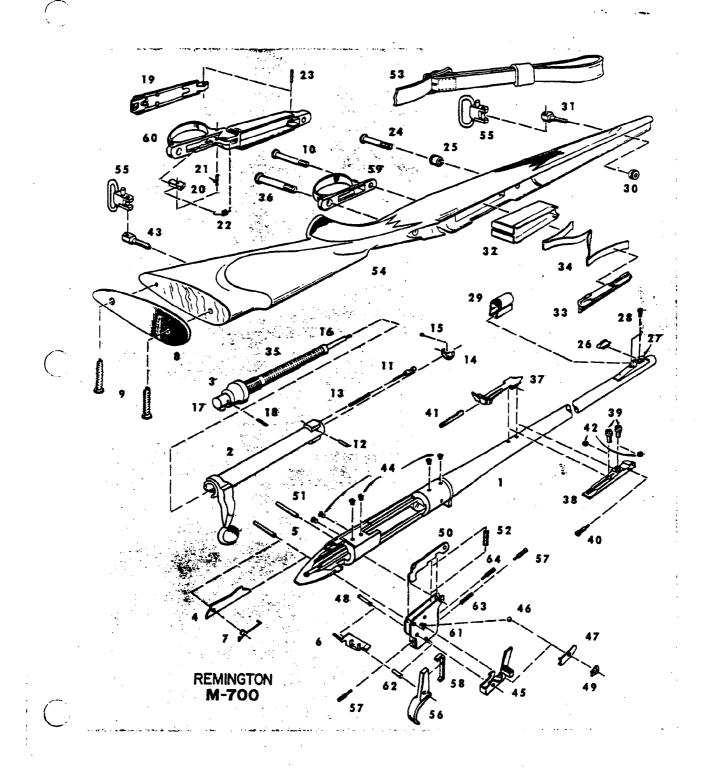
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SECTIONAL VIEW

# REMINGTON FIELD SERVICE MANUAL

MODEL 700



# ADDITIONAL CALIBERS (Not Shown in Sectional View)

## **INCLUDES VARMINT MODEL**

# REMINGTON FIELD SERVICE MANUAL

MODEL 700

### Nete: Caliber part numbers not listed below same as 30-06 (222 Rem. Mag. discontinued)

Part Na.	NAME OF PART	Part No.	NAME OF PART
26272 26274	Barrel Assembly, 7mm Rem. Mag. Barrel Assembly, 6mm Rem. Mag.	17891	Magazine Spring, 243 and 308 Win., 6mm Rem., 6.5mm Rem. Mag., 350 Rem. Mag., ADL Grade
	Barrel Assembly, 264 Win. Mag.	15698	Magazine Spring, 22-250 Rem.
26273		15699	Magazine Spring, 22-250 Rem., ómm Rem., 243 Win., BDL Grade
26265	Barrel Assembly, 222 Rem.	17058	Main Spring, 222 Rem., 222 Rem. Mag., 223 Rem., 243 Win., 308
26266	Barrel Assembly, 222 Rem. Mag.		Win., 6.5mm Rem. Mog., 350 Rem. Mog.
26267	Barrel Assembly, 243 Win.	18843	Rear Scope Base, Varmint
27675	Barrei Assembly, 300 Win. Mag.	1	
26268	Barrel Assembly, 308 Win.	24526	Rear Sight Assembly, 7mm Rem. Mag., 264 Win. Mag.
26269	Barrel Assembly, 270 Win.	21387	Recoil Pad, 7mm Rem. Mag., 264 and 300 Win. Mag.
27678	Barrei Assembly, 22-250 Rem.	25410	Recoil Pad Screw, 7mm Rem. Mag., 264 and 300 Win. Mag.
27676	Barrel Assembly, 6.5mm Rem. Mag.	18842	Scope Base Screw, Rear, Varmint
27677	Barrel Assembly, 350 Rem. Mag.	16205	Scope Base Screw Front, Varmint
29570	Barrel Assembly, Varmint, 222 Rem. (includes Barrel, Barrel Bracket, Receiver)	26382	Stock Assembly, 7mm Rem. Mag., 264 Win. Mag., ADL Grade (in- cludes Front Guard Screw Bushing, Recoil Pad, Recoil Pad Screw (2) Stack Schen Baindering, Screw, Stack Baidering, Screw (2) Stack Screw Bushing, Screw, Stack Baidering, Screw (2) Stack Screw Bushing, Screw Stack Baidering, Screw (2) Stack Screw Bushing, Screw Stack Baidering, Screw (2) Stack Screw Bushing, Screw Stack Baidering, Screw (2) Stack Screw Bushing, Screw Stack Baidering, Screw (3) Stack Screw Bushing, Screw Stack Baidering, Screw (3) Stack Screw Bushing, Screw Stack Screw Stack Baidering, Screw (3) Stack Screw Bushing, Screw Stack Screw Stack Screw Stack Screw (3) Stack Screw Stack Stack Screw Stack Screw Stack Stack Screw Stack S
29571	Barrel Assembly, Varmint, 22-250 Rem.		<ul><li>(2), Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dawel)</li></ul>
29572	Barrei Assembly, Varmint, 223 Rem.	26380	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win.
29573	Barrel Assembly, Varmint, ómm Rem.	20300	6mm Rem., 22-250 Rem., ADL Grade
29574	Barrel Assembly, Varmint, 243 Win.	26415	Stock Assembly, 7mm Rem. Mag., 264-300 Win. Mag., BDL Grade
6328	Boit Assembly, 7mm Rem. Mag., 264 and 300 Win. Mag.		(includes Fore-End, Fore-End Spacer, Grip Cap, Grip Cap Spacer
26329	Bolt Assembly, 6.5mm Rem. Mag., 350 Rem. Mag.		Recoil Pad, Recoil Pad Screw (2), Front Swivel Nut, Stock, Stoci
6325	Balt Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.		Reinforcing Screw, Stock Reinforcing Screw Dowel)
6326	Balt Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	26400	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win.
26318	Balt Final Assembly, 7mm Rem. Mag., 264 and 300 Win. Mag. (in- cludes same as 30-06)	29585	6mm Rem., 22-250 Rem., BDL Grade Stock Assembly, Varmint, BDL Grade (includes Butt Plate, Butt Plate
6319	Balt Final Assembly, 6.5mm Rem. Mag., 350 Rem. Mag. /		Screw (2), Fore-End, Fore-End Spacer, Grip Cap, Grip Ca Spacer, From Swivel Nut, Stock, Stock Reinfarcing Screw, Stoc
6315	Bolt Final Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.		Reinforcing Screw Dowel)
6316	Bolt Final Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	26402	Stock Assembly, 6.5mm Rem. Mag., 350 Rem. Mag. (includes Fore
5852	Ejector, 222 Rem., 223 Rem., 223 Rem. Mag.	ł	End Spacer, Fore-End Tip, Front Swivel Nut, Grip Cap, Grip Caj Spacer, Recoil Pad, Recoil Pad Screw (2), Stock)
5709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.	26375	Trigger Guard, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem. 243 and 308 Win., 6mm Rem., 22-250 Rem.
5850	Extractor, 222 Rem., 223 Rem., 222 Rem. Mag.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 222 Rem. Mag.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.		223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag. (includes same as 30-06 BDL Grade
27342	Extractor Rivet, 222 Rem., 223 Rem., 222 Rem. Mag.		CALIFERS, 275 HEM Manue ASS WIN MACHINA
2021	Firing Pin, 222 Rem., 222 Rem. Mag., 243-308 Win., 6mm Rem. Mag.,		CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
	22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag., 223 Rem.	27265	Barrei Assembly, 375 H&H Mag.
2041	Firing Pin Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag., 223	27266	Barrel Assembly, 458 Win. Mag.
	Rem.	15709	Extractor
6434	Floor Plate, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem., 243	16771	Front Sight, 375 H&H Mag.
	and 308 Win., 6mm Rem., 22-250 Rem.	23805	Front Sight, 458 Win. Mag.
2037	Front Guard Screw, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6 mm Rem., 22-250 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same a standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used
6204	Front Scope Base, Varmint		DISCONTINUED or SERVICE PARTS
5282	Magazine, ADL Grade, 222 Rem., 222 Rem. Mag.	26270	Barrei Assembly, 280 Rem.
6716	Magazine, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem.	20467	Extractor, 222 Cal.
5283	Magazine, ADL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.	17639	Ejector, 222 Cal.
6715	Magazine, BDL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.	16717	Front Sight Ramp, ómm Rem., 7mm Rem. Mag., 264 Win. Mag., 22
4756	Magazine, BDL Grade, 6.5mm Rem. Mag., 350 Rem. Mag.	10/17	Rem., 222 Rem. Mag., 243 Win., ADL Grade
7975	Magazine, obc Grade, oligin, keni, Mag., 330 kemi, Mag. Magazine Follower, 222 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222
	•		Rem. Mag., 243 Win., BDL Grade
6793 7054	Magazine Follower, 222 Rem. Mag.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
7056	Magazine Follower, 243 and 308 Win., 6mm Rem., 22-250 Rem., 6.5 mm Rem. Mag., 350 Rem. Mag.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag. 222 Rem., 222 Rem. Mag., 243 Win.
5285	Magazine Spacer, 222 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag.
6826	Magazine Spacer, 222 Rem., BDL Grade	17040	222 Rem., 222 Rem. Mag., 243 Win.
5286	Magazine Spacer, 222 Rem. Mag., 223 Rem., BDL Grade	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rea
5742	Magazine Spacer, 222 Rem. Mag., ADL Grade		Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rea
7983	Magazine Spring, 222 Rem., 222 Rem. Mag., 223 Rem.		Sight Step, Rear Sight Washer (2)

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# MALFUNCTIONS

## **CAUSE and CORRECTION**

## (Con't. from Page 4)

#### **Fails to Eject**

### **Bolt Puils Out** Cause,

Cause:

Cause:

Correction: 1. Free up.

Correction: 1. Free up.

**Bulges or Blows Cases** 

2. Replace.

Safe Works Too Hard or Too Freely

too freely).

2. Replace Washer.

1. Oversize Chamber.

Assembly.

Maximum head space.

Correction: 1. Change Barrel or Barrel and Receiver

-	
Couse	

- 1. Burr at Ejector Hole in Bolt. 2. Ejector binds or fails to retract far enough.
- 3. Extractor Rivet loose.
- 4. Extractor drops shell.

#### Correction: 1. Deburr.

- 2. Free up or replace.
- 3. Re-stake or replace.
- 4. Replace Extractor.

# Misfires Cause:

- 1. Short Firing Pin (damaged).
- 2. Firing Pin binds.
  - 3. Short Firing Pin protrusion.
  - Firing Control out of adjustment. 4.
  - 5. Faulty ammunition.

### Correction: 1. Replace.

- 2. Free up or replace.
  - 3. Change Firing Pin or Bolt.
  - 4. Adjust.

#### **Follows Down**

Cause

- 1. Trigger Adjusting Screw, rear, out of adjustment (improper horizontal engagement of Sear and Connector).
  - 2. Improper vertical engagement of Sear and Connector.
  - 3. Trigger doesn't retract.
  - Corners on Sear or Connector rounded.
  - 5. Trigger binds on Trigger Plate.
  - 6. Not enough tension on Weight Screw (light pull).

### Correction: 1. Adjust.

- 2. Fit new Fire Control.
  - 3. Fit new Fire Control.
  - 4. Fit new Fire Control.
  - 5. File eliminate interference.
- 6. Adjust.

#### **Bolt Opens Hard**

Causes 1. See Fails to Extract.

- 2. Upset Extraction Cam on Bolt Handle.
- 3. Burr at Ejector Hole in Bolt.
- 4. Blown or set back Primer on shell.

Correction: 1. See Fails to Extract.

- 2. Smooth up.
- 3. Deburr.
- 4. Ream Chamber if throat is shallow (ammunition may be at fault):

8

1.	Barrel
2.	Horns,

- - 2. Correct if possible.
    - 3. Tighten or change Sights.

**Bolt Binds** 

- Cause: 1. Guard Screws protrude into Bolt track. 2. Scope Screws protrude into Bolt track. 3. Bolt Handle interference on Stock.
  - 4. Step at rear of Bolt Lugs.

1. Bolt Stop or Bolt Release binds.

1. Safe binds (works hard).

2. Bolt Stop or Bolt Release broken.

2. Safety Snap Washer stretched out (Safe works

2. Fit new Bolt (ammunition may be at fault).

- Correction: 1. File ends of Screws.
  - 2. File ends of Screws.
    - 3. Correct Stock or fit new Stock.
    - 4. File to blend.

- 1. Crown of Barrel damaged. Causa-

  - 2. Lead or change Barrel.
    - 3. Change Barrei.
      - 4. Correct bedding.
      - 5. Tighten or replace.

#### **Point of Impact Not Correct**

- not straight. Cause:
  - breaks, etc. in Bore.
  - 3. Improper or loose Sights.
- Correction: 1. Straighten.

- Doesn't Group
  - 2. Leading of Bore.
  - - 3. Oversize Bore.

- Correction: 1. Recrown.
- - - - 4. Improper bedding of Barrel in Stock.
- 5. Loose Sights.

### MODEL 700 Introduction

## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725.

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Therefore, the assembly and servicing instructions for the Model 700 will list only parts that are of design and operation not used in any other model.



The Instruction Folder RD-5461 is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and the instructions for the care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

# MODEL 700 Index

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Bolt Final Assembly (ADL Grade)	#26317	1, 2 & 3
Bolt	#26327	1,2&3
Ejector	#17017	1,2&3
Ejector Pin	#17676	1,2&3
Ejector Spring	#17019	1,2&3
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Extractor Rivet	#27340	1,2&3
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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division lien, New York

 $\Box$ 

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut

R2524454

### REMINGTON FIELD SERVICE MANUAL

### TRIGGER GUARD (ADL GRADE)

<u>To Disassemble</u> - Unscrew and remove rear and center guard screws and remove trigger guard.

To Replace - Interchange with no factory adjustment required.

To Reassemble - Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

<u>Caution</u>: Before assembling stock to receiver, particularly on ADL Grade, locate magazine fully into magazine recess in bottom of receiver. This will prevent any damage to stock when stock is tightened against receiver.

BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

<u>To Disassemble</u> - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

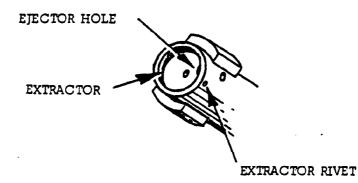
<u>Caution:</u> Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

EIECTOR RETAINING PIN ETECTOR Drive Out Here EJECTOR SPRING

# REMINGTON FIELD SERVICE MANUAL

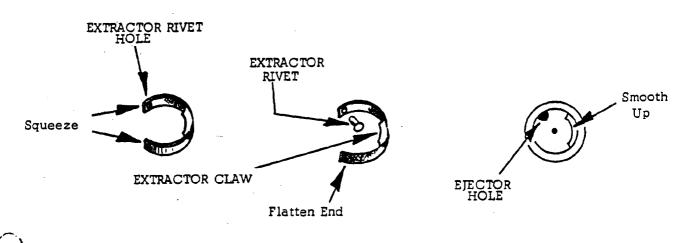
### BOLT FINAL ASSEMBLY Continued

Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)



Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)



Straighten tail of extractor. (See sketch above)

## REMINGTON FIELD SERVICE MANUAL

### BOLT FINAL ASSEMBLY Continued

Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

If the fired case is gripped too loosely (case drops away when bolt is held face downward) - extractor must be pulled from under rim to increase tension against fired case. Disassemble, if necessary, and rebend extractor as indicated in sketch on preceding page

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch on preceding page)

<u>Note</u>: An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

To Disassemble - See Model 725 manual and disassemble in the same manner.

<u>To Replace</u> - Interchangeable with no factory adjustment required.

<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

R&D:FGH 3-12-63

### REMINGTON FIELD SERVICE MANUAL

### SIGHTS

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

<u>To Disassemble</u> - Spread cover slightly and push forward in cover slots on either side of the ramp.

To Replace - Interchangeable - no factory adjustment required.

<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

### FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
- <u>To Replace</u> Interchangeable no factory adjustment required.

To Reassemble - Follow reverse order.

- FRONT SIGHT RAMP (Screw on type, used on the following calibers only: 222, 222 Magnum, 243, 6mm, 7mm Magnum and 264 Magnum)
- <u>To Disassemble</u> Unscrew front sight ramp screw and pry ramp up off ramp pins.
- To Replace Interchangeable no factory adjustment required.
- <u>To Reassemble</u> Place ramp pins in holes on top of barrel, align pins with holes in bottom of ramp and tap ramp down on to barrel until seated. Screw in ramp screw.

NOTE: Other calibers (308, 270, 280 and 30-06) have a brazed on front sight ramp which is not easily disassembled.

## REMINGTON FIELD SERVICE MANUAL

SLING STRAP ASSEMBLY & MOUNTINGS, COMPLETE - A sling strap complete with mountings is packaged with each BDL Grade rifle. When attaching to rifle --- assemble both quick detachable (Q.D.) swivel assemblies to stock. To do this, push plunger on swivel until small plate lifts and can be swung free of attaching stud on swivel. Then insert attaching stud into eye of stock screw. Close plate on swivel to lock swivel to stock screw.

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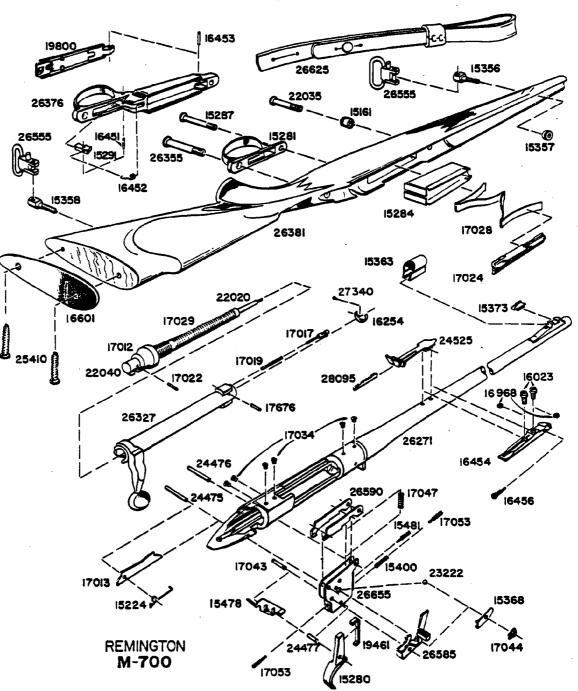
To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.

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# REMINGTON FIELD SERVICE MANUAL



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## REMINGTON FIELD SERVICE MANUAL

The Remington Model 700 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721, 722 and 725.

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When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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Magazine (ADL Grade)	#15284	1
Bolt Final Assembly (ADL Grade)	#26317	1, 2 & 3
Bolt	#26327	1,2&3
Ejector	#17017	1,2&3
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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division ilion, New York

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### REMINGTON FIELD SERVICE MANUAL

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(See Model 725 Manual)

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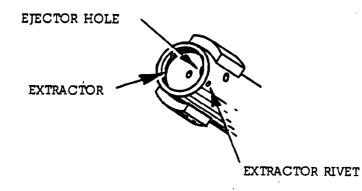
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## REMINGTON FIELD SERVICE MANUAL

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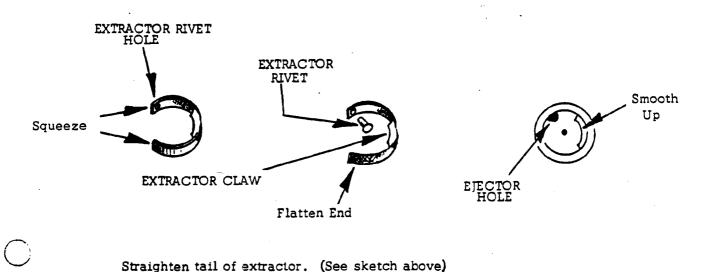
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Disassemble ejector and ejector spring from breech bolt. Drive extractor rivet from breech bolt - outside to inside. (See sketch below)



Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

<u>To Reassemble</u> - Adjust replacement for proper tension <u>before reassembly</u> as follows: Squeeze ends of extractor together slightly. (See sketch below)



### REMINGTON FIELD SERVICE MANUAL

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Reassemble extractor to bolt face and snap under bolt rim. Align extractor rivet hole in extractor with rivet hole in bolt rim. Insert extractor rivet thru aligned hole with rivet head against extractor when reassembling.

<u>Note</u>: If original disassembled extractor is reassembled, adjustment for proper tension before reassembly may not be necessary. A replacement extractor rivet must be supplied for reassembly.

Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

Smooth up staking to blend with outside wall of bolt. Adjust extractor for proper tension, using a fired case. Extractor must grip the fired case firmly and hold the fired case when the breech is held face downwards.

If the fired case is gripped too securely (case snaps free with difficulty) tap extractor smartly, with a soft metal punch, back under bolt rim. Test with fired cartridge case again. Repeat same operation if extractor needs further adjustment to reduce tension.

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<u>Note:</u> An earlier design, in 222 Caliber, incorporated a "snap in" type extractor which required no rivet. These may be assembled and disassembled in the same manner as the Model 725.

BOLT STOP (See sectional view on last page)

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<u>To Reassemble</u> - The bolt stop spring is of a new design and therefore is assembled in a different manner than the Model 725. Place bolt stop spring in the recess in the receiver so that the long end is forward and the bent end faces outward. Place bolt stop in receiver slot with the contoured edge on top and the hole to the rear. Align and tap in bolt stop pin.

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## REMINGTON FIELD SERVICE MANUAL

### SIGHTS

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - is designed to provide housing for the front sight blade.

- <u>To Disassemble</u> Spread cover slightly and push forward in cover slots on either side of the ramp.
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<u>To Reassemble</u> - Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

## FRONT SIGHT

- <u>To Disassemble</u> Drive front sight out of front sight ramp from left to right.
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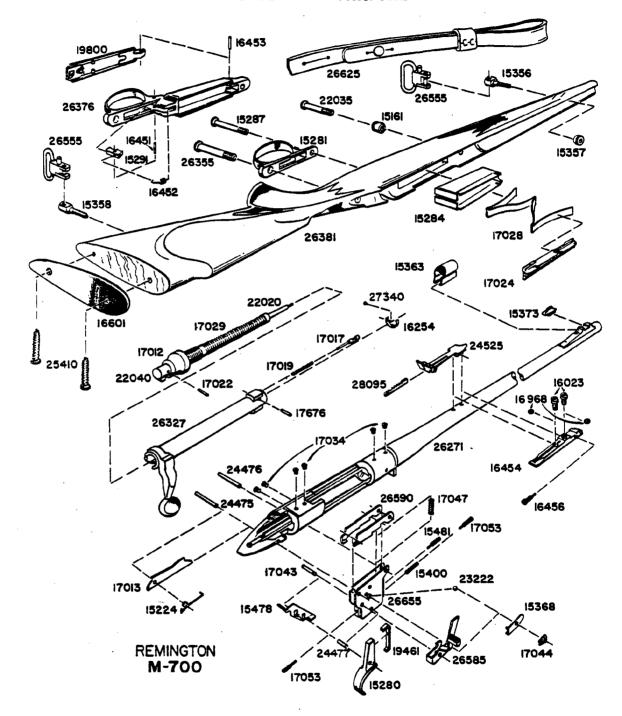
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## REMINGTON FIELD SERVICE MANUAL

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# MODEL 700 Introduction

# REMINGTON FIELD SERVICE MANUAL

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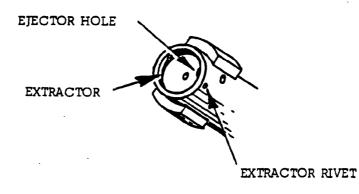
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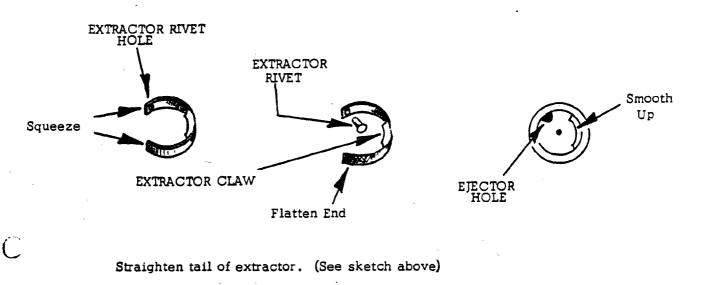
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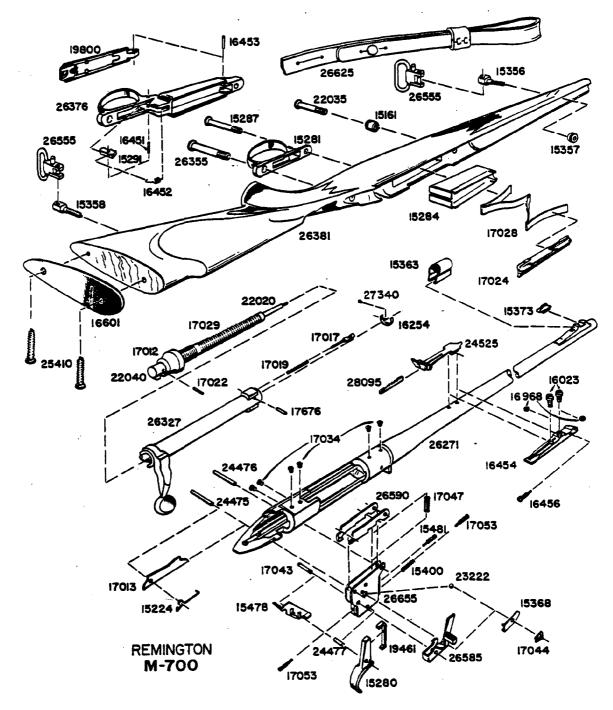
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# REMINGTON FIELD SERVICE MANUAL

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#### INTRODUCTION

There is a sentence in a pilot's flight manual that reads, "When you enter the cockpit of this aircraft, you become part of a system over which you have control both in terms of operation and safe handling. You are the only one that can make the system safe or unsafe."

The same is true of the shooter, whether a hunter, target shooter or casual weekend plinker. From the time he picks up a firearm, the shooter becomes a part of a system over which he has complete control. He is the only part of the system that can make a gun safe — or unsafe.

Hunting and target shooting are among the safest of all sports. This booklet is intended to make them even safer — by reemphasizing and reaffirming the basics of safe gun handling and storage and by reminding each individual shooter that he or she is the key to firearms safety.

Please read this booklet carefully and follow the safety procedures outlined. Firearms safety is up to you. Make no mistake about it.

# KNOW YOUR GUN-READ YOUR INSTRUCTION MANUAL

Don't Rely on Your Gun's Safety. Treat Every Gun as if It Were Loaded and Ready to Fire

The safety on any gun is a mechanical device that serves as a partot a complete system of safe gun handling. The safety is not intended to serve — nor can it possibly serve — as a substitute for common sense or safe gun handling.

For example, never pull the trigger on a firearm when the safety is in the "safe" position or anywhere in between "safe" and off. It is possible that the gun could fire anyway, and it is also possible that the gun could fire later when you release the safety — without your ever touching the trigger again. Always place the safety completely in the "fire" or "safe" positions. Never in between. Half-safe is unsafe. Don't play with your safety, putting it on and off. Leave it on until you are absolutely ready to fire. You and the safe gun

handling procedures you have learned are your gun's primary safeties. To rely entirely upon a mechanical device is unsafe. Use your safety safely.

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Never Cross a Fence, Climb a Tree or Jump a Ditch With a Loaded Gun

There are times during nearly all hunting trips when common sense and the basic rules of firearms safety will

Common sense and the basic rules of firearms safety will require you to unload your gun for maximum safety. Anytime there is an added risk that you might lose your balance and drop or lose control of your gun. you should unload. Before climbing a fence or crossing a stream are perfect examples. If you need to climb a slip-pery hill and certainly if you are going to climb a tree to hunt from a tree stand, you should unload first. Then, should you lose your balance and lose control of your dun, you will not iconardize your safety of gun, you will not jeopardize your safety or the safety of your companions by dropping a loaded gun which could discharge.

The chances of missing a shot at game by unloading at such times are slim and more than offset by the added safety of unloading.





Never Load or Carry a Loaded Gun Until You Are Ready To Use it

One of the cardinal rules of shooting safety is to load your gun only when ready to use it — and to unload as soon as you are through. A loaded gun has no place in — or near — a car or truck or building. Keep your fingers off the trigger while loading or unloading. For shotgun shooting, don't load until you've started into the field or zero well estitud in a blind. Unload before

into the field or are well settled in a blind. Unload before you leave!

Many big game hunters will not chamber a cartridge until they have actually sighted game and decided to shoot. This is especially true when hunting from tree stands.

Target shooters should never load until it is their turn to shoot, and they should unload immediately if there is a delay in the shooting progression.

Think of yourself and your gun as part of a system whose sate operation depends on you. Your gun can't think. You can. Don't load until ready to shoot — and unload as soon as you're done.





Watch Your Muzzle So the Other Fellow Doesn't Have To

If everyone handled his gun so carefully that the muzzle never pointed at something the gunner didn't intend to shoot, we d have no firearms accidents. It's as simple as that, and it's up to you.

Learn to keep your muzzle always pointed in a safe direction. That may be in the air on some occasions, at the ground on others, but never at anyone or at anything not intended as a target.

You can always tell an experienced shooter by how he or she handles a gun. A knowledgeable shooter always opens the action on a gun before handing it to someone else and always checks to make sure the gun is unloaded if t is handed to him.

Handle guns so others will want to hunt with you, not away from you. You and your gun are parts of a system whose safe operation depends on you. Your gun can't think, but you can.

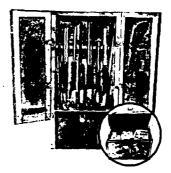
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#### Keep Guns and Ammunition Separately and in Locked Storage

There's really only one basic way to safely store guns and ammunition. They should both be kept locked. separate from one another, with the keys under the control of a responsible adult. Casual visitors and children should find it impossible to handle either without the direct approval, action and supervision of an experienced person totally informed in the principles of safe gun handling. This may take some extra time and effort on your part, but consider the potential consequences of the wrong hands putting guns and ammunition together.





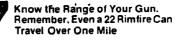
Don't Shoot Unless Absolutely Sure of Your Target and What is Beyond It

You can't call a bullet back. And you can't change its direction.

Once you've pulled the trigger on your rifle. shotgun or handgun, you have given up all control over where the bullet will go or what it will strike. Every shooter whether a big game hunter, upland gunner or plinker owes it to himself and to everyone within range of his firearm to be absolutely sure of his target. Make certain there are no hunters, buildings or other objects behind or near your target.

And make absolutely sure of the target itself. Particularly during the low-light periods of dawn and dusk, it is easy to mistake one shape for another. Scientists call it "Early Blur," and it is one reason you should be totally sure of your target before pulling the trigger.

Firearms safety is up to you. Make no mistake about it.



All shooters hope they will hit what they are aiming at when they pull the trigger. Safe shooters also consider where their shot might go if they miss.

Shooters should keep in mind how far a bullet will travel if it misses its intended target or ricochets in another direction. A 22 short can travel 1½ miles, and a high-velocity cartridge such as a 30-06 can send its bullet more than 3 miles.

Shotgun pellets can travel 500 yards, and shotgun slugs have a range of one-half mile.

Before firing at game or other targets afield, shooters should be certain there are no roads, buildings or livestock in the course of fire, should the bullet go astray. Guns and ammunition cannot think. You can.







**Always Wear Eye and Ear Protection** When Shooting

Most rules of shooting safety are intended to protect you and others around you, but there are two rules that are for your protection alone.

These rules involve the wearing of eye and ear protection. Eye protection can take the form of inexpensive plastic safety glasses, sunglasses, the shooter's own prescription lenses or specialized shooting glasses. They guard against twigs, falling shot, clay target chips and the rare ruptured case or firearm malfunction.

Heavy repeated exposure to shooting noise is not only uncomfortable at the time, it can also cause permanent hearing loss that may not be detected until it is too late.

There are a wide variety of hearing protectors available, ranging from throwaway or reusable ear plugs to sound-deadening muffs that cover the entire ear. No target shooter, plinker or hunter sighting in should ever be without them.

Obey the safety rules that are intended to protect you. Wear ear and eye protection.



#### Always Be Sure the Barrel is Clear of **Obstructions. Only Carry** Ammunition of the Proper Size for the Gun You Are Using

It might be mud, snow or a shotshell wad. It could even be a cleaning patch or the wrong size ammunition placed in your gun's chamber by mistake. All are obstructions that can block a gun barrel and cause serious injury to the shock a gen beck agen becked in the shock agen become lodged in your gun barrel by careless gun handling — as in the case of mud or snow. Or, they may have been left there accidentally by someone else. Proper safety procedures require that all gun barrels be been for a first part of the barrel of the barrels.

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Carry only the proper ammunition for the gun you are shooting. Mixing ammunition causes problems. A 20 gauge shotshell, for example, will pass through the chamber of a 12 gauge and lodge in the barrel. Never allow different types of ammunition to get

mixed up in the pockets of your hunting or shooting coat. It is a simple and basic safety step to check your barrel for obstructions before shooting - for your own safety and to prevent damage to your gun.







**Always Carry Handguns With** the Hammer Down on an **Empty Chamber** 

Handgun safety is largely a matter of common sense and the development of safe habits. For example: ·Carry loaded revolvers with empty chamber under

- the hammer. •Carry loaded pistols with the magazine inserted but
- with an empty chamber. Always empty handguns before carrying into a house. car. boat or RV.
- •Never point a handgun at anything you don't intend to shoot.
- Never handle a handgun without opening it yourself to check to see if it's loaded.
  Always open your handgun and keep it open after
- firing. Be sure of your backstop and what lies beyond it before you shoot. Refer to the instruction manual you received with

your gun.

Safety Series, 1075 Post Road, Riverside, CT 06878

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# MODEL 721-722

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Date Unknown

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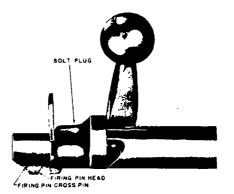
# Details of Disassembly

# 1. BOLT AND COMPONENTS:

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

# 2. FIRING PIN AND COMPONENTS:

Pull firing pin head rearward until a coin can be inserted between it and the bolt plug. (Fig. 1) This can be done by catching the notch in the firing pin head on a sharp corner. Unscrew the bolt plug to remove the firing pin assembly.



#### 3. FIRING PIN:

Drive out the firing pin cross pin (See Fig. 1) with a punch, leaving the punch in the hole to hold parts together to prevent the main spring tension from stripping off the firing pin head and bolt plug forcefully. Compress the main spring with the bolt plug until coin, punch and firing pin head can be removed and release the main spring tension carefully, removing firing pin head, bolt plug and main spring.

## 4. EJECTOR:

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

# Details of Disassembly

# 5. EXTRACTOR:

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. Do not attempt to remove only one end of the extractor and then pull it from the bolt face as bending will result.

# 6. BARREL AND ACTION FROM STOCK:

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower, and trigger guide plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

#### 7. BOLT STOP:

Drive out bolt stop pin, drop rear end of trigger housing, remove bolt stop and bolt stop spring.

#### 8. TRIGGER HOUSING ASSEMBLY:

Drive out sear pin and remove trigger housing assembly from bottom of receiver.

#### 9. TRIGGER HOUSING:

Remove sear, safety cam and sear spring. With a screwdriver or coin push the safety snap washer out of the slot in the safety pivot pin, remove safety detent spring, safety detent ball, safety pivot pin, bolt stop release, and safety. Be careful not to lose the safety detent ball. Remove the front and rear trigger adjusting screws, trigger spring, and trigger stop screw. Drive out the trigger pin and remove trigger and trigger connector.

#### 10. BARREL-RECEIVER ASSEMBLY:

When necessary to disassemble, return rifle to factory.

## Details of Assembly

## 1. TRIGGER HOUSING:

Assemble trigger connector, trigger and drive in trigger pin until it is even with right side of trigger housing. Assemble trigger spring, front trigger adjusting screw, rear trigger adjusting screw, and trigger stop screw.

Assemble safety, bolt stop release, safety pivot pin, safety detent ball, safety detent spring, and safety snap washer.

Assemble sear spring, sear, and safety cam.

2. BOLT ASSEMBLY: EXTRACTOR:

> With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into the bolt face with the fingers.

# 3. EJECTOR:

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

# 4. FIRING PIN:

Assemble main spring and bolt plug, grasp bolt plug and compress main spring, assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

5. FIRING PIN ASSEMBLY:

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

BARREL-ACTION

6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver,

# Details of Assembly

# 6. BOLT STOP: (Cont'd)

and drive bolt stop pin in part way. Raise up rear end of trigger housing until hole aligns, compress sear and safety cam and completely drive in bolt stop pin.

#### 7. BOLT ASSEMBLY:

Assemble bolt assembly in receiver and close, leaving firing pin cocked. Turn the rear trigger adjusting screw right or left to obtain the proper engagement of the trigger connector with the sear. Turn the front trigger adjusting screw right or left to secure the proper weight of pull. Adjust trigger stop screw by turning clockwise until trigger cannot be pulled. Hold on trigger and back off trigger stop screw until firing pin falls.

## 8. BARREL-ACTION-STOCK ASSEMBLY:

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

# Fitting of New Parts and Adjusting

Barrel-Receiver Assembly 1.

- 2. Bolt
- Bolt Plug 3.
- Bolt Stop 4.
- Bolt Stop Release 5.
- 6. Bolt Stop Spring
- 7. Ejector
- 8. Ejector Spring
- 9. Extractor
- 10. Firing Pin 11. Firing Pin Head
- 12. Front Trigger Adjusting Screw
- 13. Main Spring
- 14. Magazine
- 15. Magazine Follower
- 16. Magazine Spring

- 17. Rear Trigger Adjusting Screw 18. Safety 19. Safety Detent 20. Safety Detent Spring
   21. Safety Pivot Pin
   22. Safety Snap Washer
   23. Sear-Safety Cam Assembly
- 24. Sear Spring
- 25. Stock 26. Trigger Assembly
- 27. Trigger
- 28. Trigger Connector
- 29. Trigger Guard
- 30. Trigger Guide Plate

- 31. Trigger Housing 32. Trigger Spring 33. Trigger Stop Screw

#### Fitting of New Parts and Adjusting

## 1. BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

2. <u>BOLT</u>

Remove bolt assembly from receiver.

Remove firing pin assembly, ejector and extractor from bolt.

Try new bolt for freedom in receiver and headspace.

Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver.

Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

3. BOLT PLUG

Remove bolt assembly from receiver.

Remove firing pin assembly from bolt, drive out firing pin cross pin, and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety.

4. BOLT STOP

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop.

After replacing bolt stop, check for freedom of movement.

5. BOLT STOP RELEASE

Remove bolt assembly from receiver, rear, center and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

# Fitting of New Parts and Adjusting

5. BOLT STOP RELEASE (Cont'd)

After replacing bolt stop release, check for freedom of movement.

6. BOLT STOP SPRING

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop and spring.

After replacing bolt stop spring, check for freedom of movement of the bolt stop.

7. EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector.

After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

8. EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

After reassembling ejector spring, check freedom of ejector.

9. EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble a ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection.

# Fitting of New Parts and Adjusting

# 10. FIRING PIN

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Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross cross pin and remove firing pin head, bolt plug and main spring from firing pin.

After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety, and blow.

#### 11. FIRING PIN HEAD

Remove bolt assembly from receiver and firing pin assembly from breech bolt, Drive out firing pin cross pin and remove firing pin head.

After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

#### 12. FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

#### 13. MAIN SPRING

Remove bolt assembly from receiver, and firing pin assembly from bolt.

Drive out firing pin cross pin and remove firing pin head, bolt plug, and main spring.

After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

## 14. MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine, and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding of cartridges.

# Fitting of New Parts and Adjusting

# 15. MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

## 16. MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower.

After reassembling magazine spring, check loading and feeding of cartridges.

# 17. REAK TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

# 18. SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin, and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear, and freedom of movement.

#### 19. SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard'screws, and action from stock. Remove safety snap washer, safety detent spring, and safety detent.

After reassembling new detent, try safety for proper operation.

# Fitting of New Parts and Adjusting

## 20. SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

#### 21. SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety pivot pin.

#### 22. SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer.

#### 23. SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly.

After reassembling new sear-safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

# 24. SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam, and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt, and trigger.

# Fitting of New Parts and Adjusting

# 25. STOCK

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

#### 26. TRIGGER ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly.

After reassembling new trigger assembly, try bolt for cocking firing pin, safety, and trigger for correct weight and travel. Try trigger for proper engagement of trigger connector with sear.

# 27. TRIGGER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger, check trigger for travel and weight of pull. Adjust front and rear trigger adjusting screws and trigger stop screw if required. Try safe and cocking of firing pin.

#### 28. TRIGGER CONNECTOR

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger connector, check trigger for operation and freedom. Try safe and cocking of firing pin.

# Fitting of New Parts and Adjusting

# 29. TRIGGER GUARD

Remove bolt assembly from receiver, front center, and rear trigger guard screws, and trigger guard from stock.

#### 30. TRIGGER GUIDE PLATE

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

# 31. TRIGGER HOUSING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Drive out bolt stop pin part way, drive out sear pin and remove trigger assembly from receiver. Remove all parts from the trigger housing.

After reassembling trigger housing check operation of trigger, safety, bolt, and firing pin. Adjust front and rear trigger adjusting screws, and trigger stop screw, if required.

#### 32. TRICGER SPRING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing.

After reassembling trigger spring, adjust front trigger adjusting screw until the proper weight of trigger pull is accomplished.

#### 33. TRIGGER STOP SCREW

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove trigger stop screw from trigger housing.

After replacing trigger stop screw, adjust until the proper movement of trigger is accomplished.

# Failures to Operate

- 1.
- 2.
- 3.
- 4. 5. 6.
- Does not cock. Ejection fails. Extraction fails. Fails to feed. Missfires Safety does not operate.

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# MODELS 721-722 C.F. BOLT ACTION RIFLES

# Failures to Operate

1. Does not cock

Cause: Not enough trigger engagement with sear. Correction: Back off rear trigger adjusting screw.

2. Ejection fails

Cause: Ejector sticks or weak ejection spring. Correction: Free ejector or fit new ejector spring.

3. Extraction fails

Cause: Extractor worn, broken, or loose. Correction: Fit new extractor. Extractor must not rotate past detent.

4. Fails to feed

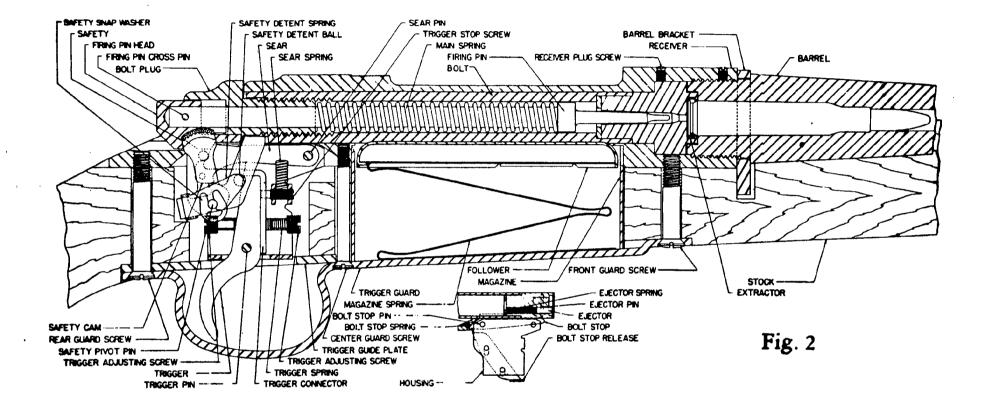
Cause: Catch on cartridge opening in bottom of receiver; magazine spring weak or broken; or, magazine follower sticks. Correction: Chamfer cartridge opening; fit new magazine spring; or, free follower or fit new one.

5. Missfires

Cause: Firing pin sticks or broken; weak main spring; trigger stop screw too far in housing; or, front trigger adjusting screw in too far. Correction: Clean residue or oil off firing pin, or fit new one. Fit new main spring, back off trigger stop screw, back off front trigger adjusting screw, or fit new trigger spring.

# 6. <u>Safety does not operate</u>

Cause: Does not lock bolt, or does not lock safety cam, or tension too light in detents. Correction: Adjust safety, or fit new one; file new safety, or free stock at bolt handle; fit new safety spring.



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# REMINGTON Model 721–722

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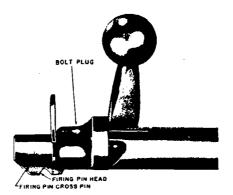
# Details of Disassembly

# 1. BOLT AND COMPONENTS:

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

# 2. FIRING PIN AND COMPONENTS:

Pull firing pin head rearward until a coin can be inserted between it and the bolt plug. (Fig. 1) This can be done by catching the notch in the firing pin head on a sharp corner. Unscrew the bolt plug to remove the firing pin assembly:



#### 3. FIRING PIN:

Drive out the firing pin cross pin (See Fig. 1) with a punch, leaving the punch in the hole to hold parts together to prevent the main spring tension from stripping off the firing pin head and bolt plug forcefully. Compress the main spring with the bolt plug until coin, punch and firing pin head can be removed and release the main spring tension carefully, removing firing pin head, bolt plug and main spring.

# 4. EJECTOR:

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

# Details of Disassembly

# 5. EXTRACTOR:

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. Do not attempt to remove only one end of the extractor and then pull it from the bolt face as bending will result.

#### 6. BARREL AND ACTION FROM STOCK:

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower, and trigger guide plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

#### 7. BOLT STOP:

Drive out bolt stop pin, drop rear end of trigger housing, remove bolt stop and bolt stop spring.

# 8. TRIGGER HOUSING ASSEMBLY:

Drive out sear pin and remove trigger housing assembly from bottom of receiver.

# 9. TRIGGER HOUSING:

Remove sear, safety cam and sear spring. With a screwdriver or coin push the safety snap washer out of the slot in the safety pivot pin, remove safety detent spring, safety detent ball, safety pivot pin, bolt stop release, and safety. Be careful not to lose the safety detent ball. Remove the front and rear trigger adjusting screws, trigger spring, and trigger stop screw. Drive out the trigger pin and remove trigger and trigger connector.

#### 10. BARREL-RECEIVER ASSEMBLY:

When necessary to disassemble, return rifle to factory.

# Details of Assembly

#### 1. TRIGGER HOUSING:

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Assemble trigger connector, trigger and drive in trigger pin until it is even with right side of trigger housing. Assemble trigger spring, front trigger adjusting screw, rear trigger adjusting screw, and trigger stop screw.

Assemble safety, bolt stop release, safety pivot pin, safety detent ball, safety detent spring, and safety snap washer.

Assemble sear spring, sear, and safety cam.

2. BOLT ASSEMBLY: EXTRACTOR:

> With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into the bolt face with the fingers.

#### 3. EJECTOR:

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

4. FIRING PIN:

Assemble main spring and bolt plug, grasp bolt plug and compress main spring, assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

#### 5. FIRING PIN ASSEMBLY:

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

#### BARREL-ACTION

6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver,

# Details of Assembly

# 6. BOLT STOP: (Cont'd)

and drive bolt stop pin in part way. Raise up rear end of trigger housing until hole aligns, compress sear and safety cam and completely drive in bolt stop pin.

# 7. BOLT ASSEMBLY:

Assemble bolt assembly in receiver and close, leaving firing pin cocked. Turn the rear trigger adjusting screw right or left to obtain the proper engagement of the trigger connector with the sear. Turn the front trigger adjusting screw right or left to secure the proper weight of pull. Adjust trigger stop screw by turning clockwise until trigger cannot be pulled. Hold on trigger and back off trigger stop screw until firing pin falls.

#### 8. BARREL-ACTION-STOCK ASSEMBLY:

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

# Fitting of New Parts and Adjusting

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	Barrel-Receiver Assembly Bolt	17.	Rear Trigger Adjusting Screw
		10	
-	Bolt Plug		Safety
	Bolt Stop	19.	Safety Detent
5.	Bolt Stop Release	20.	Safety Detent Spring
6.	Bolt Stop Spring		Safety Pivot Pin
7.	Ejector	22.	Safety Snap Washer
8.	Ejector Spring	23.	Sear-Safety Cam Assembly
9.	Extractor	24.	Sear Spring
10.	Firing Pin	25.	Stock
11.	Firing Pin Head	26.	Trigger Assembly
12.	Front Trigger Adjusting	27.	Trigger
	Screw	28.	Trigger Connector
13.	Main Spring		Trigger Guard
14.	Magazine		Trigger Guide Plate
15.	Magazine Follower	31.	Trigger Housing
16.	Magazine Spring	32.	Trigger Spring
			Trigger Stop Screw

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#### MODELS 721-722 C.F. BOLT ACTION RIFLES

# Fitting of New Parts and Adjusting

## 1. BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

2. <u>BOLT</u>

Remove bolt assembly from receiver.

Remove firing pin assembly, ejector and extractor from bolt.

Try new bolt for freedom in receiver and head-space.

Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver.

Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

3. BOLT PLUG

Remove bolt assembly from receiver.

Remove firing pin assembly from bolt, drive out firing pin cross pin, and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety.

4. BOLT STOP

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop.

After replacing bolt stop, check for freedom of movement.

5. BOLT STOP RELEASE

Remove bolt assembly from receiver, rear, center and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

### Fitting of New Parts and Adjusting

5. BOLT\_STOP RELEASE (Cont'd)

After replacing bolt stop release, check for freedom of movement.

6. BOLT STOP SPRING

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop and spring.

After replacing bolt stop spring, check for freedom of movement of the bolt stop.

7. EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector.

After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

8. EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

After reassembling ejector spring, check freedom of ejector.

### 9. EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble a ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection.

#### Fitting of New Parts and Adjusting

### 10. FIRING PIN

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross cross pin and remove firing pin head, bolt plug and main spring from firing pin.

After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety, and blow.

### 11. FIRING PIN HEAD

Remove bolt assembly from receiver and firing pin assembly from breech bolt, Drive out firing pin cross pin and remove firing pin head.

After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

### 12. FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

### 13. MAIN SPRING

Remove bolt assembly from receiver, and firing pin assembly from bolt.

Drive out firing pin cross pin and remove firing pin head, bolt plug, and main spring.

After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

### 14. MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine, and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding of cartridges.

#### Fitting of New Parts and Adjusting

### 15. MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

### 16. MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower.

After reassembling magazine spring, check loading and feeding of cartridges.

### 17. REAL TRICCER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

#### 18. SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin, and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear, and freedom of movement.

### 19. SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, and safety detent.

After reassembling new detent, try safety for proper operation.

Fitting of New Parts and Adjusting

### 20. SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

### 21. SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety pivot pin.

### 22. SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer.

### 23. SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly.

After reassembling new sear-safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

### 24. SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam, and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt, and trigger.

### Fitting of New Parts and Adjusting

### 25. <u>STOCK</u>

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

### 26. TRIGGER ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly.

After reassembling new trigger assembly, try bolt for cocking firing pin, safety, and trigger for correct weight and travel. Try trigger for proper engagement of trigger connector with sear.

### 27. TRIGGER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger, check trigger for travel and weight of pull. Adjust front and rear trigger adjusting screws and trigger stop screw if required. Try safe and cocking of firing pin.

#### 28. TRIGGER CONNECTOR

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger connector, check trigger for operation and freedom. Try safe and cocking of firing pin.

Fitting of New Parts and Adjusting

### 29. TRIGGER GUARD

Remove bolt assembly from receiver, front center, and rear trigger guard screws, and trigger guard from stock.

### 30. TRIGGER GUIDE PLATE

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

### 31. TRIGGER HOUSING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Drive out bolt stop pin part way, drive out sear pin and remove trigger assembly from receiver. Remove all parts from the trigger housing.

After reassembling trigger housing check operation of trigger, safety, bolt, and firing pin. Adjust front and rear trigger adjusting screws, and trigger stop screw, if required.

### 32. TRIGGER SPRING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing.

After reassembling trigger spring, adjust front trigger adjusting screw until the proper weight of trigger pull is accomplished.

### 33. TRIGGER STOP SCREW

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove trigger stop screw from trigger housing.

After replacing trigger stop screw, adjust until the proper movement of trigger is accomplished.

721-722-13

### MODELS 721-722 C. F. BOLT ACTION RIFLES

### Fitting of New Parts and Adjusting

IMPORTANT: No adjustment or removal of the rear trigger adjusting screw is recommended unless replacement is necessary. The rear trigger adjusting screw is set at the factory to engage the trigger and provide the correct amount of supporting trigger connector surface beneath the sear.

Pull of Trigger - is adjusted to the desired weight by turning the front trigger adjusting screw clockwise for a heavier weight adjustment and counter clockwise for a lighter weight adjustment.

Travel of the Trigger - may be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

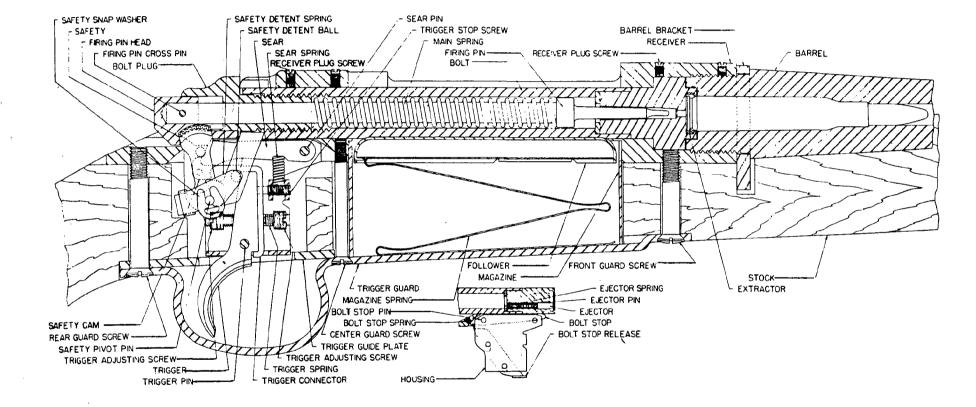
### Failures to Operate

- Does not cock. 1. 2. Ejection fails.
- Extraction fails. 3.
- 4. Fails to feed.
- Missfires

. . . . .

5. 6. Safety does not operate.

J.F. Finnegan:emb August 1956



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# REMINGTON Model 721–722

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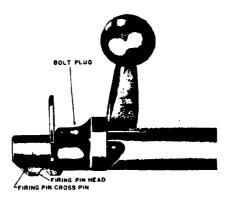
### Details of Disassembly

### 1. BOLT AND COMPONENTS:

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

### 2. FIRING PIN AND COMPONENTS:

Pull firing pin head rearward until a coin can be inserted between it and the bolt plug. (Fig. 1) This can be done by catching the notch in the firing pin head on a sharp corner. Unscrew the bolt plug to remove the firing pin assembly:



### 3. FIRING PIN:

Drive out the firing pin cross pin (See Fig. 1) with a punch, leaving the punch in the hole to hold parts together to prevent the main spring tension from stripping off the firing pin head and bolt plug forcefully. Compress the main spring with the bolt plug until coin, punch and firing pin head can be removed and release the main spring tension carefully, removing firing pin head, bolt plug and main spring.

### 4. EJECTOR:

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

### Details of Disassembly

### 5. EXTRACTOR:

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. Do not attempt to remove only one end of the extractor and then pull it from the bolt face as bending will result.

### 6. BARREL AND ACTION FROM STOCK:

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower, and trigger guide plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

### 7. BOLT STOP:

Drive out bolt stop pin, drop rear end of trigger housing, remove bolt stop and bolt stop spring.

### 8. TRIGGER HOUSING ASSEMBLY:

Drive out sear pin and remove trigger housing assembly from bottom of receiver.

### 9. TRIGGER HOUSING:

Remove sear, safety cam and sear spring. With a screwdriver or coin push the safety snap washer out of the slot in the safety pivot pin, remove safety detent spring, safety detent ball, safety pivot pin, bolt stop release, and safety. Be careful not to lose the safety detent ball. Remove the front and rear trigger adjusting screws, trigger spring, and trigger stop screw. Drive out the trigger pin and remove trigger and trigger connector.

### 10. BARREL-RECEIVER ASSEMBLY:

When necessary to disassemble, return rifle to factory.

### Details of Assembly

### 1. TRIGGER HOUSING:

Assemble trigger connector, trigger and drive in trigger pin until it is even with right side of trigger housing. Assemble trigger spring, front trigger adjusting screw, rear trigger adjusting screw, and trigger stop screw.

Assemble safety, bolt stop release, safety pivot pin, safety detent ball, safety detent spring, and safety snap washer.

Assemble sear spring, sear, and safety cam.

2. <u>BOLT ASSEMBLY</u>: EXTRACTOR:

> With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into the bolt face with the fingers.

### 3. EJECTOR:

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

### 4. FIRING PIN:

Assemble main spring and bolt plug, grasp bolt plug and compress main spring, assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

### 5. FIRING PIN ASSEMBLY:

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

BARREL-ACTION

6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver, 721 - 722-4

### MODELS 721-722 C.F. BOLT ACTION RIFLES

### Details of Assembly

6. BOLT STOP: (Cont'd)

and drive bolt stop pin in part way. Raise up rear end of trigger housing until hole aligns, compress sear and safety cam and completely drive in bolt stop pin.

### 7. BOLT ASSEMBLY:

Assemble bolt assembly in receiver and close, leaving firing pin cocked. Turn the rear trigger adjusting screw right or left to obtain the proper engagement of the trigger connector with the sear. Turn the front trigger adjusting screw right or left to secure the proper weight of pull. Adjust trigger stop screw by turning clockwise until trigger cannot be pulled. Hold on trigger and back off trigger stop screw until firing pin falls.

### 8. BARREL-ACTION-STOCK ASSEMBLY:

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

### Fitting of New Parts and Adjusting

1. Barrel-Receiver Assembly 17. Rear Trigger Adjusting 2. Bolt Screw Bolt Plug 18. Safety 3. 19. Safety Detent Bolt Stop 4. 20. Safety Detent Spring 21. Safety Pivot Pin 5. 6. Bolt Stop Release Bolt Stop Spring 22. Safety Snap Washer 23. Sear-Safety Cam Assembly 7. 8. Ejector Ejector Spring 24. Sear Spring 9. Extractor Stock
 Trigger Assembly
 Trigger Connector 10. Firing Pin 11. Firing Pin Head 12. Front Trigger Adjusting Screw 13. Main Spring 29. Trigger Guard 30. Trigger Guide Plate 14. Magazine 31. Trigger Housing 32. Trigger Spring 33. Trigger Stop Screw 15. Magazine Follower 16. Magazine Spring

### Fitting of New Parts and Adjusting

#### 1. BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

### 2. <u>BOLT</u>

Remove bolt assembly from receiver.

Remove firing pin assembly, ejector and extractor from bolt.

Try new bolt for freedom in receiver and headspace.

Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver.

Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

3. BOLT PLUG

Remove bolt assembly from receiver.

Remove firing pin assembly from bolt, drive out firing pin cross pin, and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety.

4. BOLT STOP

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop.

After replacing bolt stop, check for freedom of movement.

#### 5. BOLT STOP RELEASE

Remove bolt assembly from receiver, rear, center and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

### Fitting of New Parts and Adjusting

### 5. BOLT STOP RELEASE (Cont'd)

After replacing bolt stop release, check for freedom of movement.

6. BOLT STOP SPRING

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop and spring.

After replacing bolt stop spring, check for freedom of movement of the bolt stop.

7. EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector.

After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

### 8. EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

After reassembling ejector spring, check freedom of ejector.

### 9. EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble a ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection. 

#### MODELS 721-722 C.F. BOLT ACTION RIFLES

### Fitting of New Parts and Adjusting

### 10. FIRING PIN

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross cross pin and remove firing pin head, bolt plug and main spring from firing pin.

After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety, and blow.

### 11. FIRING PIN HEAD

Remove bolt assembly from receiver and firing pin assembly from breech bolt, Drive out firing pin cross pin and remove firing pin head.

After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

### 12. FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

### 13. MAIN SPRING

Remove bolt assembly from receiver, and firing pin assembly from bolt.

Drive out firing pin cross pin and remove firing pin head, bolt plug, and main spring.

After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

#### 14. MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine, and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding of cartridges.

#### Fitting of New Parts and Adjusting

### 15. MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

#### 16. MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower.

After reassembling magazine spring, check loading and feeding of cartridges.

#### 17. REAK TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

### 18. SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin, and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear, and freedom of movement.

#### 19. SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, and safety detent.

After reassembling new detent, try safety for proper operation.

### Fitting of New Parts and Adjusting

### 20. SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

### 21. SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety pivot pin.

### 22. SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer.

### 23. SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly.

After reassembling new sear-safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

### 24. SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam, and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt, and trigger.

### Fitting of New Parts and Adjusting

### 25. STOCK

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

#### 26. TRIGGER ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly.

After reassembling new trigger assembly, try bolt for cocking firing pin, safety, and trigger for correct weight and travel. Try trigger for proper engagement of trigger connector with sear.

#### 27. TRIGGER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger, check trigger for travel and weight of pull. Adjust front and rear trigger adjusting screws and trigger stop screw if required. Try safe and cocking of firing pin.

#### 28. TRIGGER CONNECTOR

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger connector, check trigger for operation and freedom. Try safe and cocking of firing pin. 721 - 722-12

### MODELS 721-722 C.F. BOLT ACTION RIFLES

### Fitting of New Parts and Adjusting

### 29. TRIGGER GUARD

Remove bolt assembly from receiver, front center, and rear trigger guard screws, and trigger guard from stock.

### 30. TRIGGER GUIDE PLATE

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

### 31. TRIGGER HOUSING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Drive out bolt stop pin part way, drive out sear pin and remove trigger assembly from receiver. Remove all parts from the trigger housing.

After reassembling trigger housing check operation of trigger, safety, bolt, and firing pin. Adjust front and rear trigger adjusting screws, and trigger stop screw, if required.

### 32. TRIGGER SPRING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing.

After reassembling trigger spring, adjust front trigger adjusting screw until the proper weight of trigger pull is accomplished.

### 33. TRIGGER STOP SCREW

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove trigger stop screw from trigger housing.

After replacing trigger stop screw, adjust until the proper movement of trigger is accomplished.

# MODELS 721-722 C. F. BOLT ACTION RIFLES Fitting of New Parts and Adjusting

IMPORTANT: No adjustment or removal of the rear trigger adjusting screw is recommended unless replacement is necessary. The rear trigger adjusting screw is set at the factory to engage the trigger and provide the correct amount of supporting trigger connector surface beneath the sear.

<u>Pull of Trigger</u> - is adjusted to the desired weight by turning the front trigger adjusting screw clockwise for a heavier weight adjustment and counter clockwise for a lighter weight adjustment.

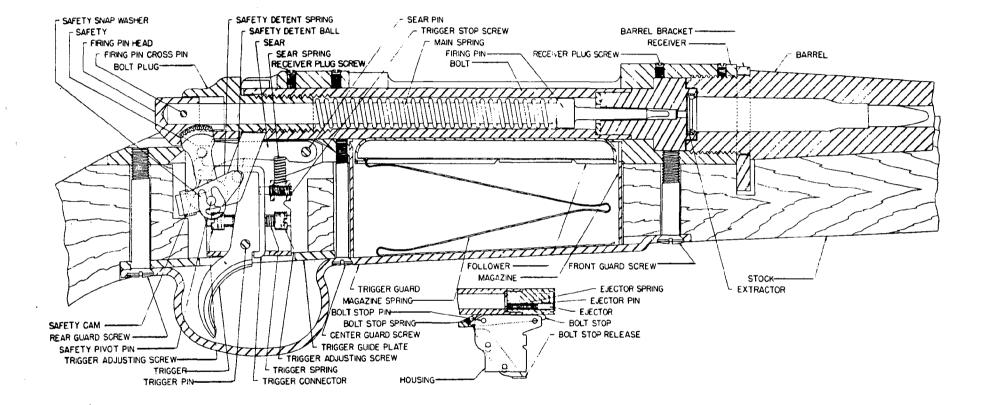
<u>Travel of the Trigger</u> - may be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

### Failures to Operate

Does not cock.
 Ejection fails.
 Extraction fails.
 Fails to feed.
 Missfires
 Safety does not operate.

J.F. Finnegan:emb August 1956

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## REMINGTON FIELD SERVICE MANUAL

#### DISASSEMBLY

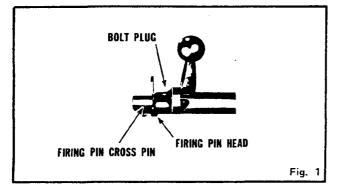
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#### BOLT AND COMPONENTS

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

#### FIRING PIN AND COMPONENTS

Pull firing pin head rearward until a coin can be inserted between it and bolt plug. (Fig. 1). This can be done by catching notch in firing pin head on a sharp corner. Unscrew bolt plug to remove firing pin assembly.



#### **FIRING PIN**

Drive out firing pin cross pin (See Fig. 1) with a punch, leaving punch in hole to hold parts together to prevent main spring tension from stripping off firing pin head and bolt plug forcefully. Compress main spring with bolt plug until coin, punch and firing pin head can be removed and release main spring tension carefully, removing firing pin head, bolt plug and main spring.

#### EJECTOR

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

#### EXTRACTOR

With pointed tweezers inserted in holes provided in the ends of extractor, compress ends together until extractor can be removed from face of bolt. Do not attempt to remove only one end of extractor and then pull it from bolt face as bending will result.

### BARREL AND ACTION FROM STOCK

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower and trigger guide

plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

#### BOLT STOP

Drive out bolt stop pin, drop rear end of trigger housing, remove bolt stop and bolt stop spring.

#### TRIGGER HOUSING ASSEMBLY

Drive out sear pin and remove trigger housing assembly from bottom of receiver.

#### TRIGGER HOUSING

Remove sear, safety cam and sear spring. With a screwdriver or coin push the safety snap washer out of slot in safety pivot pin, remove safety detent spring, safety detent ball, safety pivot pin, bolt stop release, and safety. Be careful not to lose safety detent ball. Remove front and rear trigger adjusting screws, trigger spring, and trigger stop screw. Drive out trigger pin and remove trigger and trigger connector.

#### BARREL-RECEIVER ASSEMBLY

When necessary to disassemble, return rifle to factory.

ASSEMBLY

#### TRIGGER HOUSING

Assemble trigger connector, trigger and drive in trigger pin until it is even with right side of trigger housing. Assemble trigger spring, front trigger adjusting screw, rear trigger adjusting screw, and trigger stop screw. Assemble safety, bolt stop release, safety pivot pin, safety detent ball, safety detent spring, and safety snap washer.

Assemble sear spring, sear and safety cam.

#### BOLT ASSEMBLY EXTRACTOR

With pointed tweezers inserted in holes provided in end of extractor, compress ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into bolt face with fingers.

#### EJECTOR

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

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### FIRING PIN

Assemble main spring and bolt plug, grasp bolt plug and compress main spring. Assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

#### FIRING PIN ASSEMBLY

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

#### BARREL-ACTION

#### BOLT STOP

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver, and drive bolt stop pin in part way. Raise up rear end of trigger housing until hole aligns, compress sear and safety cam and completely drive in bolt stop pin.

#### BOLT ASSEMBLY

Assemble bolt assembly in receiver and close, leaving firing pin cocked. Turn rear trigger adjusting screw right or left to obtain proper engagement of trigger connector with sear. Turn front trigger adjusting screw right or left to secure proper weight of pull. Adjust trigger stop screw by turning clockwise until trigger cannot be pulled. Hold on trigger and back off trigger stop screw until firing pin falls.

#### BARREL-ACTION-STOCK ASSEMBLY

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

#### FITTING OF NEW PARTS AND ADJUSTING

#### BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

#### BOLT

Remove bolt assembly from receiver. Remove firing pin assembly, ejector and extractor from bolt. Try new bolt for freedom in receiver and headspace. Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver. Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

#### BOLT PLUG

Remove bolt assembly from receiver. Remove firing pin assembly from bolt, drive out firing pin cross pin and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety.

#### BOLT STOP

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and remove bolt stop. After replacing bolt stop, check for freedom of movement.

#### BOLT STOP RELEASE

Remove bolt assembly from receiver, rear center and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

After replacing bolt stop release, check for freedom of movement.

#### BOLT STOP SPRING

Remove bolt assembly from receiver, rear, center and front trigger guard screw, and action from stock. Drive out bolt stop pin part way and remove bolt stop and spring. After replacing bolt stop spring, check for freedom of movement of the bolt stop.

#### EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector. After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

#### EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring. After reassembling ejector spring, check freedom of ejector.

#### EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring. With pointed tweezers inserted in holes provided in ends of extractor, compress ends together until extractor can be removed from face of bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection.

#### FIRING PIN

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring from firing pin.

After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety, and blow.

#### FIRING PIN HEAD

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross pin and remove

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firing pin head. After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

#### FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

#### MAIN SPRING

Remove bolt assembly from receiver and firing pin assembly from bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring. After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

#### MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding or cartridges.

#### MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

#### MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower. After reassembling magazine spring, check loading and feeding of cartridges.

#### REAR TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

#### SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear and freedom of movement.

#### SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer, safety detent spring and safety detent.

After reassembling new detent, try safety for proper operation.

#### SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

#### SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

#### SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer.

#### SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, sear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly;

After reassembling new sear-safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

#### SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt and trigger.

#### STOCK .

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

### MODEL 721-722

#### TRIGGER ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly.

After reassembling new trigger assembly, try bolt for cocking firing pin, safety, and trigger for correct weight and travel. Try trigger for proper engagement of trigger connector with sear.

#### TRIGGER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger, check trigger for travel and weight of pull. Adjust front and rear trigger adjusting screws and trigger stop screw if required. Try safe and cocking of firing pin.

#### TRIGGER CONNECTOR

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger connector, check trigger for operation and freedom. Try safe and cocking of firing pin.

#### TRIGGER GUARD

Remove bolt assembly from receiver, front center, and rear trigger guard screws and trigger guard from stock.

#### TRIGGER GUIDE PLATE

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

#### TRIGGER HOUSING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws and action from stock. Drive out bolt stop pin part way, drive out sear pin and remove trigger assembly from receiver. Remove all parts from trigger housing.

After reassembling trigger housing check operation of trigger, safety, bolt, and firing pin. Adjust front and rear trigger adjusting screws and trigger stop screw, if required.

#### TRIGGER SPRING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing After reassembling trigger spring, adjust front trigger adjusting screw until the proper weight of trigger pull is accomplished.

### TRIGGER STOP SCREW

Remove bolt assembly from receiver, front, center, and rear trigger guard screws and action from stock. Remove trigger stop screw from trigger housing.

After replacing trigger stop screw, adjust until proper movement of trigger is accomplished.

# **CYCLE OF OPERATION**

The operation cycle of the Model 721-722 is similar and common with most hand-operated bolt action rifles. Firing, movement of Bolt Handle upward and fully back to open, then forward again and down to close Bolt completes cycle. Presuming rifle to be fully loaded with one cartridge locked in barrel chamber, the sequence for operations cycle is as follows:

#### FIRING

The firing cycle is simply the release of a spring-loaded firing pin. The forward thrust of the spring-Urged pin strikes primer of cartridge with sufficient force to indent primer and ignite powder charge. With thumb-operated safety in "OFF" position, rifle is fired by pulling trigger rearward, In detail, the rearward movement of trigger carrier trigger connector forward. This action deprives blocked sear of its support and permits it to be cammed downward by pressure from cocked firing pin. As this support is removed beneath sear, firing pin cams sear downward and sear cams connector forward. Action of connector is to allow shortest movement of trigger possible with absolutely no over-travel.

#### UNLOCK

After firing, the upward swing of bolt handle rotates bolt. The two locking lugs at head of bolt are then unseated from support of two locking shoulders in Receiver. The bolt is then free to be withdrawn rearward.

#### COCK

Simutaneously with the unlocking cycle, a cam at rear of rotating bolt withdraws and locates firing pin to a partially cocked position on rear perimeter of bolt. The remainder of cocking is accomplished during locking cycle.

#### EXTRACTION

The rim of cartridge is seated within Bolt Head and is gripped by claw of a circular recessed Extractor. During the latter portion of rotation of Bolt Handle for unlocking a primary extraction cam retracts Bolt approximately 1/8" with a mechanical advantage of 8–1. With Bolt Handle turned fully upward and lugs of Bolt clear of locking shoulders in Receiver, bolt is free to be withdrawn rearward and complete extraction.

#### EJECTION

A spring urged pin ejector is located within bolt face and maintains outward pressure on base of cartridge. As bolt is moved rearward and front of cartridge or fired case reaches ejection port, constant pressure of ejector and opposing grip of extractor eject cartridge case from open port of receiver.

#### FEEDING

As fired cartridge is ejected, rearward travel of bolt is halted by bolt stop. As bolt clears magazine opening, top cartridge in magazine is urged upward by magazine spring and into feeding position. With action completely open, initial return movement of bolt engages rim of top cartridge fed from magazine. The continued forward travel of bolt advances cartridge up incline of Receiver and into chamber. Guided by bullet end of cartridge entering chamber, rear end is leveled free of feeding lip of Receiver.

#### LOADING

Resting ahead of advancing bolt, cartridge is urged forward and loaded into barrel chamber.

#### LOCKING

With action closed and cartridge full seated in chamber, further movement of Bolt Handle **downward** rotates and locks Bolt against chambered cartridge. During this rotary locking cycle, three engagements are effected: (1) The two lugs on bolt head are firmly supported by the locking shoulders within receiver; (2) Base of cartridge is seated in head of bolt, depressing ejector and flexing extractor to snap claw over rim of cartridge; and (3) Sear engages a camming surface on firing pin head, cocking cam of bolt is disengaged from firing pin and rotated to firing position, Sear is blocked in firing position by trigger and trigger connector until released by trigger action.

#### SAFETY

The thumb-operated Safety, located at rear right side of Receiver, has two functions. With action closed and Bolt in a locked position, rearward pivot of safety ("ON" position) will place a supporting member under safety cams which will in turn prevent release of cocked firing pin. The second function with safety in the same "ON" position will swing a locking blade into a channel at bottom rear of Bolt. This will lock Bolt in a closed position: With safety clicked forward in "OFF" position, internal conditions described above will be nonexistent, thereby permitting rifle to be fired.

The instructions for Loading and Unloading, with directions for disassembly and care of rifle are contained in the instruction folder supplied with each rifle.

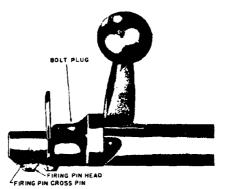
### Details of Disassembly

### 1. BOLT AND COMPONENTS:

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

#### 2. FIRING PIN AND COMPONENTS:

Pull firing pin head rearward until a coin can be inserted between it and the bolt plug. (Fig. 1) This can be done by catching the notch in the firing pin head on a sharp corner. Unscrew the bolt plug to remove the firing pin assembly:



### 3. FIRING PIN:

Drive out the firing pin cross pin (See Fig. 1) with a punch, leaving the punch in the hole to hold parts together to prevent the main spring tension from stripping off the firing pin head and bolt plug forcefully. Compress the main spring with the bolt plug until coin, punch and firing pin head can be removed and release the main spring tension carefully, removing firing pin head, bolt plug and main spring.

### 4. EJECTOR:

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

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### MODELS 721-722 C.F. BOLT ACTION RIFLES

### Details of Disassembly

### 5. EXTRACTOR:

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. Do not attempt to remove only one end of the extractor and then pull it from the bolt face as bending will result.

### 6. BARREL AND ACTION FROM STOCK:

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower, and trigger guide plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

### 7. BOLT STOP:

Drive out bolt stop pin, drop rear end of trigger housing, remove bolt stop and bolt stop spring.

### 8. TRIGGER HOUSING ASSEMBLY:

Drive out sear pin and remove trigger housing assembly from bottom of receiver.

### 9. TRIGGER HOUSING:

Remove sear, safety cam and sear spring. With a screwdriver or coin push the safety snap washer out of the slot in the safety pivot pin, remove safety detent spring, safety detent ball, safety pivot pin, bolt stop release, and safety. Be careful not to lose the safety detent ball. Remove the front and rear trigger adjusting screws, trigger spring, and trigger stop screw. Drive out the trigger pin and remove trigger and trigger connector.

### 10. BARREL-RECEIVER ASSEMBLY:

When necessary to disassemble, return rifle to factory.

### Details of Assembly

### 1. TRIGGER HOUSING:

Assemble trigger connector, trigger and drive in trigger pin until it is even with right side of trigger housing. Assemble trigger spring, front trigger adjusting screw, rear trigger adjusting screw, and trigger stop screw.

Assemble safety, bolt stop release, safety pivot pin, safety detent ball, safety detent spring, and safety snap washer.

Assemble sear spring, sear, and safety cam.

2. <u>BOLT ASSEMBLY</u>: EXTRACTOR:

> With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into the bolt face with the fingers.

#### 3. EJECTOR:

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

### 4. FIRING PIN:

Assemble main spring and bolt plug, grasp bolt plug and compress main spring, assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

### 5. FIRING PIN ASSEMBLY:

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

### BARREL-ACTION

6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver, 721 - 722-4

### MODELS 721-722 C.F. BOLT ACTION RIFLES

### Details of Assembly

6. BOLT STOP: (Cont'd)

and drive bolt stop pin in part way. Raise up rear end of trigger housing until hole aligns, compress sear and safety cam and completely drive in bolt stop pin.

### 7. BOLT ASSEMBLY:

Assemble bolt assembly in receiver and close, leaving firing pin cocked. Turn the rear trigger adjusting screw right or left to obtain the proper engagement of the trigger connector with the sear. Turn the front trigger adjusting screw right or left to secure the proper weight of pull. Adjust trigger stop screw by turning clockwise until trigger cannot be pulled. Hold on trigger and back off trigger stop screw until firing pin falls.

### 8. BARREL-ACTION-STOCK ASSEMBLY:

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

### Fitting of New Parts and Adjusting

- 1. Barrel-Receiver Assembly
- 2. Bolt
- 3. Bolt Plug
- 4. Bolt Stop
- 5. Bolt Stop Release
- 6. Bolt Stop Spring

- Joir Stop Spring
   Ejector
   Ejector Spring
   Extractor
   Firing Pin
   Firing Pin Head
   Front Trigger Adjusting Screw
- 13. Main Spring
- 14. Magazine
- 15. Magazine Follower
- 16. Magazine Spring
- 17. Rear Trigger Adjusting Screw 18. Safety 19. Safety Detent Safety Detent
   Safety Detent Spring
   Safety Pivot Pin
   Safety Snap Washer
   Sear-Safety Cam Assembly
   Sear Spring
   Stock
   Trigger Assembly
   Trigger Connector
   Trigger Guard

- 29. Trigger Guard

- 30. Trigger Guide Plate 31. Trigger Housing 32. Trigger Spring 33. Trigger Stop Screw

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### MODELS 721-722 C.F. BOLT ACTION RIFLES

### Fitting of New Parts and Adjusting

### 1. BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

### 2. <u>BOLT</u>

Remove bolt assembly from receiver.

Remove firing pin assembly, ejector and extractor from bolt.

Try new bolt for freedom in receiver and headspace.

Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver.

Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

3. BOLT PLUG

Remove bolt assembly from receiver.

Remove firing pin assembly from bolt, drive out firing pin cross pin, and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety.

4. BOLT STOP

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop.

After replacing bolt stop, check for freedom of movement.

#### 5. BOLT STOP RELEASE

Remove bolt assembly from receiver, rear, center and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

### Fitting of New Parts and Adjusting

5. BOLT STOP RELEASE (Cont'd)

After replacing bolt stop release, check for freedom of movement.

6. BOLT STOP SPRING

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock.

Drive out bolt stop pin part way and remove bolt stop and spring.

After replacing bolt stop spring, check for freedom of movement of the bolt stop.

7. EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector.

After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

### 8. EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

After reassembling ejector spring, check freedom of ejector.

9. EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring.

With pointed tweezers inserted in the holes provided in the ends of the extractor, compress the ends together until the extractor can be removed from the face of the bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble a ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection.

### Fitting of New Parts and Adjusting

### 10. FIRING PIN

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross cross pin and remove firing pin head, bolt plug and main spring from firing pin.

After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety, and blow.

#### 11. FIRING PIN HEAD

Remove bolt assembly from receiver and firing pin assembly from breech bolt, Drive out firing pin cross pin and remove firing pin head.

After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

### 12. FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

### 13. MAIN SPRING

Remove bolt assembly from receiver, and firing pin assembly from bolt.

Drive out firing pin cross pin and remove firing pin head, bolt plug, and main spring.

After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

#### 14. MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine, and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding of cartridges.

# Fitting of New Parts and Adjusting

# 15. MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

### 16. MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower.

After reassembling magazine spring, check loading and feeding of cartridges.

#### 17. REAR TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

## 18. SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin, and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear, and freedom of movement.

# 19. SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, and safety detent.

After reassembling new detent, try safety for proper operation.

Fitting of New Parts and Adjusting

# 20. SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

# 21. SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer and safety pivot pin.

#### 22. SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer.

# 23. SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly.

After reassembling new sear-safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

# 24. SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam, and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt, and trigger.

# Fitting of New Parts and Adjusting

# 25. STOCK

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

#### 26. TRIGGER ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly.

After reassembling new trigger assembly, try bolt for cocking firing pin, safety, and trigger for correct weight and travel. Try trigger for proper engagement of trigger connector with sear.

#### 27. TRIGGER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger, check trigger for travel and weight of pull. Adjust front and rear trigger adjusting screws and trigger stop screw if required. Try safe and cocking of firing pin.

#### 28. TRIGGER CONNECTOR

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger connector, check trigger for operation and freedom. Try safe and cocking of firing pin.

# Fitting of New Parts and Adjusting

# 29. TRIGGER GUARD

Remove bolt assembly from receiver, front center, and rear trigger guard screws, and trigger guard from stock.

# 30. TRIGGER GUIDE PLATE

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

# 31. TRIGGER HOUSING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Drive out bolt stop pin part way, drive out sear pin and remove trigger assembly from receiver. Remove all parts from the trigger housing.

After reassembling trigger housing check operation of trigger, safety, bolt, and firing pin. Adjust front and rear trigger adjusting screws, and trigger stop screw, if required.

### 32. TRIGGER SPRING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing.

After reassembling trigger spring, adjust front trigger adjusting screw until the proper weight of trigger pull is accomplished.

# 33. TRIGGER STOP SCREW

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, and action from stock. Remove trigger stop screw from trigger housing.

After replacing trigger stop screw, adjust until the proper movement of trigger is accomplished.

# Fitting of New Parts and Adjusting

IMPORTANT: No adjustment or removal of the rear trigger adjusting screw is recommended unless replacement is necessary. The rear trigger adjusting screw is set at the factory to engage the trigger and provide the correct amount of supporting trigger connector surface beneath the sear.

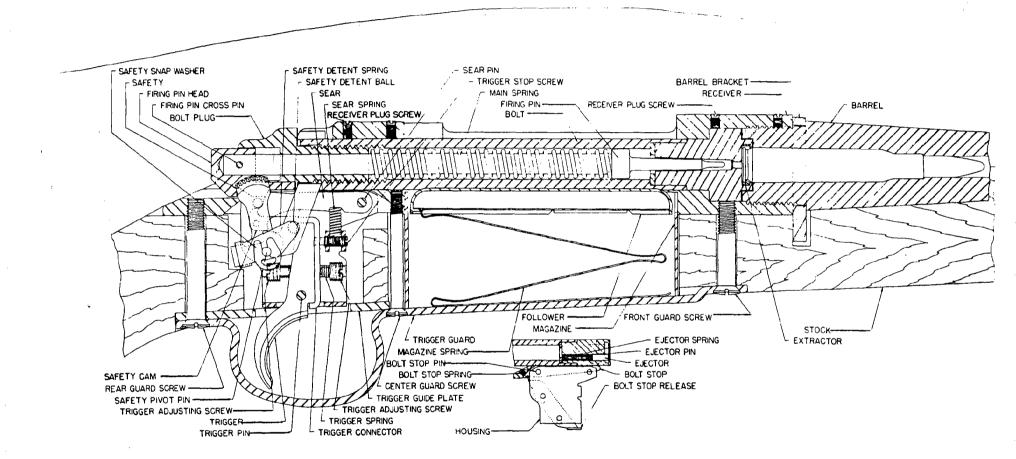
<u>Pull of Trigger</u> - is adjusted to the desired weight by turning the front trigger adjusting screw clockwise for a heavier weight adjustment and counter clockwise for a lighter weight adjustment.

<u>Travel of the Trigger</u> - may be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

# Failures to Operate

Does not cock.
 Ejection fails.
 Extraction fails.
 Fails to feed.
 Missfires
 Safety does not operate.

J.F. Finnegan:emb August 1956



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R2524550

# REMINGTON FIELD SERVICE MANUAL

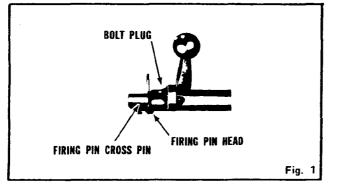
#### DISASSEMBLY

#### BOLT AND COMPONENTS

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

#### FIRING PIN AND COMPONENTS

Pull firing pin head rearward until a coin can be inserted between it and bolt plug. (Fig. 1). This can be done by catching notch in firing pin head on a sharp corner. Unscrew bolt plug to remove firing pin assembly.



#### **FIRING PIN**

Drive out firing pin cross pin (See Fig. 1) with a punch, leaving punch in hole to hold parts together to prevent main spring tension from stripping off firing pin head and bolt plug forcefully. Compress main spring with bolt plug until coin, punch and firing pin head can be removed and release main spring tension carefully, removing firing pin head, bolt plug and main spring.

#### EJECTOR

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

#### EXTRACTOR

With pointed tweezers inserted in holes provided in the ends of extractor, compress ends together until extractor can be removed from face of bolt. Do not attempt to remove only one end of extractor and then pull it from bolt face as bending will result.

#### BARREL AND ACTION FROM STOCK

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower and trigger guide

plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

#### BARREL - RECEIVER ASSEMBLY

When necessary to disassemble, return rifle to factory.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

ASSEMBLY

#### BOLT ASSEMBLY EXTRACTOR

With pointed tweezers inserted in holes provided in end of extractor, compress ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into bolt face with fingers.

#### EJECTOR

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

#### FIRING PIN

Assemble main spring and bolt plug, grasp bolt plug and compress main spring. Assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

#### FIRING PIN ASSEMBLY

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

#### BARREL - ACTION

#### BOLT ASSEMBLY

1

Assemble bolt assembly into rifle. Push forward as far as possible and lower bolt handle. Note: Bolt must remain cocked to install. If uncocked, firing pin head will be recessed well inside bolt plug. To cock bolt, clamp firing pin head firmly to prevent movement and turn bolt with handle. Continue turning bolt handle until cocking notch on rear engages firing pin head. Bolt is then cocked and may be installed.

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#### BARREL-ACTION-STOCK ASSEMBLY

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

#### FITTING OF NEW PARTS AND ADJUSTING

#### BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

#### BOLT

Remove bolt assembly from receiver. Remove firing pin assembly, ejector and extractor from bolt. Try new bolt for freedom in receiver and headspace. Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver. Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

#### BOLT PLUG

Remove bolt assembly from receiver. Remove firing pin assembly from bolt, drive out firing pin cross pin and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety switch.

#### EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector. After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

#### EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring, After reassembling ejector spring, check freedom of ejector.

#### EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring. With pointed tweezers inserted in holes provided in ends of extractor, compress ends together until extractor can be removed from face of bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection.

#### FIRING PIN

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring from firing pin. After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety switch and blow.

#### **FIRING PIN HEAD**

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross pin and remove firing pin head. After reassembling firing pin head, check cocking, safety switch operation, cocking of firing pin, protrusion, and blow.

#### MAIN SPRING

Remove bolt assembly from receiver and firing pin assembly from bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring. After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

#### MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding or cartridges.

#### MAGAZINE FOLLOWERS

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

#### MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower. After reassembling magazine spring, check loading and feeding of cartridges.

#### STOCK

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety switch and trigger.

#### **TRIGGER GUARD**

Remove bolt assembly from receiver, front center, and rear trigger guard screws and trigger guard from stock.

# **1**RIGGER GUIDE PLATE

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

# CYCLE OF OPERATION

The operation cycle of the Model 721-722 is similar and common with most hand-operated bolt action rifles. Firing, movement of Bolt Handle upward and fully back to open, then forward again and down to close Bolt complete cycle. Presuming rifle to be fully loaded with one cartridge locked in barrel chamber, the sequence for operation cycle is as follows:

#### FIRING

The firing cycle is simply the release of a spring-loaded firing pin. The forward thrust of the spring-urged pin strikes primer of cartridge with sufficient force to indent primer and ignite powder charge. With thumb-operated safety switch in "OFF" position, rifle is fired by pulling trigger rearward. In detail, the rearward movement of trigger carrier trigger connector forward. This action deprives blocked sear of its support and permits it to be cammed downward by pressure from cocked firing pin. As this support is removed beneath sear, firing pin cams sear downward and sear cams connector forward. Action of connector is to allow shortest movement of trigger possible with absolutely no over-travel.

#### UNLOCK

After firing, the upward swing of bolt handle rotates bolt. The two locking lugs at head of bolt are then unseated from support of two locking shoulders in Receiver. The bolt is then free to be withdrawn rearward.

#### COCK

Simultaneously with the unlocking cycle, a cam at rear of rotating bolt withdraws and located firing pin to a partially cocked position on rear perimeter of bolt. The remainder of cocking is accomplished during locking cycle.

#### EXTRACTION

The rim of cartridge is seated within Bolt Head and is gripped by claw of a circular recessed Extractor. During the latter portion of rotation of Bolt Handle for unlocking a primary extraction cam retracts Bolt approximately 1/8" with a mechanical advantage of 8 - 1. With Bolt Handle turned fully upward and lugs of Bolt clear of locking shoulders in Receiver, bolt is free to be withdrawn rearward and complete extraction. A spring urged pin ejector is located within bolt face and maintains outward pressure on base of cartridge. As bolt is moved rearward and front of cartridge or fired case reaches ejection port, constant pressure of ejector and opposing grip of extractor eject cartridge case from open port of receiver.

#### FEEDING

As fired cartridge is ejected, rearward travel of bolt is halted by bolt stop. As bolt clears magazine opening, top cartridge in magazine is urged upward by magazine spring and into feeding position. With action completely open, initial return movement of bolt engages rim of top cartridge fed from magazine. The continued forward travel of bolt advances cartridge up incline of Receiver and into chamber. Guided by bullet end of cartridge entering chamber, rear end is leveled free of feeding lip of Receiver.

#### LOADING

Resting ahead of advancing bolt, cartridge is urged forward and loaded into barrel chamber.

#### LOCKING

With action closed and cartridge full seated in chamber, further movement of Bolt Handle downward rotates and locks Bolt against chambered cartridge. During this rotary locking cycle, three engagements are effected: (1) The two lugs on bolt head are firmly supported by the locking shoulders within receiver; (2) Base of cartridge is seated in head of bolt, depressing ejector and flexing extractor to snap claw over rim of cartridge; and (3) Sear engages a camming surface on firing pin head, cocking cam of bolt is disengaged from firing pin and rotated to firing poisiton, Sear is blocked in firing position by trigger and trigger connector until released by trigger action.

#### SAFETY SWITCH

The thumb-operated Safety Switch, located at rear right side of Receiver, has two functions. With action closed and Bolt in a locked position, rearward pivot of safety switch ("ON" position) will place a supporting member under safety cams which will in turn prevent release of cocked firing pin. The second function with safety switch in the same "ON" position will swing a locking blade into a channel at bottom rear of Bolt. This will lock Bolt in a closed position. With safety switch clicked forward in "OFF" position, internal conditions described above will be nonexistent, thereby permitting rifle to be fired.

The instructions for Loading and Unloading, with directions for disassembly and care of rifle are contained in the instruction folder supplied with each rifle.

# REMINGTON Model 725

1962

# Remington FIELD SERVICE MANUAL

The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721-722 or other bolt action repeating rifles. Therefore the ASSEMBLY and SERVICING instructions for the Model 725 will list only those parts of unlike design and operation.

Included will be the hinged floor plate for loading or unloading with the bolt closed, and the three (3) position safety lock. Additional instructions will cover stock swivels, grip cap and front sight components.



The Instruction Folder, RD 5359, is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instruction and instructions for care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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> Send all guns for factory service and inquiries on service and parts to **REMINGTON ARMS COMPANY**, INC. **Arms Service Division** Ilion, New York All other inquiries are to be addressed to

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# Remington FIELD SERVICE MANUAL

# SIGHTS:

FRONT SIGHT COVER is designed to provide housing for the front sight blade.

To Disassemble Spread Cover slightly and push forward in cover slots on either side of the ramp. Disassemble from the rifle.

To Replace Interchangeable - no factory adjustment required.

To Reassemble Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

FRONT SIGHT BLADE is designed with flat face gold bead.

To Disassemble Remove Front sight cover. Support Front ramp to prevent damage to barrel and drive out Front sight pin. Pull out and disassemble front sight blade from the rifle.

To Replace Interchangeable - no factory adjustment required.

To Reassemble Support barrel to prevent damage and insert blade in slot in front sight ramp. Align holes and tap in front sight pin.

REAR SIGHT ASSEMBLY is designed with open "U" type eyepiece.

To Disassemble Unscrew rear sight screw and disassemble from rifle. Pull up and disassemble rear sight assembly from barrel. Remove loosened rear sight step.

To Replace Interchangeable with no factory adjustment required. Replacement as assembly recommended. Rear sight assembly is factory-listed to include: rear sight eyepiece, rear sight collar, rear sight leaf, rear sight windage screw. Special factory processes assemble the part.

To Reassemble Assemble rear sight assembly in place with bottom cars of the sight aligned properly to rear sight base. Assemble rear sight screw and turn until tight. Lift rear sight eyepiece and assemble rear sight step beneath eyepiece.

# Remington FIELD SERVICE MANUAL

REAR SIGHT STEP is designed to raise or lower the rear sight assembly for range purposes.

To Disassemble Lift or raise rear sight assembly by the eyepiece and slide rear sight step to the rear. Disassemble from barrel.

To Replace Interchangeable with no factory adjustment required. Additional sight steps, marked for size, are available for range purposes.

To Reassemble Lift eyepiece and slide rear sight step in place.

REAR SIGHT BASE is designed to mount the rear sight assembly on the barrel.

To Disassemble Remove rear sight assembly and rear sight step. Unscrew and disassemble rear sight base screw (2). Disassemble rear sight base and rear sight washers (2) from parrel.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Align to barrel screw holes, insert rear sight base screw (2) and rear sight washers (2), and turn screws to tighten base securely to barrel.

BARREL ASSEMBLY is designed as a rigid factory-assembled group with the Receiver. BARREL BRACKET as a factory-assembled component of the barrel assembly is designed to vertical recoil shoulder to transfer the back-thrust of the firing recoil against the stock. FRONT SIGHT RAMP as another component of the barrel assembly is factory-brazed to the barrel and designed to establish the sight line and mount the front sight blade.

Note: The barrel assembly, although somewhat different in design from the Model 721-722, mounts to other parts of the rifle in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Replacement as an assembly is recommended. However, the rifle must be returned to the factory for selective assembly. Return of rifle to factory for replacement of any components is also recommended (of barrel assembly). Model 725 ASSEMBLY Page 3

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# Remington FIELD SERVICE MANUAL

STOCK ASSEMBLY is designed to support the barrel assembly and other action parts during firing and handling.

To Disassemble Unscrew and disassemble front and rear trigger screws. Pull loosened stock assembly (and trigger guard assembly) from rifle.

To Replace Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock assembly is factory-listed to include: stock, butt plate, butt plate screw (2), grip cap, grip cap screw, stock swivel front assembly, stock swivel rear assembly, stock swivel nut, stock swivel screw bushing - front, and stock reinforcing screw.

To Reassemble Mount trigger guard assembly to stock assembly, then assemble over trigger assembly and magazine. Hold firmly to receiver and assemble guard screws. Turn both guard screws evenly until tight.

STOCK SWIVEL FRONT ASSEMBLY is designed to mount a sling strap to the rifle stock at the front.

To Disassemble Unscrew and disassemble stock swivel front assembly from stock.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel front assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw - front.

To Reassemble Assemble through stock swivel screw bushing front, and thread into stock swivel nut. Turn until tight and adjust crosswise to stock.

STOCK SWIVEL REAR ASSEMBLY is designed to mount a sling strap to the rear of the stock.

To Disassemble Unscrew and disassemble stock swivel rear assembly from stock.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel rear assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw - rear.

To Reassemble Turn and thread into stock until tight. Adjust crosswise to stock.

# Remington FIELD SERVICE MANUAL

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STOCK SWIVEL NUT is designed to mount and tighten stock swivel front assembly firmly to stock.

To Disassemble Remove stock assembly from rifle. Unscrew stock swivel front assembly partway from stock. Tap against stock swivel assembly until stock swivel nut pushes upward '---(take care to avoid damage to stock.) from parrel radius in stock. Remove stock swivel front assembly and thread to barrel side of nut. Pull out and disassemble stock swivel nut from stock. Remove stock swivel front assembly from stock swivel nut.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Reseat stock swivel nut to barrel radius cut in stock. Note taper angle on knurled outside of stock swivel nut. Locate small diameter of taper inward to stock when reassembling to stock. Tap nut gently into place, then rethread stock swivel front assembly from bottom face of stock. Turn swivel until stock swivel nut drawn downward and firmly into stock.

STOCK SWIVEL SCREW BUSHING, FRONT is designed to mount and pivot stock swivel front assembly to stock.

To Disassemble Remove stock from rifle. Remove stock swivel front assembly. Remove stock swivel nut. Apply close fitting tool against bushing from parrel radius cut in stock. Tap against inner end of bushing until this stock swivel bushing, front can be disassembled from bottom face of stock. Avoid damage to stock.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Locate properly to bottom face of stock and tap gently into stock until firmly in place.

BUTT PLATE is designed as aluminum alloy. Light weight and rustproof.

To Disassemble Unscrew butt plate screw (2). Disassemble butt plate from end of stock.

To Replace Interchangeable with no factory adjustment required. However, replacement part may need additional "surfacing" to end of stock wood, or edge of butt plate for proper match of butt plate to stock.

To Reassemple Assemble butt plate to end of stock, align screw holes, assemble butt plate screw (2), and turn until butt plate is tight.

Model 725 ASSENELY Page 5

# Remington FIELD SERVICE MANUAL

GRIP CAP is designed for terminal effect to end of grip and decorative addition of "Remington" script mark.

To Disassemble Unscrew and remove grip cap screw. Disassemble loosened grip cap from stock.

To Replace Interchangeable with no factory adjustment required. Additional "surfacing" of stock or edge of cap needed for proper matching effect.

To Reassemble Locate and align grip cap to stock. Insert grip cap screw and tighten firmly until grip cap is assembled to stock.

TRIGGER GUARD ASSEMBLY of hinged design, permits loading or unloading of the fixed magazine box with a "closed" bolt.

To Disassemble Remove bolt assembly. Unscrew and pull out guard screw, front and rear. Lift loosened stock assembly from trigger. Pull out and disassemble trigger guard from rifle.

Note: Magazine follower and magazine spring (assembled to floor plate) will also be removed from the stock assembly. To remove, unlatch floor plate, lift folded end of spring upwards, pull back and disassemble from floor plate. Magazine follower and magazine spring are same as for Model 721-722 (per respective calibers).

See Model 721-722 Manual for necessary SERVICE instructions.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as assembly if desired. The trigger guard assembly is factory-listed to include floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

To Reassemble Follow reverse order. Tighten guard screws firmly.

Model 725 ASSEITELY Page δ

# Remington FIELD SERVICE MANUAL

TRIGGER GUARD ASSEMELY - COMPONENTS:

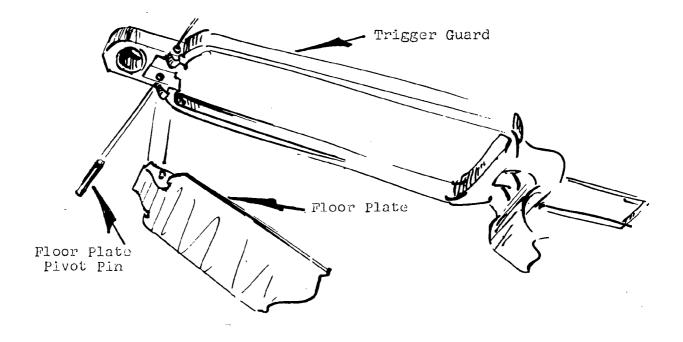
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Remove trigger guard assembly. Remove magazine follower, magazine spring from floor plate.

Floor Flate is designed to close bottom of fixed magazine box and mount magazine spring.

To Disassemble Tap out and removefloor plate pivot pin from front of trigger guard. Disassemble floor plate from trigger guard. Caution: Floor plate pivot pin is tight-fitting: therefore.

ution: Floor plate pivot pin is tight-fitting; therefore, support trigger guard properly to prevent damage to guard at front section. See sketch below.



To Replace Interchangeable with no factory adjustment required.

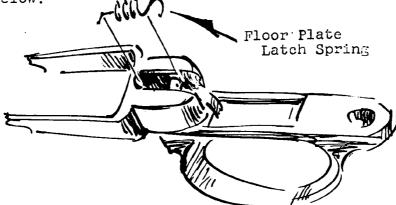
To Reassemble Follow reverse order. Make certain floor plate is free swinging and locks into floor plate latch properly. Model 725 ASSEMBLY Page 7

Remington FIELD SERVICE MANUAL

TRIGGER GUARD ASSEMBLY - COMPONENTS: Continued

Floor Plate Latch Spring is designed to place tension on floor plate latch.

To Disassemble Remove trigger guard assembly from rifle. Unhook rear of floor plate latch spring from floor plate latch. Unhook front of latch spring from trigger guard. Disassemble loosened floor plate latch spring from trigger guard. See sketch below.

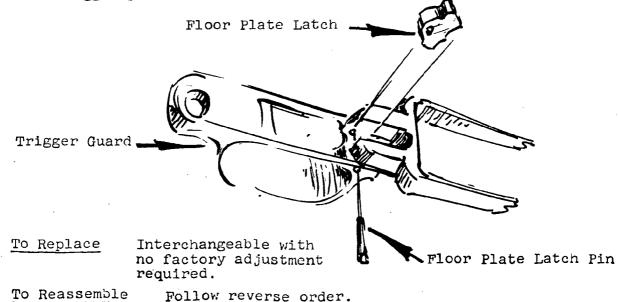


To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

Floor Plate Latch is designed to latch the floor plate to the trigger guard.

To Disassemble Remove trigger guard assembly from rifle. Remove floor plate latch from trigger guard. Tap out <u>floor</u> plate latch pin, left to right. Disassemble floor plate latch from trigger plate. See sketch below.



# Remington FIELD SERVICE MANUAL

TRIGGER GUARD is designed to hold magazine in assembly position and mount components of trigger guard assembly.

<u>To Disassemble</u> Remove trigger guard assembly from rifle. Remove magazine follower and magazine spring from floor plate. Remove floor plate, floor plate latch spring, floor plate latch from trigger guard.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order. Replace all assembly components to trigger guard before reassembly of trigger guard assembly to rifle.

MAGAZINE is designed as staggered column, box type.

<u>Note</u>: Magazine component, although slightly different in design from Model 721-722, assembles in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

BOLT FINAL ASSEMBLY is designed with shrouded head for safety and strength.

Note: Bolt final assembly, although slightly different in design also from the Model 721-722, assembles in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Bolt assembly component of BOLT FINAL ASSEMBLY includes bolt body assembly, bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor, firing pin assembly, and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is required. Model 725 ASSEMBLY Page 9

# Remington FIELD SERVICE MANUAL

BOLT STOP is designed to prevent bolt final assembly from being pulled completely from rifle unless bolt stop release is pressed upwards. BOLT STOP SPRING is designed to place bolt stop under tension. BOLT STOP PIN is designed to hold the bolt stop in assembly position and also mount the safety lock thumopiece to the right side of the receiver.

To Disassemble Remove bolt rinal assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble bolt stop pin snap washer from left end of bolt stop pin. See sketch SAFETY LOCK THUMBPIECE. Push left end of bolt stop pin across only enough to release bolt stop. Disassemble loosened bolt stop and bolt stop spring. Take care that small bolt stop spring is not lost.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

SAFETY LOCK THUMBPIECE ASSEMBLY is designed to operate the "three" position safety. BOLT LOCK is designed to pivot upward and lock bolt closed when safety thumbpiece is pushed to the ON SAFE or "S" mark on the receiver.

To Disassemble Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Remove bolt stop. Push bolt stop pin completely across and disassemble pin and safety lock thumbpiece assembly from rifle. BOLT LOCK WILL ALSO be loosened at this time and can be disassembled from right side of trigger housing. See sketch page 11.

Note: Trigger housing will be in "free pivot" on sear pin only when bolt stop pin is removed. Take care that sear spring, underlying sear and safety cam (also in free pivot), is not lost.

Model 725 ASSEMELY Page 10

# Remington FIELD SERVICE MANUAL

#### SAFETY LOCK THUMBPIECE ASSEMBLY Continued

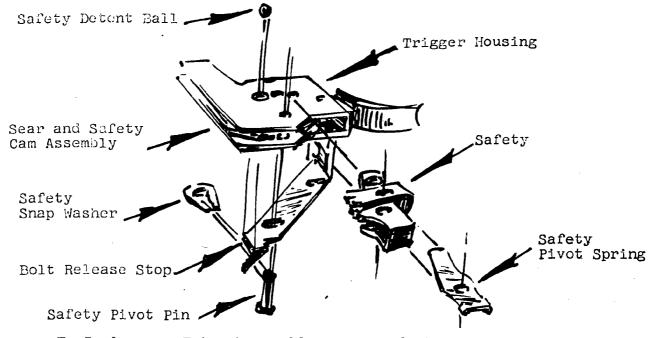
To Replace Interchangeable with no factory adjustment required. Replace safety lock thumopiece assembly as assembly unit.

To Reassemble Follow reverse order. Assemble ratchet teeth in bolt lock and safety lock thumbpiece assembly to safety component properly before bolt stop pin is inserted. Check for proper operation of components to three (3) position stops on receivor.

SAFATY is designed to support safety can of sear and safety cam assembly against "coched" bolt. This is accomplished by operation of upthrust inner blade section when safety lock thumbpiece assembly is in ON SAFE position to rear of receiver.

To Disassemble Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble satisty snap washer. Pull off and disassemble safety pivot\_spring. Remove loosened safety detent sall. Push across and disassemple safety pivot pin. Pull out and disassemble safety from trigger housing. See shetch below. Note: Dolt stop release on opposite side of housing will

be free when safety pivot pin is removed.



To Replace Interchangeable with no factory adjustment required.

Follow reverse order. Ratchet teeth on safety To Reassemble should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumbpiece assembly for proper operation of three position safety stops.

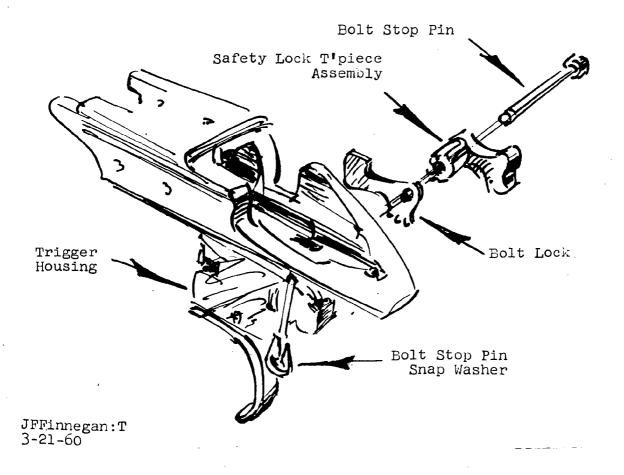
Model 725 ASSEMBLY Page 11

# Remington FIELD SERVICE MANUAL

TRIGGER ASSEMBLY is designed to mount the action mechanisms of trigger, safety, sear, bolt stop release, to the receiver component of the barrel assembly.

Note: Trigger assembly, although somewhat different in design from the Model 721-722, assembles in the same manner to the receiver. Sear pin and bolt stop pin mount the housing component of trigger assembly to receiver. See Model 721-722 Manual for necessary SERVICE instructions to trigger and sear mechanisms.

To Replace Trigger assembly may be replaced as an assembly with no factory adjustment required. Trigger assembly includes bolt stop release, housing, safety, safety detent ball. safety detent spring, safety pivot pin, safety snap washer, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw. (Seesketch below).



Model 725 ACTION CYCLE Page 12

# Remington FIELD SERVICE MANUAL

# (See Instruction Folder - RD 5359)

The action cycle of the Model 725 may start as the magazine is loaded and a cartridge locked by the bolt in the chamber. The trigger is pulled to fire each cartridge and the bolt handle is raised to turn and pull the bolt rearward. The return of the bolt forward to reload the next cartridge and then the handle turned down to lock the bolt against the chambered cartridge, completes the operation cycle.

Each cycle is summarized briefly, then in detail the movement of related parts is described more fully. For reason of a <u>safe</u> operation cycle, the Three Position Safety Lock is explained to preface this Cycle.

# Jafety Loci:

Safe "S" (mark on receiver) - The rifle cannot be fired nor the bolt handle raised to unlock the bolt from the barrel when the safety lock thumppiece is rotated fully rearward to the "S" mark on the receiver. In detail, the thumbpiece locks a safety cam component of the trigger assembly up and against the "cocked" firing pin assembly to prevent its forward release. A bolt lock component is also rotated into a bottom channel in the locked bolt. This bolt lock prevents the bolt and bolt handle from turning to unlock.

Unloc: Position (no mark on receiver) - The rifle cannot be fired; however, the bolt handle can be raised to unlock and withdraw the bolt, when the safety lock thumbpiece is rotated to a stop position between the Safe "S" and Fire "F" mark on the receiver. In detail, the firing pin assembly continues to be held "cocked" by the safety cam component. However, the bolt lock is rotated from engagement with the bottom channel in the bolt and the bolt handle can be raised to turn and withdraw the bolt.

Fire "F" (mark on receiver) - The rifle can be fired or the bolt handle raised to turn and unlock the bolt when the safety lock thumopiece is rotated fully forward to the "F" mark on the receiver. In detail, the safety cam component within the trigger assembly is no longer held against the "cocked" firing pin assembly. The bolt lock. as in the Unlock Position, is rotated from engagement with the bottom channel in the polt. The bolt is free to turn and unlock if the handle is raised. Model 725 ACTION CYCLE Page 13

# Remington FIELD SERVICE MANUAL

Firing (safety lock in "F" position) The firing cycle is simply the pull of the trigger each time to release a spring-loaded or "cocked" firing pin to fire the cartridge. In detail, this pull of the trigger carries forward a connector component from beneath the sear. This forward movement of the connector leaves the sear unsupported against the "cocked" firing pin. With support removed, sear is cammed downward by the spring-urged firing pin. The mainspring then thrusts the firing pin forward to strike the cartridge.

Note: The design and movement of the connector is to adjust for the shortest possible pull of the trigger with absolutely no over-travel.

<u>Unlocking</u> The unlock cycle is the raising of the bolt handle to disengage the solt from the breech of the barrel. In detail, this upward swing of the bolt handle turns the bolt to unseat the locking lugs on the head of the bolt from the recoil shoulders in the receiver.

Cocking The "cocking" cycle may be summarized as two movements: (1) The "cocking" of the boltwhich occurs during the unlocking cycle; and (2) The "cocking" of the rifle which occurs during the locking cycle. In detail, the first movement is the withdrawal and notching of the firing pin against the pressure of the tensed mainspring in the bolt. The final movement is the holding or sustaining of the withdrawn or "cocked" pin until the trigger is pulled.

The first or withdrawal movement is caused by the turning of the bolt as the handle is raised. During the turning, a cam cut at the rear of the bolt forces the firing pin assembly rearward, to locate in a notch on the rear rim of the bolt. The final or sustaining movement is simply the transfer of this "cocked" position of the firing pin from the bolt to the sear in the trigger assembly. This transfer to the sear occurs as the bolt handle is lowered in the locking cycle.

The sear then holds the firing pin or rifle "cocked" until the trigger is pulled during the firing cycle, or the bolt handle is raised to re-transfer the "cocking" of the firing pin to the bolt rim.

Model 725 ACTION CYCLE Page 14

# Remington FIELD SERVICE MANUAL

Extracting The extracting cycle consists of the "freeing" of the fired cartridge case (or live round) from the cartridge chamber walls in the barrel breech and the pulling of the case from the chamber. In detail, as the bolt handle is raised to unlock the bolt, the final upturn motion engages a camming surface in the receiver. This rearward camming motion of the bolt will disengage the fired case from tight contact with the barrel chamber. Further rearward pull on the bolt handle extracts the fired case completely from the chamber. During the extraction cycle the fired case is gripped firmly to the bolt face by an extractor component. This extractor is recessed within the rim on the bolt head.

Feeding The feeding cycle is the lift and forward movement of the top most cartridge from magazine to barrel breech. In detail, as the bolt clears the magazine opening, the top cartridge in the magazine is pressed upwards by the magazine spring and into feeding position. The return movement of the bolt pushes against the rear of the cartridge. The bullet end of the cartridge moves up the bullet incline and the rear is leveled out free of the feeding lip on the receiver.

Loading The loading cycle is rather brief and comprises the movement of the free cartridge as it is pushed forward by the bolt and loaded completely into the barrel chamber.

Locking The locking cycle occurs as the downward turn of the bolt handle rotates the bolt and locks it against the chambered cartridge. In detail, four engagements are made by this locking cycle: (1) the two locking lugs on bolt head are firmly seated against the recoil shoulders in the receiver; (2) the base of the loaded cartridge is recessed within the bolt face, depressing the ejector and flexing the extractor to snap the claw over the base rim of the cartridge; (3) the sear engages a camming surface to the rear of the firing pin, on the firing pin head; and (4) the scar is supported from beneath by the connector to hold the firing pin back and the rifle "cocked" until the trigger is pulled. Model 725 SERVICING Page 15

# Remington FIELD SERVICE MANUAL

SERVICE instructions for the Remington Model 725 and the Models 721 and 722 are very much alike in many respects (see M/721-722 Manual). Because of this design similarity only limited SERVICING is needed for the M/725; and other than damaged or missing components related to the safety or hinged floor plate mechanisms, or stock, little, if any, servicing for the M/725 is necessary.

#### FLOOR PLATE MECHANISM

1. Floor Plate fails to lock bottoms on stock.

Service: Remove wood margin beneath floor plate.

2. Damaged or missing components.

Service: Repair or replace floor plate, floor plate latch, floor plate latch spring.

#### SAFETY MECHANISM

- 1. Damaged or missing components.
  - Service: Repair or replace safety lock thumopiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball, safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety cam assembly.

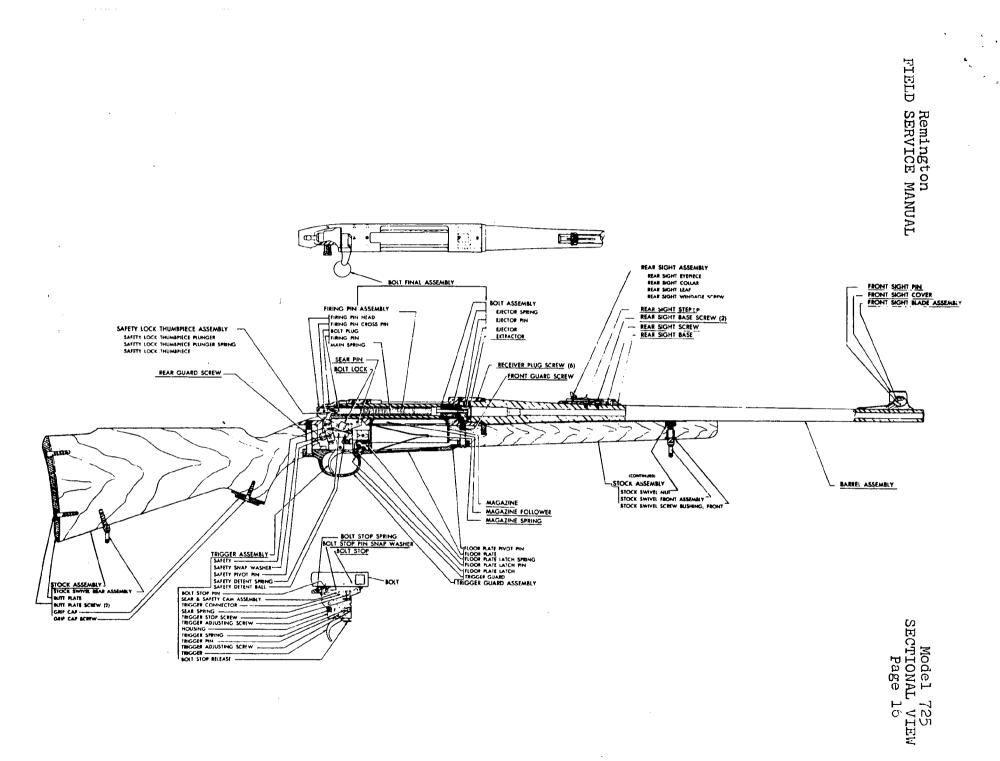
#### STOCK ASSEMBLY

1. Fails to target properly.

Service: a) Adjust or replace sights.

- b) Check barrel bedding. Barrel should be free floating along receiver sides and along barrel length. Should seat evenly in barrel radius cut and have firm contact only at end of stock.
- c) Replace stock, if damaged.

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# REMINGTON Model 725

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# Remington FIELD SERVICE MANUAL

The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721-722 or other bolt action repeating rifles. Therefore the ASSEMBLY and SERVICING instructions for the Model 725 will list only those parts of unlike design and operation.

Included will be the hinged floor plate for loading or unloading with the bolt closed, and the three (3) position safety lock. Additional instructions will cover stock swivels, grip cap and front sight components.



The Instruction Folder, RD 5359, is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instruction and instructions for care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport 2, Connecticut Model 72) ASSEMBLY Page 1

# Remington FIELD SERVICE MANUAL

#### SIGHTS:

FRONT SIGHT COVER is designed to provide housing for the front sight blade.

To Disassemble Spread Cover slightly and push forward in cover slots on either side of the ramp. Disassemble from the rifle.

To Replace Interchangeable - no factory adjustment required.

To Reassemble Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

FRONT SIGHT BLADE is designed with flat face gold bead.

To Disassemble Remove front sight cover. Support front ramp to prevent damage to barrel and drive out front sight pin. Pull out and disassemble front sight blade from the rifle.

To Replace Interchangeable - no factory adjustment required.

To Reassemble Support barrel to prevent damage and insert blade in slot in front sight ramp. Align holes and tap in front sight pin.

REAR SIGHT ASSEMBLY is designed with open "U" type eyepiece.

To Disassemble Unscrew rear sight screw and disassemble from rifle. Pull up and disassemble rear sight assembly from barrel. Remove loosened rear sight step.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as assembly recommended. Rear sight assembly is factory-listed to include: rear sight eyepiece, rear sight collar, rear sight leaf, rear sight windage screw. Special factory processes assemble the part.

To Reassemble Assemble rear sight assembly in place with bottom ears of the sight aligned properly to rear sight base. Assemble rear sight screw and turn until tight. Lift rear sight eyepiece and assemble rear sight step beneath eyepiece.

# Remington FIELD SERVICE MANUAL

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REAR SIGHT STEP is designed to raise or lower the rear sight assembly for range purposes.

To Disassemble Lift or raise rear sight assembly by the eyepiece and slide rear sight step to the rear. Disassemble from barrel.

To Replace Interchangeable with no factory adjustment required. Additional sight steps, marked for size, are available for range purposes.

To Reassemble Lift eyepiece and slide rear sight step in place.

REAR SIGHT BASE is designed to mount the rear sight assembly on the barrel.

To Disassemble Remove rear sight assembly and rear sight step. Unscrew and disassemble rear sight base screw (2). Disassemble rear sight base and rear sight washers (2) from barrel.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Align to barrel screw holes, insert rear sight base screw (2) and rear sight washers (2), and turn screws to tighten base securely to barrel.

BARREL ASSEMBLY is designed as a rigid factory-assembled group with the Receiver. BARREL BRACKET as a factory-assembled component of the barrel assembly is designed to vertical recoil shoulder to transfer the back-thrust of the firing recoil against the stock. FRONT SIGHT RAMP as another component of the barrel assembly is factory-brazed to the barrel and designed to establish the sight line and mount the front sight blade.

Note: The barrel-assembly, although somewhat different in design from the Model 721-722, mounts to other parts of the rifle in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Replacement as an assembly is recommended. However, the rifle must be returned to the factory for selective assembly. Return of rifle to factory for replacement of any components is also recommended (of barrel assembly). Model 725 ASSEMBLY Page 3

# Remington FIELD SERVICE MANUAL

STOCK ASSEMBLY is designed to support the barrel assembly and other action parts during firing and handling.

To Disassemble Unscrew and disassemble front and rear trigger screws. Pull loosened stock assembly (and trigger guard assembly) from rifle.

To Replace Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock assembly is factory-listed to include: stock, butt plate, butt plate screw (2), grip cap, grip cap screw, stock swivel front assembly, stock swivel rear assembly, stock swivel nut, stock swivel screw bushing - front, and stock reinforcing screw.

To Reassemble Mount trigger guard assembly to stock assembly, then assemble over trigger assembly and magazine. Hold firmly to receiver and assemble guard screws. Turn both guard screws evenly until tight.

STOCK SWIVEL FRONT ASSEMBLY is designed to mount a sling strap to the rifle stock at the front.

To Disassemble Unscrew and disassemble stock swivel front assembly from stock.

To Replace Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel front assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw - front.

To Reassemble Assemble through stock swivel screw oushing front, and thread into stock swivel nut. Turn until tight and adjust crosswise to stock.

STOCK SWIVEL REAR ASSEMBLY is designed to mount a sling strap to the rear of the stock.

To Disassemble Unscrew and disassemble stock swivel rear assembly from stock.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel rear assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw - rear.

To Reassemble Turn and thread into stock until tight. Adjust crosswise to stock.

## Remington FIELD SERVICE MANUAL

STOCK SWIVEL NUT is designed to mount and tighten stock swivel front assembly firmly to stock.

To Disassemple Remove stock assembly from rifle. Unscrew stock swivel front assembly partway from stock. Tap against stock swivel assembly until stock swivel nut pushes upward ---(take care to avoid damage to stock.) from parrel radius in stock. Remove stock swivel front assembly and thread to parrel side of nut. Pull out and disassemble stock swivel nut from stock. Remove stock swivel front assembly from stock swivel nut.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Reseat stock swivel nut to barrel radius cut in stock. Note taper angle on knurled outside of stock swivel nut. Locate small diameter of taper inward to stock when reassembling to stock. Tap nut gently into place, then retaread stock swivel front assembly from bottom face of stock. Turn swivel until stock swivel nut drawn downward and firmly into stock.

STOCK SWIVEL SCREW BUSHING, FRONT is designed to mount and pivot stock swivel front assembly to stock.

To Disassemble Remove stock from rifle. Remove stock swivel front assembly. Remove stock swivel nut. Apply close fitting tool against bushing from barrel radius cut in stock. Tap against inner end of bushing until this stock swivel bushing, front can be disassembled from bottom face of stock. Avoid damage to stock.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Locate properly to bottom face of stock and tap gently into stock until firmly in place.

BUTT PLATE is designed as aluminum alloy. Light weight and rustproof.

To Disassemole Unscrew butt plate screw (2). Disassemble butt plate from end of stock.

To Replace Interchangeable with no factory adjustment required. However, replacement part may need additional "surfacing" to end of stock wood, or edge of outt plate for proper match of butt plate to stock.

To Reassemble Assemble butt plate to end of stock, align screw noles, assemble butt plate screw (2), and turn until butt plate is tight.

## Remington FIELD SERVICE MANUAL

GRIP CAP is designed for terminal effect to end of grip and decorative addition of "Remington" script mark.

To Disassemble Unscrew and remove grip cap screw. Disassemble loosened grip cap from stock.

To Replace Interchangeable with no factory adjustment required. Additional "surfacing" of stock or edge of cap needed for proper matching effect.

To Reassemble Locate and align grip cap to stock. Insert grip cap screw and tighten firmly until grip cap is assembled to stock.

TRIGGER GUARD ASSEMBLY of hinged design, permits loading or unloading of the fixed magazine box with a "closed" bolt.

To Disassemble Remove bolt assembly. Unscrew and pull out guard screw, front and rear. Lift loosened stock assembly from trigger. Pull out and disassemble trigger guard from rifle.

<u>Note</u>: Magazine follower and magazine spring (assembled to floor plate) will also be removed from the stock assembly. To remove, unlatch floor plate, lift folded end of spring upwards, pull back and disassemble from floor plate. Magazine follower and magazine spring are same as for Model 721-722 (per respective calibers).

See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Interchangeable with no factory adjustment required. Replacement as assembly if desired. The trigger guard assembly is factory-listed to include floor plate. floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

To Reassemble Follow reverse order. Tighten guard screws firmly.

## Remington FIELD SERVICE MANUAL

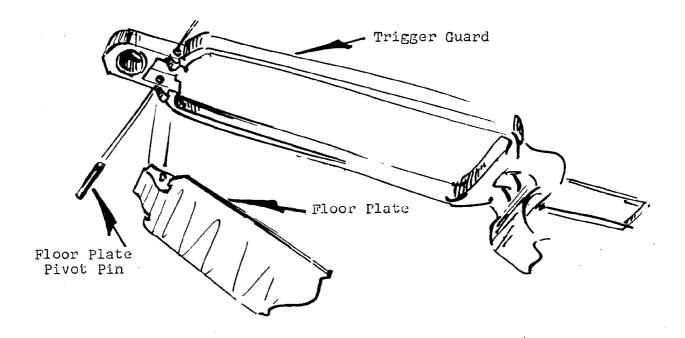
TRIGGER GUARD ASSEMELY - COMPONENTS:

Remove trigger guard assembly. Remove magazine follower, magazine spring from floor plate.

Floor Plate is designed to close bottom of fixed magazine box and mount magazine spring.

To Disassemble Tap out and remove floor plate pivot pin from front of trigger guard. Disassemble floor plate from trigger guard. Caution: Floor plate pivot pin is tight-fitting: therefore,

on: Floor plate pivot pin is tight-fitting; therefore, support trigger guard properly to prevent damage to guard at front section. See sketch below.



To Replace Interchangeable with no factory adjustment required.

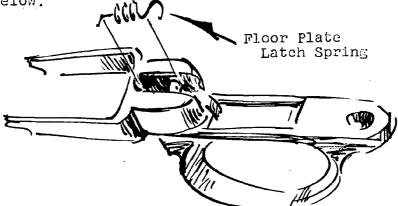
To Reasscable Follow reverse order. Make certain floor plate is free swinging and locks into floor plate latch properly.

## Remington FIELD SERVICE MANUAL

TRIGGER GUARD ASSEMBLY - COMPONENTS: Continued

Floor Plate Latch Spring is designed to place tension on floor plate latch.

To Disassemble Remove trigger guard assembly from rifle. Unhook rear of floor plate latch spring from floor plate latch. Unhook front of latch spring from trigger guard. Disassemble loosened floor plate latch spring from trigger guard. See sketch below.

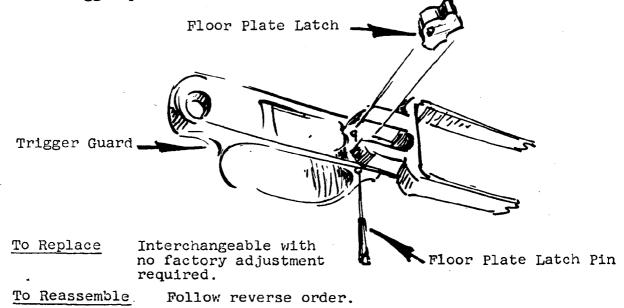


To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

Floor Plate Latch is designed to latch the floor plate to the trigger guard.

To Disassemble Remove trigger guard assembly from rifle. Remove floor plate latch from trigger guard. Tap out <u>floor</u> plate latch pin, left to right. Disassemble floor plate latch from trigger plate. See sketch below.



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TRIGGER GUARD is designed to hold magazine in assembly position and mount components of trigger guard assembly.

<u>To Disassemble</u> Remove trigger guard assembly from rifle. Remove magazine follower and magazine spring from floor plate. Remove floor plate, floor plate latch spring, floor plate latch from trigger guard.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order. Replace all assembly components to trigger guard before reassembly of trigger guard assembly to rifle.

MAGAZINE is designed as staggered column, box type.

<u>Note</u>: Magazine component, although slightly different in design from Model 721-722, assembles in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

BOLT FINAL ASSEMBLY is designed with shrouded head for safety and strength.

Note: Bolt final assembly, although slightly different in design also from the Model 721-722, assembles in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Bolt assembly component of BOLT FINAL ASSEMBLY includes bolt body assembly, bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor, firing pin assembly, and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is required.

## Remington FIELD SERVICE MANUAL

BOLT STOP is designed to prevent bolt final assembly from being pulled completely from rifle unless bolt stop release is pressed upwards. BOLT STOP SPRING is designed to place bolt stop under tension. BOLT STOP PIN is designed to hold the bolt stop in assembly position and also mount the safety lock thumbpiece to the right side of the receiver.

To Disassemble Remove polt rinal assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble bolt stop pin snap washer from left end of bolt stop pin. See sketch SAFETY LOCK THUMBPIECE. Push left end of bolt stop pin across only enough to release bolt stop. Disassemble loosened bolt stop and bolt stop spring. Take care that small bolt stop spring is not lost.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

SAFETY LOCK THUMBPIECE ASSEMBLY is designed to operate the "three" position safety. BOLT LOCK is designed to pivot upward and lock bolt closed when safety thumbpiece is pushed to the ON SAFE or "S" mark on the receiver.

- To Disassemble Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Remove bolt stop. Push bolt stop pin completely across and disassemble pin and safety lock thumbpiece assembly from rifle. BOLT LOCK WILL ALSO be loosened at this time and can be disassembled from right side of trigger housing. See sketch page 11.
  - Note: Trigger housing will be in "free pivot" on sear pin only when bolt stop pin is removed. Take care that sear spring, underlying sear and safety cam (also in free pivot), is not lost.

#### SAFETY LOCK THUMBPIECE ASSEMBLY Continued

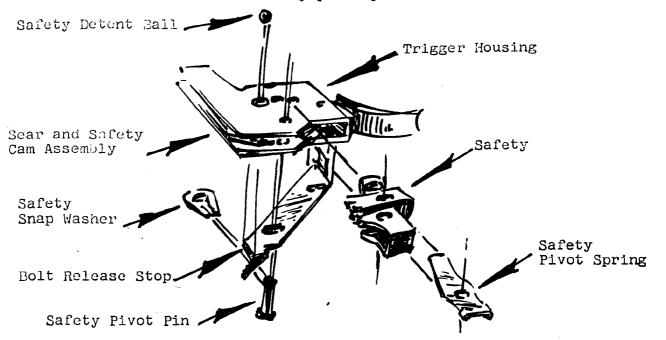
To Replace Interchangeable with no factory adjustment required. Replace safety lock thumbpiece assembly as assembly unit.

To Reassemble Follow reverse order. Assemble ratchet teeth in bolt lock and safety lock thumbpiece assembly to safety component properly before bolt stop pin is inserted. Check for proper operation of components to three (3) position stops on receiver.

SAFATY is designed to support safety can of sear and safety can assembly against "coched" polt. This is accomplished by operation of upthrust inner blade section then safety lock thumbpiece assembly is in ON SAFE position to rear of receiver.

To Disassemble Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble safety snap washer. Pull off and disassemble <u>safety pivot spring</u>. Remove loosened <u>safety detent ball</u>. Push across and disassemble <u>safety pivot pin</u>. Pull out and disassemble <u>safety from trigger</u> housing. See shetch below. Note: Dolt stop release on opposite side of housing will

be free when safety pivot pin is removed.



To Replace Interchangeable with no factory adjustment required.

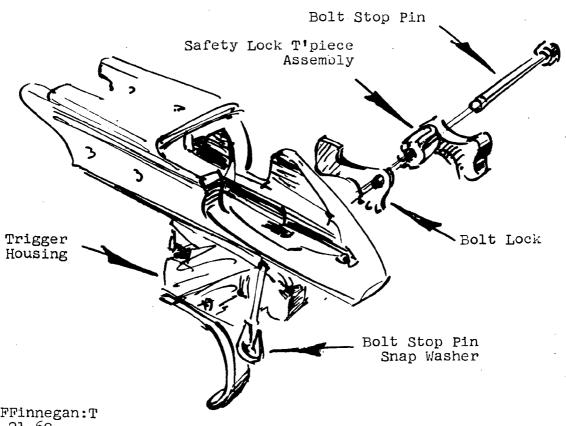
To Reassemble Follow reverse order. Ratchet teeth on safety should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumspiece assembly for proper operation of three position safety stops.

## Remington FIELD SERVICE MANUAL

TRIGGER ASSEMBLY is designed to mount the action mechanisms of trigger, safety, sear, bolt stop release, to the receiver component of the barrel assembly.

Note: Trigger assembly, although somewhat different in design from the Model 721-722, assembles in the same manner to the receiver. Sear pin and bolt stop pin mount the housing component of trigger assembly to receiver. See Model 721-722 Manual for necessary SERVICE instructions to trigger and sear mechanisms.

To Replace Trigger assembly may be replaced as an assembly with no factory adjustment required. Trigger assembly includes bolt stop release, housing, safety, safety detent ball. safety detent spring, safety pivot pin, safety snap washer, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw. (Seesketch below).



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(See Instruction Folder - RD 5359)

The action cycle of the Model 725 may start as the magazine is loaded and a cartridge locked by the bolt in the chamber. The trigger is pulled to fire each cartridge and the bolt handle is raised to turn and pull the bolt rearward. The return of the bolt forward to reload the next cartridge and then the handle turned down to lock the bolt against the chambered cartridge, completes the operation cycle.

Each cycle is summarized briefly, then in detail the movement of related parts is described more fully. For reason of a safe operation cycle, the Three Position Safety Lock is explained to preface this Cycle.

## Safety Loca

Safe 'S' (mark on receiver) - The rifle cannot be fired nor the bolt handle raised to unlock the bolt from the barrel when the safety lock thumppiece is rotated fully rearward to the "S" mark on the receiver. In detail, the thumbpiece locks a safety cam component of the trigger assembly up and against the "cocked" firing pin assembly to prevent its forward release. A bolt lock component is also rotated into a bottom channel in the locked bolt. This bolt lock prevents the bolt and bolt handle from turning to unlock.

Unloc: Position (no mark on receiver) - The rifle cannot be fired; however, the bolt handle can be raised to unlock and withdraw the bolt, when the safety lock thumbpiece is rotated to a stop position between the Safe "S" and Fire "F" mark on the receiver. In detail, the firing pin assembly continues to be held "cocked" by the safety cam component. However, the bolt lock is rotated from engagement with the bottom channel in the bolt and the bolt handle can be raised to turn and withdraw the bolt.

Fire 'F" (mar!: on receiver) - The rifle <u>can be fired</u> or the bolt handle raised to turn and unlock the bolt when the safety lock thumspiece is rotated fully forward to the "F" mark on the receiver. In detail, the safety cam component within the trigger assembly is no longer held against the "cocked" firing pin assembly. The bolt lock. as in the Unlock Position, is rotated from engagement with the bottom channel in the polt. The bolt is free to turn and unlock if the handle is raised.

## Remington FIELD SERVICE MANUAL

Firing (safety lock in "F" position) The firing cycle is simply the pull of the trigger each time to release a spring-loaded or 'cocked" firing pin to fire the cartridge. In detail, this pull of the trigger carries forward a connector component from beneath the sear. This forward movement of the connector leaves the sear unsupported against the "cocked" firing pin. With support removed, sear is canned downward by the spring-urged firing pin. The mainspring then thrusts the firing pin forward to strike the cartridge.

<u>Note</u>: The design and movement of the connector is to adjust for the shortest possible pull of the trigger with absolutely no over-travel.

<u>Unlocking</u> The unlock cycle is the raising of the bolt handle to disengage the bolt from the breech of the barrel. In detail, this upward swing of the bolt handle turns the bolt to unseat the locking lugs on the head of the bolt from the recoil shoulders in the receiver.

Cocking The "cocking" cycle may be summarized as two movements: (1) The "cocking" of the boltwhich occurs during the unlocking cycle; and (2) The "cocking" of the rifle which occurs during the locking cycle. In detail, the first movement is the withdrawal and notching of the firing pin against the pressure of the tensed mainspring in the bolt. The final movement is the holding or sustaining of the withdrawn or "cocked" pin until the trigger is pulled.

The first or withdrawal movement is caused by the turning of the bolt as the handle is raised. During the turning, a cam cut at the rear of the bolt forces the firing pin assembly rearward, to locate in a notch on the rear rim of the bolt. The final or sustaining movement is simply the transfer of this "cocked" position of the firing pin from the bolt to the sear in the trigger assembly. This transfer to the sear occurs as the bolt handle is lowered in the locking cycle.

The sear then holds the firing pin or rifle "cocked" until the trigger is pulled during the firing cycle, or the bolt handle is raised to re-transfer the "cocking" of the firing pin to the bolt rim.

Extracting The extracting cycle consists of the "freeing" of the fired cartridge case (or live round) from the cartridge chamber walls in the barrel breech and the pulling of the case from the chamber. In detail, as the bolt handle is raised to unlock the bolt, the final upturn motion engages a camming surface in the receiver. This rearward camming motion of the bolt will disengage the fired case from tight contact with the barrel chamber. Further rearward pull on the bolt handle extracts the fired case completely from the chamber. During the extraction cycle the fired case is gripped firmly to the bolt face by an extractor component. This extractor is recessed within the rim on the bolt head.

Feeding The feeding cycle is the lift and forward movement of the top most cartridge from magazine to barrel breech. In detail, as the polt clears the magazine opening, the top cartridge in the magazine is pressed upwards by the magazine spring and into feeding position. The return movement of the bolt pushes against the rear of the cartridge. The bullet end of the cartridge moves up the bullet incline and the rear is leveled out free of the feeding lip on the redeiver.

Loading The loading cycle is rather brief and comprises the movement of the free cartridge as it is pushed forward by the bolt and loaded completely into the barrel chamber.

Locking The locking cycle occurs as the downward turn of the bolt handle rotates the bolt and locks it against the chambered cartridge. In detail, four engagements are made by this locking cycle: (1) the two locking lugs on bolt head are firmly seated against the recoil shoulders in the receiver; (2) the base of the loaded cartridge is recessed within the bolt face, depressing the ejector and flexing the extractor to snap the claw over the base rim of the cartridge; (3) the sear engages a camming surface to the rear of the firing pin, on the firing pin head; and (4) the scar is supported from beneath by the connector to hold the firing pin back and the rifle "cocked" until the trigger is pulled. Model 725 SERVICING Page 15

## Remington FIELD SERVICE MANUAL

SERVICE instructions for the Remington Model 725 and the Models 721 and 722 are very much alike in many respects (see M/721-722 Manual). Because of this design similarity only limited SERVICING is needed for the M/725; and other than damaged or missing components related to the safety or hinged floor plate mechanisms, or stock, little, if any, servicing for the M/725 is necessary.

#### FLOOR PLATE MECHANISM

1. Floor Plate fails to lock bottoms on stock.

Service: Remove wood margin beneath floor plate.

2. Damaged or missing components.

Service: Repair or replace floor plate, floor plate latch. floor plate latch spring.

#### SAFETY MECHANISM

- 1. Damaged or missing components.
  - Service: Repair or replace safety lock thumopiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball, safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety cam assembly.

#### STOCK ASSEMBLY

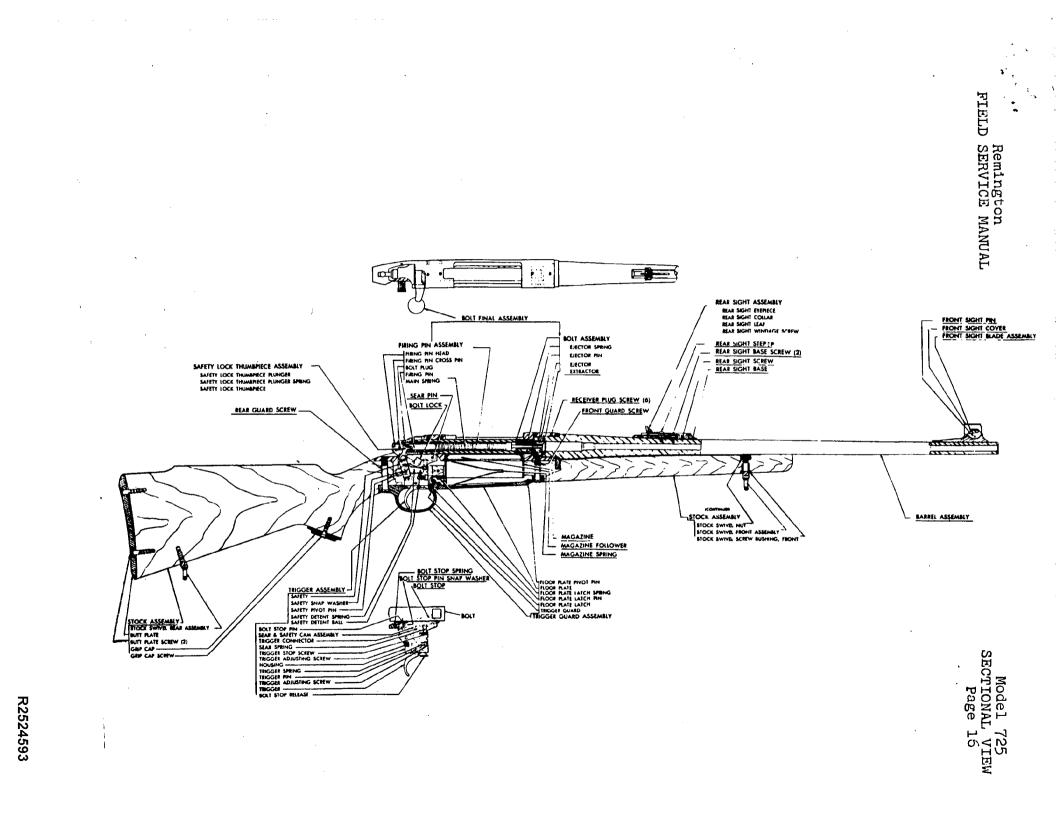
1. Fails to target properly.

Service: a) Adjust or replace sights.

- b) Check barrel bedding. Barrel should be free floating along receiver sides and along barrel length. Should seat evenly in barrel radius cut and have firm contact only at end of stock.
- c) Replace stock, if damaged.

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The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similar to the Models 721-722 or other bolt action repeating rifles. Therefore the ASSEMBLY and SERVICING instructions for the Model 725 will list only those parts of unlike design and operation.

Included will be the hinged floor plate for loading or unloading with the bolt closed, and the three (3) position safety lock. Additional instructions will cover stock swivels, grip cap and front sight components.



The Instruction Folder, RD 5359, is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instruction and instructions for care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

1965

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# Remington FIELD.SERVICE MANUAL

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC.

Bridgeport 2, Connecticut

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## Remington FIELD SERVICE MANUAL

## SIGHTS:

FRONT SIGHT COVER is designed to provide housing for the front sight blade.

To Disassemble Spread Cover slightly and push forward in cover slots on either side of the ramp. Disassemble from the rifle.

To Replace Interchangeable - no factory adjustment required.

To Reassemble Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

FRONT SIGHT BLADE is designed with flat face gold bead.

To Disassemble Remove front sight cover. Support front ramp to prevent damage to barrel and drive out front sight pin. Pull out and disassemble front sight blade from the rifle.

To Replace Interchangeable - no factory adjustment required.

To Reassemble Support barrel to prevent damage and insert blade in slot in front sight ramp. Align holes and tap in front sight pln.

REAR SIGHT ASSEMBLY is designed with open "U" type eyepiece.

To Disassemble Unscrew rear sight screw and disassemble from rifle. Pull up and disassemble rear sight assembly from barrel. Remove loosened rear sight step.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as assembly recommended. Rear sight assembly is factory-listed to include: rear sight eyepiece, rear sight collar, rear sight leaf, rear sight windage screw. Special factory processes assemble the part.

To Reassemble Assemble rear sight assembly in place with bottom ears of the sight aligned properly to rear sight base. Assemble rear sight screw and turn until tight. Lift rear sight eyepiece and assemble rear sight step beneath eyepiece.

REAR SIGHT STEP is designed to raise or lower the rear sight assembly for range purposes.

To Disassemble Lift or raise rear sight assembly by the eyepiece and slide rear sight step to the rear. Disassemble from barrel.

To Replace Interchangeable with no factory adjustment required. Additional sight steps, marked for size, are available for range purposes.

To Reassemble Lift eyepiece and slide rear sight step in place.

REAR SIGHT BASE is designed to mount the rear sight assembly on the barrel.

To Disassemble Remove rear sight assembly and rear sight step. Unscrew and disassemble rear sight base screw (2). Disassemble rear sight base and rear sight washers (2) from barrel.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Align to barrel screw holes, insert rear sight base screw (2) and rear sight washers (2), and turn screws to tighten base securely to barrel.

BARREL ASSEMBLY is designed as a rigid factory-assembled group with the Receiver. BARREL BRACKET as a factory-assembled component of the barrel assembly is designed to vertical recoil shoulder to transfer the back-thrust of the firing recoil against the stock. FRONT SIGHT RAMP as another component of the barrel assembly is factory-brazed to the barrel and designed to establish the sight line and mount the front sight blade.

Note: The barrel assembly, although somewhat different in design from the Model 721-722, mounts to other parts of the rifle in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Replacement as an assembly is recommended. However, the rifle must be returned to the factory for selective assembly. Return of rifle to factory for replacement of any components is also recommended (of barrel assembly).

## Remington FIELD SERVICE MANUAL

STOCK ASSEMBLY is designed to support the barrel assembly and other action parts during firing and handling.

To Disassemble Unscrew and disassemble front and rear trigger screws. Pull loosened stock assembly (and trigger guard assembly) from rifle.

To Replace Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock assembly is factory-listed to include: stock, butt plate, butt plate screw (2), grip cap, grip cap screw, stock swivel front assembly, stock swivel rear assembly, stock swivel nut, stock swivel screw bushing - front, and stock reinforcing screw.

To Reassemble Mount trigger guard assembly to stock assembly, then assemble over trigger assembly and magazine. Hold firmly to receiver and assemble guard screws. Turn both guard screws evenly until tight.

STOCK SWIVEL FRONT ASSEMBLY is designed to mount a sling strap to the rifle stock at the front.

To Disassemble Unscrew and disassemble stock swivel front assembly from stock.

<u>To Replace</u> Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel front assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw - front.

To Reassemble Assemble through stock swivel screw bushing front, and thread into stock swivel nut. Turn until tight and adjust crosswise to stock.

STOCK SWIVEL REAR ASSEMBLY is designed to mount a sling strap to the rear of the stock.

To Disassemble Unscrew and disassemble stock swivel rear assembly from stock.

To Replace Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel rear assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw - rear.

To Reassemble Turn and thread into stock until tight. Adjust crosswise to stock.

## Remington FIELD SERVICE MANUAL

STOCK SWIVEL NUT is designed to mount and tighten stock swivel front assembly firmly to stock.

To Disassemble Remove stock assembly from rifle. Unscrew stock swivel front assembly partway from stock. Tap against stock swivel assembly until stock swivel nut pushes upward ---(take care to avoid damage to stock.) from parrel radius in stock. Remove stock swivel front assembly and thread to parrel side of nut. Pull out and disassemble stock swivel nut from stock. Remove stock swivel front assembly from stock swivel nut.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Reseat stock swivel nut to barrel radius cut in stock. Note taper angle on knurled outside of stock swivel nut. Locate small diameter of taper inward to stock when reassembling to stock. Tap nut gently into place, then rethread stock swivel front assembly from bottom face of stock. Turn swivel until stock swivel nut drawn downward and firmly into stock.

STOCK SWIVEL SCREW BUSHING, FRONT is designed to mount and pivot stock swivel front assembly to stock.

To Disassemble Remove stock from rifle. Remove stock swivel front assembly. Remove stock swivel nut. Apply close fitting tool against bushing from barrel radius cut in stock. Tap against inner end of bushing until this stock swivel bushing, front can be disassembled from bottom face of stock. Avoid damage to stock.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Locate properly to bottom face of stock and tap gently into stock until firmly in place.

BUTT PLATE is designed as aluminum alloy. Light weight and rustproof.

To Disassemble Unscrew butt, plate screw (2). Disassemble butt plate from end of stock.

To Replace Interchangeable with no factory adjustment required. However, replacement part may need additional "surfacing" to end of stock wood, or edge of butt plate for proper match of butt plate to stock.

To Reassemble Assemble butt plate to end of stock, align screw noles, assemble butt plate screw (2), and turn until butt plate is tight.

## Remington FIELD SERVICE MANUAL

GRIP CAP is designed for terminal effect to end of grip and decorative addition of "Remington" script mark.

To Disassemble Unscrew and remove grip cap screw. Disassemble loosened grip cap from stock.

To Replace Interchangeable with no factory adjustment required. Additional "surfacing" of stock or edge of cap needed for proper matching effect.

To Reassemble Locate and align grip cap to stock. Insert grip cap screw and tighten firmly until grip cap is assembled to stock.

TRIGGER GUARD ASSEMBLY of hinged design, permits loading or unloading of the fixed magazine box with a "closed" bolt.

To Disassemble Remove bolt assembly. Unscrew and pull out guard screw, front and rear. Lift loosened stock assembly from trigger. Pull out and disassemble trigger guard from rifle.

Note: Magazine follower and magazine spring (assembled to floor plate) will also be removed from the stock assembly. To remove, unlatch floor plate, lift folded end of spring upwards, pull back and disassemble from floor plate. Magazine follower and magazine spring are same as for Model 721-722 (per respective calibers).

See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Interchangeable with no factory adjustment required. Replacement as assembly if desired. The trigger guard assembly is factory-listed to include floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate pivot pin, trigger guard.

To Reassemble Follow reverse order. Tighten guard screws firmly.

## Remington FIELD SERVICE MANUAL

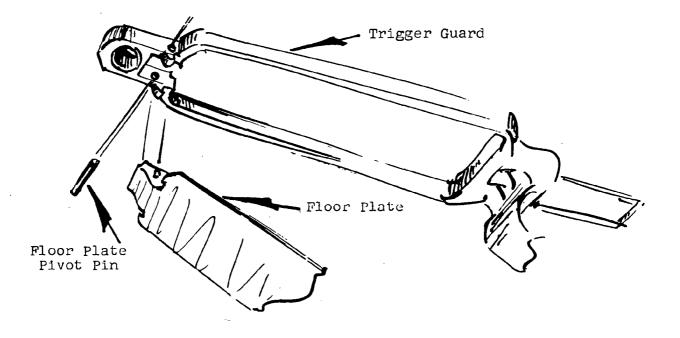
TRIGGER GUARD ASSEMELY - COMPONENTS:

Remove trigger guard assembly. Remove magazine follower, magazine spring from floor plate.

Floor Plate is designed to close bottom of fixed magazine box and mount magazine spring.

To Disassemble Tap out and removefloor plate pivot pin from front of trigger guard. Disassemble floor plate from trigger guard.

Caution: Floor plate pivot pin is tight-fitting; therefore, support trigger guard properly to prevent damage to guard at front section. See sketch below.



To Replace Interchangeable, with no factory adjustment required.

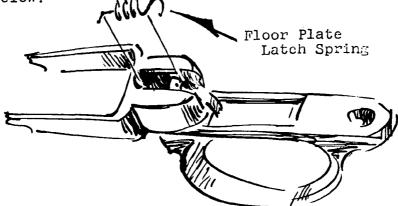
To Reasscable Follow reverse order. Make certain floor plate is free swinging and locks into floor plate latch properly.

## Remington FIELD SERVICE MANUAL

TRIGGER GUARD ASSEMBLY - COMPONENTS: Continued

Floor Plate Latch Spring is designed to place tension on floor plate latch.

To Disassemble Remove trigger guard assembly from rifle. Unhook rear of floor plate latch spring from floor plate latch. Unhook front of latch spring from trigger guard. Disassemble loosened floor plate latch spring from trigger guard. See sketch below.



To Replace Interchangeable with no factory adjustment required.

To Reassemble ... Follow reverse order.

Floor Plate Latch is designed to latch the floor plate to the trigger guard.

To Disassemble Remove trigger guard assembly from rifle. Remove floor plate latch from trigger guard. Tap out <u>floor</u> plate latch pin, left to right. Disassemble floor plate latch from trigger plate. See sketch below.

		Floor	Plate Latch					
Tı	rigger Guard	X				h h	2	
<u>To</u>	Replace	Interchanges no factory a required.			Floor	Plate	Latch	Pin
То	Reassemble	Followr	everse orde:	r.				

TRIGGER GUARD is designed to hold magazine in assembly position and mount components of trigger guard assembly.

To Disassemble Remove trigger guard assembly from rifle. Remove magazine follower and magazine spring from floor plate. Remove floor plate, floor plate latch spring, floor plate latch from trigger guard.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order. Replace all assembly components to trigger guard before reassembly of trigger guard assembly to rifle.

MAGAZINE is designed as staggered column, box type.

Note: Magazine component, although slightly different in design from Model 721-722, assembles in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

BOLT FINAL ASSEMBLY is designed with shrouded head for safety and strength.

Note: Bolt final assembly, although slightly different in design also from the Model 721-722, assembles in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace Bolt assembly component of BOLT FINAL ASSEMBLY includes bolt body assembly, bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor, firing pin assembly, and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is required.

## Remington FIELD SERVICE MANUAL

BOLT STOP is designed to prevent bolt final assembly from being pulled completely from rifle unless bolt stop release is pressed upwards. BOLT STOP SPRING is designed to place oolt stop under tension. BOLT STOP PIN is designed to hold the bolt stop in assembly position and also mount the safety lock thumopiece to the right side of the receiver.

To Disassemble Remove polt rinal assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble bolt stop pin snap washer from left end of bolt stop pin. See sketch SAFETY LOCK THUMBPIECE. Push left end of bolt stop pin across only enough to release bolt stop. Disassemble loosened bolt stop and bolt stop spring. Take care that small bolt stop spring is not lost.

To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

SAFETY LOCK THUMBPIECE ASSEMBLY is designed to operate the "three" position safety. BOLT LOCK is designed to pivot upward and lock bolt closed when safety thumbpiece is pushed to the ON SAFE or "S" mark on the receiver.

To Disassemble Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Remove bolt stop. Push bolt stop pin completely across and disassemble pin and safety lock thumbpiece assembly from rifle. BOLT LOCK WILL ALSO be loosened at this time and can be disassembled from right side of trigger housing. See sketch page 11.

Note: Trigger housing will be in "free pivot" on sear pin only when bolt stop pin is removed. Take care that sear spring, underlying sear and safety cam (also in free pivot), is not lost.

Model 725 ASSEMBLY Page 10

SAFETY LOCK THUMBPIECE ASSEMBLY Continued

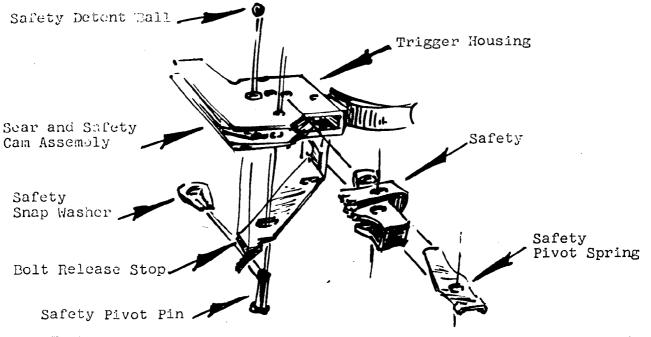
To Replace Interchangeable with no factory adjustment required. Replace safety lock thumppiece assembly as assembly unit.

To Reassemble Follow reverse order. Assemble ratchet teeth in bolt lock and safety lock thumbpiece assembly to safety component properly before bolt stop pin is inserted. Check for proper operation of components to three (3) position stops on receiver.

SAFITY is designed to support safety can of sear and safety can assembly against "cocked" polt. This is accomplished by operation of upthrust inner blade section when safety lock thumbpiece assembly is in ON SAFE position to pear of receiver.

To Disassemble Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble safety snap wacher. Pull off and disassemble <u>safety pivot spring</u>. Remove loosened <u>safety detent ball</u>. Push across and disassemble <u>safety pivot pin</u>. Pull out and disassemble safety from trigger notsing. See sketch below.

Note: Bolt stop release on opposite side of housing will be free when safety pivot pin is removed.



To Replace Interchangeable with no factory adjustment required.

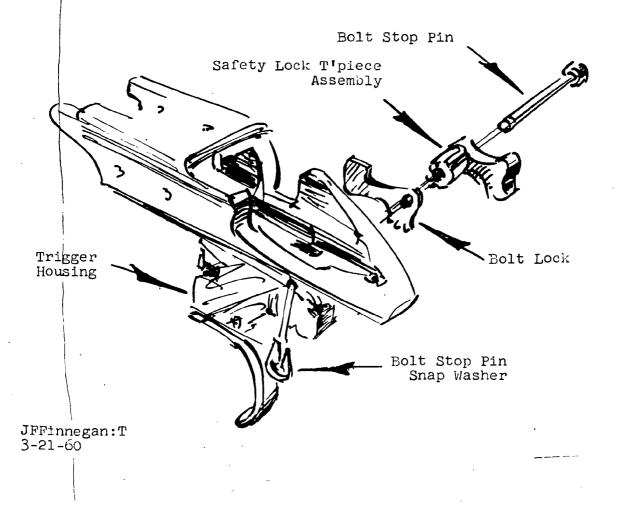
To Reassemble Follow reverse order. Ratchet teeth on safety should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumbpiece assembly for proper operation of three position safety stops.

## Remington FIELD SERVICE MANUAL

TRIGGER ASSEMBLY is designed to mount the action mechanisms of trigger, safety, sear, bolt stop release, to the receiver component of the barrel assembly.

Note: Trigger assembly, although somewhat different in design from the Model 721-722, assembles in the same manner to the receiver. Sear pin and bolt stop pin mount the housing component of trigger assembly to receiver. See Model 721-722 Manual for necessary SERVICE instructions to trigger and sear mechanisms.

To Replace Trigger assembly may be replaced as an assembly with no factory adjustment required. Trigger assembly includes bolt stop release, housing, safety, safety detent ball. safety detent spring, safety pivot pin, safety snap washer, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw. (Seesketch below).



## Remington FIELD SERVICE MANUAL

(See Instruction Folder - RD 5359)

The action cycle of the Model 725 may start as the magazine is loaded and a cartridge locked by the bolt in the chamber. The trigger is pulled to fire each cartridge and the bolt handle is raised to turn and pull the bolt rearward. The return of the bolt forward to reload the next cartridge and then the handle turned down to lock the bolt against the chambered cartridge, completes the operation cycle.

Each cycle is summarized briefly, then in detail the movement of related parts is described more fully. For reason of a <u>safe</u> operation cycle, the Three Position Safety Lock is explained to preface this Cycle.

## Safety Loci:

Safe "S" (mark on receiver) - The rifle cannot be fired nor the bolt handle raised to unlock the bolt from the barrel when the safety lock thumbpiece is rotated fully rearward to the "S" mark on the receiver. In detail, the thumbpiece locks a safety cam component of the trigger assembly up and against the "cocked" firing pin assembly to prevent its forward release. A bolt lock component is also rotated into a bottom channel in the locked bolt. This bolt lock prevents the bolt and bolt handle from turning to unlock.

Unlock Position (no mark on receiver) - The rifle cannot be fired; however, the bolt handle can be raised to unlock and withdraw the bolt, when the safety lock thumbpiece is rotated to a stop position between the Safe "S" and Fire "F" mark on the receiver. In detail, the firing pin assembly continues to be held "cocked" by the safety cam component. However, the bolt lock is rotated from engagement with the bottom channel in the bolt and the bolt handle can be raised to turn and withdraw the bolt.

Fire "F" (mark on receiver) - The rifle can be fired or the bolt handle raised to turn and unlock the bolt when the safety lock thumbpiece is rotated fully forward to the "F" mark on the receiver. In detail, the safety cam component within the trigger assembly is no longer held against the "cocked" firing pin assembly. The bolt lock. as in the Unlock Position, is rotated from engagement with the bottom channel in the bolt. The bolt is free to turn and unlock if the handle is raised.

## Remington FIELD SERVICE MANUAL

Firing (safety lock in "F" position) The firing cycle is simply the pull of the trigger each time to release a spring-loaded or "cocked" firing pin to fire the cartridge. In detail, this pull of the trigger carries forward a connector component from beneath the sear. This forward movement of the connector leaves the sear unsupported against the "cocked" firing pin. With support removed, sear is cammed downward by the spring-urged firing pin. The mainspring then thrusts the firing pin forward to strike the cartridge.

# Note: The design and movement of the connector is to adjust for the shortest possible pull of the trigger with absolutely no over-travel.

Unlocking The unlock cycle is the raising of the bolt handle to disengage the bolt from the breech of the barrel. In detail, this upward swing of the bolt handle turns the bolt to unseat the locking lugs on the head of the bolt from the recoil shoulders in the receiver.

Cocking The "cocking" cycle may be summarized as two movements: (1) The "cocking" of the boltwhich occurs during the unlocking cycle; and (2) The "cocking" of the rifle which occurs during the locking cycle. In detail, the first movement is the withdrawal and notching of the firing pin against the pressure of the tensed mainspring in the bolt. The final movement is the holding or sustaining of the withdrawn or "cocked" pin until the trigger is pulled.

The first or withdrawal movement is caused by the turning of the bolt as the handle is raised. During the turning, a cam cut at the rear of the bolt forces the firing pin assembly rearward, to locate in a notch on the rear rim of the bolt. The final or sustaining movement is simply the transfer of this "cocked" position of the firing pin from the bolt to the sear in the trigger assembly. This transfer to the sear occurs as the bolt handle is lowered in the locking cycle.

The sear then holds the firing pin or rifle "cocked" until the trigger is pulled during the firing cycle, or the bolt handle is raised to re-transfer the "cocking" of the firing pin to the bolt rim.

## Remington FIELD SERVICE MANUAL

Extracting The extracting cycle consists of the "freeing" of the fired cartridge case (or live round) from the cartridge chamber walls in the barrel breech and the pulling of the case from the chamber. In detail, as the bolt handle is raised to unlock the bolt, the final upturn motion engages a camming surface in the receiver. This rearward camming motion of the bolt will disengage the fired case from tight contact with the barrel chamber. Further rearward pull on the bolt handle extracts the fired case completely from the chamber. During the extraction cycle the fired case is gripped firmly to the bolt face by an extractor component. This extractor is recessed within the rim on the bolt head.

Feeding The feeding cycle is the lift and forward movement of the top most cartridge from magazine to barrel breech. In detail, as the bolt clears the magazine opening, the top cartridge in the magazine is pressed upwards by the magazine spring and into feeding position. The return movement of the bolt pushes against the rear of the cartridge. The bullet end of the cartridge moves up the bullet incline and the rear is leveled out free of the feeding lip on the receiver.

Loading The loading cycle is rather brief and comprises the movement of the free cartridge as it is pushed forward by the bolt and loaded completely into the barrel chamber.

Locking The locking cycle occurs as the downward turn of the bolt handle rotates the bolt and locks it against the chambered cartridge. In detail, four engagements are made by this locking cycle: (1) the two locking lugs on bolt head are firmly seated against the recoil shoulders in the receiver; (2) the base of the loaded cartridge is recessed within the bolt face, depressing the ejector and flexing the extractor to snap the claw over the base rim of the cartridge; (3) the sear engages a camming surface to the rear of the firing pin, on the firing pin head; and (4) the sear is supported from beneath by the connector to hold the firing pin back and the rifle "cocked" until the trigger is pulled. Model 725 SERVICING Page 15

## Remington FIELD SERVICE MANUAL

SERVICE instructions for the Remington Model 725 and the Models 721 and 722 are very much alike in many respects (see M/721-722 Manual). Because of this design similarity only limited SERVICING is needed for the M/725; and other than damaged or missing components related to the safety or hinged floor plate mechanisms, or stock, little, if any, servicing for the M/725 is necessary.

#### FLOOR PLATE MECHANISM

1. Floor Plate fails to lock bottoms on stock.

Service: Remove wood margin beneath floor plate.

2. Damaged or missing components.

Service: Repair or replace floor plate, floor plate latch, floor plate latch spring.

#### SAFETY MECHANISM

- 1. Damaged or missing components.
  - Service: Repair or replace safety lock thumopiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball. safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety cam assembly.

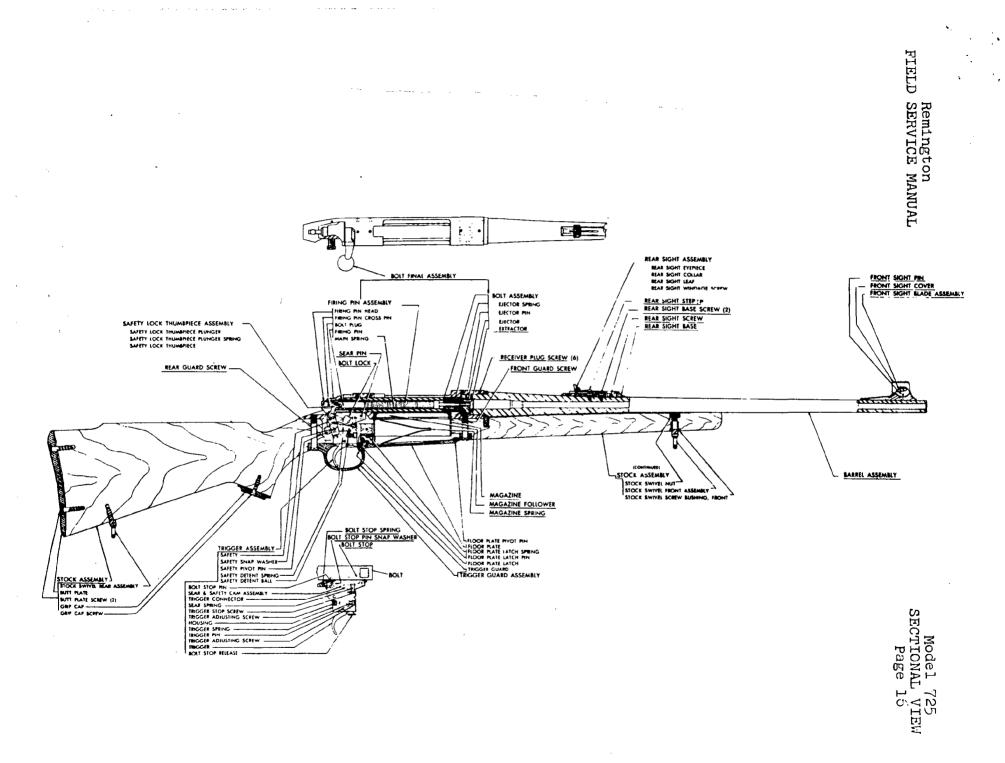
#### STOCK ASSEMBLY

1. Fails to target properly.

Service: a) Adjust or replace sights.

- b) Check barrel bedding. Barrel should be free floating along receiver sides and along barrel length. Should seat evenly in barrel radius cut and have firm contact only at end of stock.
- c) Replace stock, if damaged.

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# REMINGTON FIELD SERVICE MANUAL

The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similiar to the Models 721-722 or other bolt action repeating rifles. Therefore the **ASSEMBLY** and **SERVICING** instructions for the Model 725 will list only those parts of unlike design and operation. Unless otherwise described, all parts are interchangeable with no factory assembly or adjustment required.



Included will be the hinged floor plate for loading or unloading with the bolt closed, and the three (3) position safety lock. Additional instructions will cover stock swivels, grip cap and front sight components.

The Instruction Folder, RD 5359, is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instruction and instructions for care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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#### FRONT SIGHT COVER

To Disassemble – Spread Cover slightly and push forward in cover slots on either side of ramp. Disassemble from rifle.

To Reassemble – Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

#### FRONT SIGHT BLADE

To Disassemble – Remove front sight cover. Support front ramp to prevent damage to barrel and drive out front sight pin. Pull out and disassemble front sight blade from the rifle.

To Reassemble – Support barrel to prevent damage and insert blade in slot in front sight ramp. Align holes and tap in front sight pin.

#### REAR SIGHT ASSEMBLY

To Disassemble – Unscrew rear sight screw and disassemble from rifle. Pull up and disassemble rear sight assembly from barrel. Remove loosened rear sight step.

To Replace – Interchangeable with no factory adjustment required. Replacement as assembly recommended. Rear sight assembly is factory – listed to include: rear sight eyepiece, rear sight collar, rear sight leaf, rear sight windage screw. Special factory processes assemble the part.

To Reassemble – Assemble rear sight assembly in place with bottom ears of the sight aligned properly to rear sight base. Assemble rear sight screw and turn until tight. Lift rear sight eyepiece and assemble rear sight step beneath eyepiece.

#### REAR SIGHT STEP

To Disassemble – Lift or raise rear sight assembly by the eyepiece and slide rear sight step to the rear. Disassemble from barrel.

To Replace – Interchangeable with no factory adjustment required. Additional sight steps, marked for size, and available for range purpose.

To Reassemble – Lift eyepiece and slide rear sight step in place.

#### **REAR SIGHT BASE**

To Disassemble -- Remove rear sight assembly and rear sight step. Unscrew and disassemble rear sight base screw (2). Disassemble rear sight base and rear sight washers (2) from barrel.

To Reassemble – Align to barrel screw holes, insert rear sight base screw (2) and rear sight washers (2), and turn screws to tighten base securely to barrel.

BARREL ASSEMBLY is designed as a rigid factory-assembled group with Receiver. BARREL BRACKET as a factoryassembled component of barrel assembly is designed to vertical recoil shoulder to transfer the back-thrust of the firing recoil against stock, FRONT SIGHT RAMP as another component of barrel assembly is factory-brazed to barrel and designed to establish the sight line and mount front sight blade.

Note: The barrel assembly, although somewhat different in design from the Model 721-722, mounts to other parts of the rifle in the same manner. See Model 721-722 Manual for necessary SERVICE instructions.

To Replace – Replacement as an assembly is recommended. However, the rifle must be returned to the factory for selective assembly. Return of rifle to factory for replacement of any components is also recommended (of barrel assembly).

#### STOCK ASSEMBLY

To Disassemble – Unscrew and disassemble front and rear trigger screws. Pull loosened stock assembly (and trigger guard assembly) from rifle.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock assembly is factory-listed to include: stock, butt plate, butt plate screw (2), grip cap, grip cap screw, stock swivel front assembly, stock swivel rear assembly, stock swivel nut, stock swivel screw bushing-front, and stock reinforcing screw.

To Reassemble – Mount trigger guard assembly to stock assembly, then assemble over trigger assembly and magazine. Hold firmly to receiver and assemble guard screws. Turn both guard screws evenly until tight.

#### STOCK SWIVEL FRONT ASSEMBLY

**To Disassemble** – Unscrew and disassemble stock swivel front assembly from stock.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended, Stock swivel front assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw-front.

To Reassemble – Assemble through stock swivel screw bushing-front, and thread into stock swivel nut. Turn until tight and adjust crosswise to stock.

#### STOCK SWIVEL REAR ASSEMBLY

To Disassemble – Unscrew and disassemble stock swivel rear assembly from stock.

To Replace -- Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel rear assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw-rear.

To Reassemble – Turn and thread into stock until tight. Adjust crosswise to stock.

#### STOCK SWIVEL NUT

To Disassemble – Remove stock assembly from rifle. Unscrew stock swivel front assembly partway from stock. Tap against stock swivel assembly until stock swivel nut pushes upward--- (take care to avoid damage to stock.) from barrel radius in

stock. Remove stock swivel front assembly and thread to barrel side of nut. Pull out and disassemble stock swivel nut from stock. Remove stock swivel from assembly from stock swivel nut.

To Reassemble – Reseat stock swivel nut to barrel radius cut in stock. Note taper angle on knurled outside of stock swivel nut. Locate small diameter of taper inward to stock when reassembling to stock. Tap nut gently into place, then rethread stock swivel front assembly from bottom face of stock. Turn swivel until stock swivel nut drawn downward and firmly into stock.

#### STOCK SWIVEL SCREW BUSHING FRONT

To Disassemble – Remove stock from rifle. Remove stock swivel front assembly. Remove stock swivel nut. Apply close fitting tool against bushing from barrel radius cut in stock. Tap against inner end of bushing until this stock swivel bushing, front can be disassembled from bottom face of stock. Avoid damage to stock.

To Reassemble – Locate properly to bottom face of stock and tap gently into stock until firmly in place.

#### BUTT PLATE

To Disassemble – Unscrew butt plate screw (2), Disassemble butt plate from end of stock.

**To Replace** – Interchangeable with no factory adjustment required. However, replacement part may need additional "surfacing" to end of stock wood, or edge of butt plate for proper match of butt plate to stock.

To Reassemble – Assemble butt plate to end of stock, align screw holes, assemble butt plate screw (2), and turn until butt plate is tight.

#### GRIP CAP

To Disassemble – Unscrew and remove grip cap screw. Disassemble loosened grip cap from stock.

To Replace – Interchangeable with no factory adjustment required. Additional "surfacing" of stock or edge of cap needed for proper matching effect.

To Reassemble – Locate and align grip cap to stock. Insert grip cap screw and tighten firmly until grip cap is assembled to stock.

TRIGGER GUARD ASSEMBLY of hinged design, permits loading or unloading of the fixed magazine box with a "closed" bolt.

To Disassemble – Remove bolt assembly. Unscrew and pull out guard screw, front and rear. Lift loosened stock assembly from trigger. Pull out and disassemble trigger guard from rifle.

Note: Magazine follower and magazine spring (assembled to floor plate) will also be removed from the stock assembly. To remove, unlatch floor plate, lift folded end of spring upwards, pull back and disassemble from floor plate. Magazine follower and magazine spring are same as for Model 721-722 (per respective calibers).

See Model 721-722 Manual for necessary SERVICE instructions.

To Replace – Interchangeable with no factory adjustment required. Replacement as assembly if desired. The trigger guard assembly is factory-listed to include floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate latch pin, Trigger guard.

To Reassemble – Follow reverse order. Tighten guard screws firmly.

TRIGGER GUARD ASSEMBLY - COMPONENTS:

Remove trigger guard assembly. Remove magazine follower, magazine spring from floor plate.

Floor Plate

To Disassemble – Tap out and remove floor plate pivot pin from front of trigger guard. Disassemble floor plate from trigger guard.

Caution: Floor plate pivot pin is tight-fitting, therefore, support trigger guard properly to prevent damage to guard at front section.

To Reassemble – Follow reverse order. Make certain floor plate is free swinging and locks into floor plate latch properly.

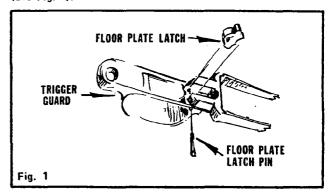
Floor Plate Latch Spring

To Disassemble – Remove triggerguard assembly from rifle. Unhook rear of floor plate latch spring from floor plate latch. Unhook front of latch spring from trigger guard. Disassemble loosened floor plate latch spring from trigger guard.

To Reassemble - Follow reverse order.

Floor Plate Latch

To Disassemble – Remove trigger guard assembly from rifle. Remove floor plate latch from trigger guard. Tap out floor plate latch pin, left to right. Disassemble floor plate latch pin, left to right. Disassemble floor plate latch from trigger plate (See Fig. 1).



To Reassemble - Follow reverse order.

#### TRIGGER GUARD

To Disassemble – Remove trigger guard assembly from rifle. Remove magazine follower and magazine spring from floor plate. Remove floor plate, floor plate latch spring, floor plate latch from trigger guard.

To Reassemble – Follow reverse order. Replace all assembly components to trigger guard before reassembly of trigger guard assembly to rifle.

#### MAGAZINE

Note: Magazine component, although slightly different in design from Model 721–722, assembles in the same manner. See Model 721–722 Manual for necessary SERVICE instructions.

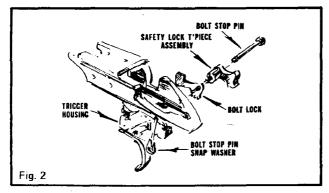
#### BOLT FINAL ASSEMBLY

Note: Bolt final assembly, although slightly different in design also from the Model 721–722, assembles in the same manner. See Model 721–722 Manual for necessarySERVICE instructions.

To Replace — Bolt assembly component of BOLT FINAL AS-SEMBLY includes bolt body assembly, bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor, firing pin assembly, and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is required.

#### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble bolt stop pin snap washer from left end of bolt stop pin. (See Fig. 2). Push left end of bolt stop pin across only enough to release bolt stop. Disassemble loosened bolt stop and bolt stop spring. Take care that small bolt stop spring is not lost.



To Reassemble - Follow reverse order.

SAFETY LOCK THUMBPIECE ASSEMBLY is designed to operate the "three" position safety. BOLT LOCK is designed to pivot upward and lock bolt closed when safety thumbpiece is pushed to the ON SAFE or "S" mark on the receiver. To Disassemble – Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Remove bolt stop. Push bolt stop pin completely across and disassemble pin and safety lock thumbpiece assembly from rifle. BOLT LOCK WILL ALSO be loosened at this time and can be disassembled from right side of trigger housing. (See Fig. 2).

Note: Trigger housing will be in "free pivot" on sear pin only when bolt stop pin is removed. Take care that sear spring, underlying sear and safety cam (also in free pivot), is not lost.

To Replace – Interchangeable with no factory adjustment required. Replace safety lock thumbpiece assembly as assembly unit.

To Reassemble – Follow reverse order. Assemble ratchet teeth in bolt lock and safety lock thumbpiece assembly to safety component properly before bolt stop pin is inserted. Check for proper operation of components to three (3) position stops on receiver.

**SAFETY** is designed to support safety cam of sear and safety cam assembly against "cocked" bolt. This is accomplished by operation of upthrust inner blade section when safety lock thumbpiece assembly is in ON SAFE position to rear of receiver.

To Disassemble – Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble safety snap washer. Pull off and disassemble safety pivot spring. Remove loosened safety detent ball. Push across and disassemble safety pivot pin. Pull out and disassemble safety from trigger housing.

Note: Bolt stop release on opposite side of housing will be free when safety pivot pin is removed.

To Reassemble – Follow reverse order. Ratchet teeth on safety should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumbpiece assembly for proper operation of three position safety stops.

#### TRIGGER ASSEMBLY

Note: Trigger assembly, although somewhat different in design from the Model 721–722, assembles in the same manner to the receiver. Sear pin and bolt stop pin mount the housing component of trigger assembly to receiver. See Model 721– 722 Manual for necessary SERVICE instructions to trigger and sear mechanisms.

To Replace – Trigger assembly may be replaced as an assembly with no factory adjustment required. Trigger assembly includes bolt stop release, housing, safety, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw. (See Fig. 2).

# CYCLE OF OPERATION

The action cycle of the Model 725 may start as magazine is loaded and a cartridge locked by bolt in chamber. The trigger is pulled to fire each cartridge and the bolt handle is raised to turn and pull bolt rearward. The return of bolt forward to reload next cartridge and the handle turned down to lock bolt against chambered cartridge, completes operation cycle.

Each cycle is summarized briefly, then in detail the movement of related parts is described more fully, For reason of a safe operation cycle, the Three position Safety Lock is explained to preface this Cycle.

#### SAFETY LOCK

Safe "S" (mark on receiver) – The rifle cannot be fired nor bolt handle raised to unlock bolt from barrel when safety lock thumbpiece is rotated fully rearward to the "S" mark on receiver. In detail, the thumbpiece locks a safety cam component of trigger assembly up and against "cocked" firing pin assembly to prevent its forward release. A bolt lock component is also rotated into a bottom channel in locked bolt. This bolt lock prevents bolt and bolt handle from turning to unlock.

Unlock position (no mark on receiver) — The rifle cannot be fired; however, bolt handle can be raised to unlock and withdraw bolt, when safety lock thumbpiece is rotated to a stop position between the Safe "S" and Fire "F" mark on receiver; In detail, the firing pin assembly continues to be held "cocked" by safety cam component. However, the bolt lock is rotated from engagement with bottom channel in bolt and the bolt handle can be raised to turn and withdraw bolt.

Fire "F" (mark on receiver) — The rifle can be fired or bolt handle raised to turn and unlock bolt when safety lock thumbpiece is rotated fully forward to "F" mark on receiver. In detail, the safety cam component within trigger assembly is no longer held against "cocked" firing pin assembly. The bolt lock, as in the Unlock Position, is rotated from engagement with bottom channel in bolt. The bolt is free to turn and unlock if handle is raised,

#### FIRING

(safety lock in "F" position) The firing cycle is simply the pull of trigger each time to release a spring-loaded or "cocked" firing pin to fire cartridge. In detail, this pull of trigger carries forward a connector component from beneath sear. This forward movement of connector leaves sear unsupported against "cocked" firing pin. With support removed, sear is cammed downward by the spring-urged firing pin. The mainspring then thrusts firing pin forward to strike cartridge.

Note: The design and movement of connector is to adjust for shortest possible pull of trigger with absolutely no over-travel.

#### UNLOCKING

The unlock cycle is the raising of bolt handle to.disengage bolt from breech of barrel. In detail, this upward swing of bolt handle turns bolt to unseat locking lugs on head of bolt from recoil shoulders in receiver.

#### COCKING

The cocking cycle may be summarized as two movements: (1) The cocking of bolt which occurrs during unlocking cycle; and (2), The "cocking" of rifle which occurs during locking cycle. In detail, the first movement is the withdrawal and notching of firing pin against pressure of the tensed mainspring in bolt. The final movement is the holding or sustaining of the withdrawn or cocked pin until trigger is pulled.

The first or withdrawal movement is caused by turning of bolt as handle is raised. During the turning, a cam cut at rear of bolt forces firing pin assembly rearward, to locate in a notch on rear rim of bolt. The final or sustaining movement is simply the transfer of this "cocked" position of firing pin from bolt to sear in trigger assembly. This transfer to sear occurs as bolt handle is lowered in locking cycle.

The sear then holds firing pin or rifle "cocked" until trigger is pulled during firing cycle, or the bolt handle is raised to retransfer cocking of firing pin to bolt rim.

#### EXTRACTING

The extracting cycle consists of freeing of fired cartridge case (or live round) from cartridge chamber walls in barrel breech and pulling of case from chamber, In detail, as bolt handle is raised to unlock bolt, the final upturn motion engages a camming surface in receiver. This rearward camming motion of bolt will disengage fired case from tight contact with barrel chamber. Further rearward pull on bolt handle extracts fired case completely from chamber. During extraction cycle, fired case is gripped firmly to bolt face by an extractor component. This extractor is recessed within the rim on bolt head.

#### FEEDING

The feeding cycle is the lift and forward movement of the top most cartridge from magazine to barrel breech. In detail, as bolt clears the magazine opening, the top cartridge in magazine is pressed upwards by magazine spring and into feeding position. The return movement of bolt pushes against rear of cartridge. The bullet end of cartridge moves up bullet incline and the rear is leveled out free of feeding lip on receiver.

#### LOADING

The loading cycle is rather brief and comprises movement of free cartridge as it is pushed forward by bolt and loaded completely into barrel chamber.

#### LOCKING

The locking cycle occurs as the downward turn of bolt handle rotates bolt and locks it against chambered cartridge. In detail, four engagements are made by this locking cycle: (1) the two locking lugs on bolt head are firmly seated against recoil shoulders in receiver; (2) the base of loaded cartridge is recessed within bolt face, depressing ejector and flexing extractor to snap claw over base rim of cartridge; (3) the sear engages a camming surface to rear of firing pin, on firing pin head; and (4) the sear is supported from beneath by connector to hold firing pin back and rifle "cocked" until trigger is pulled.

# MALFUNCTIONS

### **Cause and Correction**

Note: For malfunctions not listed below, see Model 721-722 Manual.

SERVICE instructions for the Remington Model 725 and the Models 721 and 722 are very much alike in many respects (see M/721-722 Manual). Because of this design similarity only limited SERVICING is needed for the M/725: and other than damaged or missing components related to safety or hinged floor plate mechanisms, or stock, little, if any, servicing for the M/725 is necessary.

#### FLOOR PLATE MECHANISM

- 1. Floor Plate fails to lock bottom on stock. Service: Remove wood margin beneath floor plate.
- 2. Damaged or missing components. Service: Repair or replace floor plate, floor plate latch, floor plate latch spring.

#### SAFETY MECHANISM

1.

Damaged or missing components. Service: Repair or replace safety lock thumbpiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball, safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety

#### STOCK ASSEMBLY

1. Fails to target properly.

Service: a. Adjust or replace sights.

cam assembly.

- b. Check barrel bedding. Barrel should be free floating along receiver sides and along barrel length. Should seat evenly in barrel radius cut and have firm contact only at end of stock.
- c. Replace stock, if damaged.

### REMINGTON FIELD SERVICE MANUAL

#### DISASSEMBLY

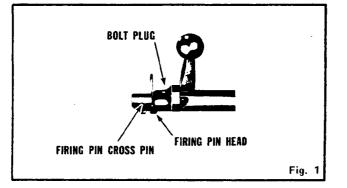
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#### BOLT AND COMPONENTS

Press upward on bolt stop release in front of trigger, lift up bolt handle as far as it will go, and pull bolt rearward from receiver.

#### FIRING PIN AND COMPONENTS

Pull firing pin head rearward until a coin can be inserted between it and bolt plug. (Fig. 1). This can be done by catching notch in firing pin head on a sharp corner. Unscrew bolt plug to remove firing pin assembly.



#### **FIRING PIN**

Drive out firing pin cross pin (See Fig. 1) with a punch, leaving punch in hole to hold parts together to prevent main spring tension from stripping off firing pin head and bolt plug forcefully. Compress main spring with bolt plug until coin, punch and firing pin head can be removed and release main spring tension carefully, removing firing pin head, bolt plug and main spring.

#### EJECTOR

Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until ejector spring is no longer loaded. Remove ejector and ejector spring.

#### EXTRACTOR

With pointed tweezers inserted in holes provided in the ends of extractor, compress ends together until extractor can be removed from face of bolt. Do not attempt to remove only one end of extractor and then pull it from bolt face as bending will result.

#### **BARREL AND ACTION FROM STOCK**

Unscrew rear, center, and front guard screws. Remove trigger guard, magazine spring, magazine follower and trigger guide

plate from bottom of stock. Lift barrel and action out of stock. Remove magazine from either stock or receiver as it will remain in either.

#### BOLT STOP

Drive out bolt stop pin, drop rear end of trigger housing, remove bolt stop and bolt stop spring.

#### TRIGGER HOUSING ASSEMBLY

Drive out sear pin and remove trigger housing assembly from bottom of receiver.

#### TRIGGER HOUSING

Remove sear, safety cam and sear spring. With a screwdriver or coin push the safety snap washer out of slot in safety pivot pin, remove safety detent spring, safety detent ball, safety pivot pin, bolt stop release, and safety. Be careful not to lose safety detent ball. Remove front and rear trigger adjusting screws, trigger spring, and trigger stop screw. Drive out trigger pin and remove trigger and trigger connector.

#### BARREL-RECEIVER ASSEMBLY

When necessary to disassemble, return rifle to factory.

#### ASSEMBLY

#### TRIGGER HOUSING

Assemble trigger connector, trigger and drive in trigger pin until it is even with right side of trigger housing. Assemble trigger spring, front trigger adjusting screw, rear trigger adjusting screw, and trigger stop screw. Assemble safety, bolt stop release, safety pivot pin, safety detent ball, safety detent spring, and safety snap washer.

Assemble sear spring, sear and safety cam.

#### BOLT ASSEMBLY EXTRACTOR

With pointed tweezers inserted in holes provided in end of extractor, compress ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not try to assemble by forcing it into bolt face with fingers.

#### EJECTOR

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

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### MODEL 721-722

#### FIRING PIN

Assemble main spring and bolt plug, grasp bolt plug and compress main spring. Assemble firing pin head, align hole in firing pin head and firing pin, insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

#### FIRING PIN ASSEMBLY

Assemble firing pin assembly in rear end of bolt. Align firing pin head with detent notch in rear end of bolt, and remove coin between firing pin head and bolt plug.

#### BARREL-ACTION

#### BOLT STOP

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver, and drive bolt stop pin in part way. Raise up rear end of trigger housing until hole aligns, compress sear and safety cam and completely drive in bolt stop pin.

#### BOLT ASSEMBLY

Assemble bolt assembly in receiver and close, leaving firing pin cocked. Turn rear trigger adjusting screw right or left to obtain proper engagement of trigger connector with sear. Turn front trigger adjusting screw right or left to secure proper weight of pull. Adjust trigger stop screw by turning clockwise until trigger cannot be pulled. Hold on trigger and back off trigger stop screw until firing pin falls.

#### BARREL-ACTION-STOCK ASSEMBLY

Assemble magazine box to receiver, stock to barrel action, magazine follower and magazine spring in magazine, trigger guide plate and trigger guard to stock with rear, center, and front guard screws.

#### FITTING OF NEW PARTS AND ADJUSTING

#### BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

#### BOLT

Remove bolt assembly from receiver. Remove firing pin assembly, ejector and extractor from bolt. Try new bolt for freedom in receiver and headspace. Mark serial number on new bolt, assemble extractor, ejector and firing pin assembly. Check freedom of firing pin and protrusion. Assemble bolt assembly in receiver. Inspect for cocking of firing pin and blow, operation of safety, ejector and extractor.

#### BOLT PLUG

Remove bolt assembly from receiver. Remove firing pin assembly from bolt, drive out firing pin cross pin and remove firing pin head and bolt plug. After reassembling, try for operation of bolt, firing pin protrusion, and safety.

#### BOLT STOP

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Drive out bolt stop pin part way and remove bolt stop. After replacing bolt stop, check for freedom of movement.

#### BOLT STOP RELEASE

Remove bolt assembly from receiver, rear center and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

After replacing bolt stop release, check for freedom of movement.

#### BOLT STOP SPRING

Remove bolt assembly from receiver, rear, center and front trigger guard screw, and action from stock. Drive out bolt stop pin part way and remove bolt stop and spring. After replacing bolt stop spring, check for freedom of movement of the bolt stop.

#### EJECTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector. After reassembling ejector, check for freedom of movement and that ejector moves below bolt face.

#### EJECTOR SPRING

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring. After reassembling ejector spring, check freedom of ejector.

#### EXTRACTOR

Remove bolt assembly from receiver. Drive out ejector pin and remove ejector and ejector spring. With pointed tweezers inserted in holes provided in ends of extractor, compress ends together until extractor can be removed from face of bolt. To replace a new extractor use tweezers as above noted. Extractor hook to face bolt.

After reassembling extractor, reassemble ejector spring, ejector with ejector pin. Try extractor on a dummy cartridge in chamber to check closing over rim and ejection.

#### **FIRING PIN**

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring from firing pin.

After assembling new firing pin, check freedom in bolt, protrusion, cocking, operation of safety, and blow.

#### **FIRING PIN HEAD**

Remove bolt assembly from receiver and firing pin assembly from breech bolt. Drive out firing pin cross pin and remove firing pin head. After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

#### FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

#### MAIN SPRING

Remove bolt assembly from receiver and firing pin assembly from bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring. After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

#### MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding or cartridges.

#### MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

#### MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower. After reassembling magazine spring, check loading and feeding of cartridges.

#### REAR TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

#### SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear and freedom of movement.

#### SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer, safety detent spring and safety detent.

After reassembling new detent, try safety for proper operation.

#### SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

#### SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

#### SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer.

#### SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, sear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly;

After reassembling new sear—safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

#### SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt and trigger.

#### STOCK

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

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firing pin head. After reassembling firing pin head, check cocking, safety operation, cocking of firing pin, protrusion, and blow.

#### FRONT TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center and front trigger guard screws, and action from stock. Remove front trigger adjusting screw.

After reassembling front trigger adjusting screw, adjust screw until trigger pull has correct weight.

#### MAIN SPRING

Remove bolt assembly from receiver and firing pin assembly from bolt. Drive out firing pin cross pin and remove firing pin head, bolt plug and main spring. After reassembling main spring, check freedom of firing pin, firing pin blow, operation of bolt.

#### MAGAZINE

Remove bolt assembly from receiver, rear, center and front trigger guard screws, action from stock, magazine spring, magazine follower from magazine and magazine from receiver or stock.

After reassembling magazine, check for loading and feeding or cartridges.

#### MAGAZINE FOLLOWER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard from stock. Remove magazine follower from magazine spring.

After reassembling magazine follower, check freedom in magazine, loading and feeding of cartridges.

#### MAGAZINE SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and trigger guard from stock. Remove magazine spring and magazine follower from magazine. Remove magazine spring from magazine follower. After reassembling magazine spring, check loading and feeding of cartridges.

#### REAR TRIGGER ADJUSTING SCREW

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove rear trigger adjusting screw. Adjust new screw until proper engagement of trigger connector and sear is made.

#### SAFETY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, and action from stock. Remove safety snap washer, safety detent spring, safety detent, safety detent pin and safety.

After reassembling new safety, check locking of bolt, working of detent, locking of sear and freedom of movement.

#### SAFETY DETENT

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer, safety detent spring and safety detent.

After reassembling new detent, try safety for proper operation.

#### SAFETY DETENT SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer and safety detent spring.

After reassembling new spring, try safety for proper working.

#### SAFETY PIVOT PIN

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer and safety pivot pin.

#### SAFETY SNAP WASHER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove safety snap washer.

#### SEAR-SAFETY CAM ASSEMBLY

Remove bolt assembly from receiver, sear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear and safety cam from trigger assembly;

After reassembling new sear-safety cam, check operation of trigger, safety, bolt, and firing pin for proper function. Adjust trigger function as needed.

#### SEAR SPRING

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly. Remove sear, safety cam and sear spring from trigger assembly.

After reassembly of new spring, check function of sear-safety cam, safety, firing pin, bolt and trigger.

#### STOCK

Remove bolt assembly from receiver, rear, center, and front trigger guard screws, trigger guard, trigger guide plate, magazine spring, magazine follower. Remove action from stock and magazine from receiver or stock.

After assembling new stock, check for barrel pull at front end of fore-end clearance at bolt handle, operation of safety and trigger.

#### TRIGGER ASSEMBLY

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Drive out bolt stop pin part way and drive out sear pin. Remove trigger assembly.

After reassembling new trigger assembly, try bolt for cocking firing pin, safety, and trigger for correct weight and travel. Try trigger for proper engagement of trigger connector with sear.

#### TRIGGER

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger, check trigger for travel and weight of pull. Adjust front and rear trigger adjusting screws and trigger stop screw if required. Try safe and cocking of firing pin.

#### TRIGGER CONNECTOR

Remove bolt assembly from receiver, rear, center, and front trigger guard screws and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing. Drive out trigger pin and remove trigger and trigger connector.

After reassembling trigger connector, check trigger for operation and freedom. Try safe and cocking of firing pin.

#### TRIGGER GUARD

Remove bolt assembly from receiver, front center, and rear trigger guard screws and trigger guard from stock.

#### **TRIGGER GUIDE PLATE**

Remove bolt assembly from receiver, front, center, and rear trigger guard screws, trigger guard and trigger guide plate.

After reassembling trigger guide plate, check freedom of trigger.

#### TRIGGER HOUSING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws and action from stock. Drive out bolt stop pin part way, drive out sear pin and remove trigger assembly from receiver. Remove all parts from trigger housing.

After reassembling trigger housing check operation of trigger, safety, bolt, and firing pin. Adjust front and rear trigger adjusting screws and trigger stop screw, if required.

#### TRIGGER SPRING

Remove bolt assembly from receiver, front, center, and rear trigger guard screws and action from stock. Remove front trigger adjusting screw and trigger spring from trigger housing

After reassembling trigger spring, adjust front trigger adjusting screw until the proper weight of trigger pull is accomplished.

#### TRIGGER STOP SCREW

Remove bolt assembly from receiver, front, center, and rear trigger guard screws and action from stock. Remove trigger stop screw from trigger housing.

After replacing trigger stop screw, adjust until proper movement of trigger is accomplished.

# **CYCLE OF OPERATION**

The operation cycle of the Model 721–722 is similar and common with most hand-operated bolt action rifles. Firing, movement of Bolt Handle upward and fully back to open, then forward again and down to close Bolt completes cycle. Presuming rifle to be fully loaded with one cartridge locked in barrel chamber, the sequence for operations cycle is as follows:

#### FIRING

The firing cycle is simply the release of a spring-loaded firing pin. The forward thrust of the spring-Urged pin strikes primer of cartridge with sufficient force to indent primer and ignite powder charge. With thumb-operated safety in "OFF" position, rifle is fired by pulling trigger rearward. In detail, the rearward movement of trigger carrier trigger connector forward. This action deprives blocked sear of its support and permits it to be cammed downward by pressure from cocked firing pin. As this support is removed beneath sear, firing pin cams sear downward and sear cams connector forward. Action of connector is to allow shortest movement of trigger possible with absolutely no over-travel.

#### UNLOCK

After firing, the upward swing of bolt handle rotates bolt. The two locking lugs at head of bolt are then unseated from support of two locking shoulders in Receiver. The bolt is then free to be withdrawn rearward.

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Simutaneously with the unlocking cycle, a cam at rear of rotating bolt withdraws and locates firing pin to a partially cocked position on rear perimeter of bolt. The remainder of cocking is accomplished during locking cycle.

#### **EXTRACTION**

The rim of cartridge is seated within Bolt Head and is gripped by claw of a circular recessed Extractor. During the latter portion of rotation of Bolt Handle for unlocking a primary extraction cam retracts Bolt approximately 1/8'' with a mechanical advantage of 8-1. With Bolt Handle turned fully upward and lugs of Bolt clear of locking shoulders in Receiver, bolt is free to be withdrawn rearward and complete extraction.

#### EJECTION

A spring urged pin ejector is located within bolt face and maintains outward pressure on base of cartridge. As bolt is moved rearward and front of cartridge or fired case reaches ejection port, constant pressure of ejector and opposing grip of extractor eject cartridge case from open port of receiver.

#### FEEDING

As fired cartridge is ejected, rearward travel of bolt is halted by bolt stop. As bolt clears magazine opening, top cartridge in magazine is urged upward by magazine spring and into feeding position. With action completely open, initial return movement of bolt engages rim of top cartridge fed from magazine. The continued forward travel of bolt advances cartridge up incline of Receiver and into chamber. Guided by bullet end of cartridge entering chamber, rear end is leveled free of feeding lip of Receiver.

#### LOADING

Resting ahead of advancing bolt, cartridge is urged forward and loaded into barrel chamber.

#### LOCKING

With action closed and cartridge full seated in chamber, further movement of Bolt Handle **downward** rotates and locks Bolt against chambered cartridge. During this rotary locking cycle, three engagements are effected: (1) The two lugs on bolt head are firmly supported by the locking shoulders within receiver; (2) Base of cartridge is seated in head of bolt, depress-ing ejector and flexing extractor to snap claw over rim of cartridge; and (3) Sear engages a camming surface on firing pin head, cocking cam of bolt is disengaged from firing pin and rotated to firing position, Sear is blocked in firing position by trigger and trigger connector until released by trigger action.

#### SAFETY

The thumb-operated Safety, located at rear right side of Receiver, has two functions. With action closed and Bolt in a locked position, rearward pivot of safety ("ON" position) will place a supporting member under safety cams which will in turn prevent release of cocked firing pin. The second function with safety in the same "ON" position will swing a locking blade into a channel at bottom rear of Bolt. This will lock Bolt in a closed position. With safety clicked forward in "OFF" position, internal conditions described above will be nonexistent, thereby permitting rifle to be fired.

The instructions for Loading and Unloading, with directions for disassembly and care of rifle are contained in the instruction folder supplied with each rifle.

### REMINGTON FIELD SERVICE MANUAL

The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similiar to the Models 721-722 or other bolt action repeating rifles. Therefore the **ASSEMBLY** and **SERVICING** instructions for the Model 725 will list only those parts of unlike design and operation. Unless otherwise described, all parts are interchangeable with no factory assembly or adjustment required.



Included will be the hinged floor plate for loading or unloading with the bolt closed, and the three (3) position safety lock. Additional instructions will cover stock swivels, grip cap and front sight components.

The Instruction Folder, RD 5359, is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instruction and instructions for care and maintenance of the rifle.

When handling he rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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### MODEL 725

#### FRONT SIGHT COVER

To Disassemble – Spread Cover slightly and push forward in cover slots on either side of ramp. Disassemble from rifle.

To Reassemble – Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

#### FRONT SIGHT BLADE

To Disassemble – Remove front sight cover. Support front ramp to prevent damage to barrel and drive out front sight pin. Pull out and disassemble front sight blade from the rifle.

To Reassemble – Support barrel to prevent damage and insert blade in slot in front sight ramp. Align holes and tap in front sight pin.

#### REAR SIGHT ASSEMBLY

To Disassemble – Unscrew rear sight screw and disassemble from rifle. Pull up and disassemble rear sight assembly from barrel. Remove loosened rear sight step.

To Replace – Interchangeable with no factory adjustment required. Replacement as assembly recommended. Rear sight assembly is factory – listed to include: rear sight eyepiece, rear sight collar, rear sight leaf, rear sight windage screw. Special factory processes assemble the part.

To Reassemble – Assemble rear sight assembly in place with bottom ears of the sight aligned properly to rear sight base. Assemble rear sight screw and turn until tight. Lift rear sight eyepiece and assemble rear sight step beneath eyepiece.

#### REAR SIGHT STEP

To Disassemble – Lift or raise rear sight assembly by the eyepiece and slide rear sight step to the rear. Disassemble from barrel.

To Replace – Interchangeable with no factory adjustment required. Additional sight steps, marked for size, and available for range purpose.

To Reassemble – Lift eyepiece and slide rear sight step in place.

#### REAR SIGHT BASE

To Disassemble – Remove rear sight assembly and rear sight step. Unscrew and disassemble rear sight base screw (2). Disassemble rear sight base and rear sight washers (2) from barrel.

To Reassemble – Align to barrel screw holes, insert rear sight base screw (2) and rear sight washers (2), and turn screws to tighten base securely to barrel.

BARREL ASSEMBLY is designed as a rigid factory-assembled group with Receiver. BARREL BRACKET as a factoryassembled component of barrel assembly is designed to vertical recoil shoulder to transfer the back-thrust of the firing recoil against stock. FRONT SIGHT RAMP as another component of barrel assembly is factory-brazed to barrel and designed to establish the sight line and mount front sight blade.

Note: The barrel assembly, although somewhat different in design from the Model 721-722, mounts to other parts of the rifle in the same manner. See Model 721–722 Manual for necessary SERVICE instructions.

To Replace – Replacement as an assembly is recommended. However, the rifle must be returned to the factory for selective assembly. Return of rifle to factory for replacement of any components is also recommended (of barrel assembly).

#### STOCK ASSEMBLY

To Disassemble – Unscrew and disassemble front and rear trigger screws. Pull loosened stock assembly (and trigger guard assembly) from rifle.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock assembly is factory-listed to include: stock, butt plate, butt plate screw (2), grip cap, grip cap screw, stock swivel front assembly, stock swivel rear assembly, stock swivel nut, stock swivel screw bushing-front, and stock reinforcing screw.

To Reassemble – Mount trigger guard assembly to stock assembly, then assemble over trigger assembly and magazine. Hold firmly to receiver and assemble guard screws. Turn both guard screws evenly until tight.

#### STOCK SWIVEL FRONT ASSEMBLY

**To Disassemble** – Unscrew and disassemble stock swivel front assembly from stock.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended, Stock swivel front assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw-front.

To Reassemble – Assemble through stock swivel screw bushing-front, and thread into stock swivel nut. Turn until tight and adjust crosswise to stock.

#### STOCK SWIVEL REAR ASSEMBLY

To Disassemble – Unscrew and disassemble stock swivel rear assembly from stock.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel rear assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw-rear.

To Reassemble – Turn and thread into stock until tight. Adjust crosswise to stock.

#### STOCK SWIVEL NUT

To Disassemble – Remove stock assembly from rifle. Unscrew stock swivel front assembly partway from stock. Tap against stock swivel assembly until stock swivel nut pushes upward---- (take care to avoid damage to stock.) from barrel radius in

stock. Remove stock swivel front assembly and thread to barrel side of nut. Pull out and disassemble stock swivel nut from stock. Remove stock swivel from assembly from stock swivel nut.

To Reassemble – Reseat stock swivel nut to barrel radius cut in stock. Note taper angle on knurled outside of stock swivel nut. Locate small diameter of taper inward to stock when reassembling to stock. Tap nut gently into place, then rethread stock swivel front assembly from bottom face of stock. Turn swivel until stock swivel nut drawn downward and firmly into stock.

#### STOCK SWIVEL SCREW BUSHING FRONT

To Disassemble – Remove stock from rifle. Remove stock swivel front assembly. Remove stock swivel nut. Apply close fitting tool against bushing from barrel radius cut in stock. Tap against inner end of bushing until this stock swivel bushing, front can be disassembled from bottom face of stock. Avoid damage to stock.

To Reassemble – Locate properly to bottom face of stock and tap gently into stock until firmly in place.

#### BUTT PLATE

To Disassemble – Unscrew butt plate screw (2), Disassemble butt plate from end of stock.

To Replace – Interchangeable with no factory adjustment required. However, replacement part may need additional "surfacing" to end of stock wood, or edge of butt plate for proper match of butt plate to stock.

To Reassemble – Assemble butt plate to end of stock, align screw holes, assemble butt plate screw (2), and turn until butt plate is tight.

#### GRIP CAP

To Disassemble – Unscrew and remove grip cap screw. Disassemble loosened grip cap from stock.

**To Replace** – Interchangeable with no factory adjustment required. Additional "surfacing" of stock or edge of cap needed for proper matching effect.

To Reassemble – Locate and align grip cap to stock. Insert grip cap screw and tighten firmly until grip cap is assembled to stock.

TRIGGER GUARD ASSEMBLY of hinged design, permits loading or unloading of the fixed magazine box with a "closed" bolt.

To Disassemble – Remove bolt assembly. Unscrew and pull out guard screw, front and rear. Lift loosened stock assembly from trigger. Pull out and disassemble trigger guard from rifle.

Note: Magazine follower and magazine spring (assembled to floor plate) will also be removed from the stock assembly. To remove, unlatch floor plate, lift folded end of spring upwards, pull back and disassemble from floor plate. Magazine follower and magazine spring are same as for Model 721-722 (per respective calibers).

See Model 721-722 Manual for necessary SERVICE instructions.

To Replace – Interchangeable with no factory adjustment required. Replacement as assembly if desired. The trigger guard assembly is factory-listed to include floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate latch pin, Trigger guard.

To Reassemble – Follow reverse order. Tighten guard screws firmly.

#### TRIGGER GUARD ASSEMBLY - COMPONENTS:

Remove trigger guard assembly. Remove magazine follower, magazine spring from floor plate.

#### **Floor Plate**

To Disassemble – Tap out and remove floor plate pivot pin from front of trigger guard. Disassemble floor plate from trigger quard.

Caution: Floor plate pivot pin is tight-fitting, therefore, support trigger guard properly to prevent damage to guard at front section.

To Reassemble – Follow reverse order. Make certain floor plate is free swinging and locks into floor plate latch properly.

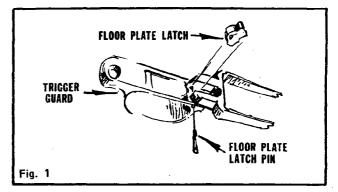
#### Floor Plate Latch Spring

**To Disassemble** – Remove triggerguard assembly from rifle. Unhook rear of floor plate latch spring from floor plate latch. Unhook front of latch spring from trigger guard. Disassemble loosened floor plate latch spring from trigger guard.

To Reassemble - Follow reverse order.

#### Floor Plate Latch

To Disassemble – Remove trigger guard assembly from rifle. Remove floor plate latch from trigger guard. Tap out floor plate latch pin, left to right. Disassemble floor plate latch pin, left to right. Disassemble floor plate latch from trigger plate (See Fig. 1).



To Reassemble - Follow reverse order.

### MODEL 725

1

#### TRIGGER GUARD

To Disassemble – Remove trigger guard assembly from rifle. Remove magazine follower and magazine spring from floor plate. Remove floor plate, floor plate latch spring, floor plate latch from trigger guard.

To Reassemble – Follow reverse order. Replace all assembly components to trigger guard before reassembly of trigger guard assembly to rifle.

#### MAGAZINE

Note: Magazine component, although slightly different in design from Model 721–722, assembles in the same manner. See Model 721–722 Manual for necessary SERVICE instructions.

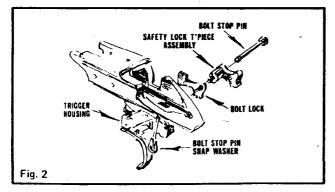
#### BOLT FINAL ASSEMBLY

Note: Bolt final assembly, although slightly different in design also from the Model 721–722, assembles in the same manner. See Model 721–722 Manual for necessarySERVICE instructions.

To Replace – Bolt assembly component of BOLT FINAL AS-SEMBLY includes bolt body assembly, bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor, firing pin assembly, and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is required.

#### BOLT STOP

To Disassemble – Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble bolt stop pin snap washer from left end of bolt stop pin. (See Fig. 2). Push left end of bolt stop pin across only enough to release bolt stop. Disassemble loosened bolt stop and bolt stop spring. Take care that small bolt stop spring is not lost.



To Reassemble - Follow reverse order.

SAFETY LOCK THUMBPIECE ASSEMBLY is designed to operate the "three" position safety. BOLT LOCK is designed to pivot upward and lock bolt closed when safety thumbpiece is pushed to the ON SAFE or "S" mark on the receiver. To Disassemble – Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Remove bolt stop. Push bolt stop pin completely across and disassemble pin and safety lock thumbpiece assembly from rifle. BOLT LOCK WILL ALSO be loosened at this time and can be disassembled from right side of trigger housing. (See Fig. 2).

Note: Trigger housing will be in "free pivot" on sear pin only when bolt stop pin is removed. Take care that sear spring, underlying sear and safety cam (also in free pivot), is not lost.

To Replace – Interchangeable with no factory adjustment required. Replace safety lock thumbpiece assembly as assembly unit.

To Reassemble – Follow reverse order. Assemble ratchet teeth in bolt lock and safety lock thumbpiece assembly to safety component properly before bolt stop pin is inserted. Check for proper operation of components to three (3) position stops on receiver.

SAFETY is designed to support safety cam of sear and safety cam assembly against "cocked" bolt. This is accomplished by operation of upthrust inner blade section when safety lock thumbpiece assembly is in ON SAFE position to rear of receiver.

To Disassemble – Remove bolt final assembly. Remove trigger guard assembly. Remove stock assembly. Slide off and disassemble safety snap washer. Pull off and disassemble safety pivot spring. Remove loosened safety detent ball. Push across and disassemble safety pivot pin. Pull out and disassemble safety from trigger housing.

Note: Bolt stop release on opposite side of housing will be free when safety pivot pin is removed.

To Reassemble – Follow reverse order. Ratchet teeth on safety should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumbpiece assembly for proper operation of three position safety stops.

#### TRIGGER ASSEMBLY

Note: Trigger assembly, although somewhat different in design from the Model 721–722, assembles in the same manner to the receiver. Sear pin and bolt stop pin mount the housing component of trigger assembly to receiver. See Model 721– 722 Manual for necessary SERVICE instructions to trigger and sear mechanisms.

To Replace – Trigger assembly may be replaced as an assembly with no factory adjustment required. Trigger assembly includes bolt stop release, housing, safety, safety detent ball, safety detent spring, safety pivot pin, safety snap washer, sear and safety cam assembly, sear spring, trigger, trigger adjusting screw (2), trigger connector, trigger pin, trigger spring, trigger stop screw. (See Fig. 2).

# CYCLE OF OPERATION

The action cycle of the Model 725 may start as magazine is loaded and a cartridge locked by bolt in chamber. The trigger is pulled to fire each cartridge and the bolt handle is raised to turn and pull bolt rearward. The return of bolt forward to reload next cartridge and the handle turned down to lock bolt against chambered cartridge, completes operation cycle.

Each cycle is summarized briefly, then in detail the movement of related parts is described more fully, For reason of a safe operation cycle, the Three position Safety Lock is explained to preface this Cycle.

#### SAFETY LOCK

Safe "S" (mark on receiver) – The rifle cannot be fired nor bolt handle raised to unlock bolt from barrel when safety lock thumbpiece is rotated fully rearward to the "S" mark on receiver. In detail, the thumbpiece locks a safety cam component of trigger assembly up and against "cocked" firing pin assembly to prevent its forward release. A bolt lock component is also rotated into a bottom channel in locked bolt. This bolt lock prevents bolt and bolt handle from turning to unlock.

Unlock position (no mark on receiver) – The rifle cannot be fired; however, bolt handle can be raised to unlock and withdraw bolt, when safety lock thumbpiece is rotated to a stop position between the Safe "S" and Fire "F" mark on receiver; In detail, the firing pin assembly continues to be held "cocked" by safety cam component. However, the bolt lock is rotated from engagement with bottom channel in bolt and the bolt handle can be raised to turn and withdraw bolt.

Fire "F" (mark on receiver) – The rifle can be fired or bolt handle raised to turn and unlock bolt when safety lock thumbpiece is rotated fully forward to "F" mark on receiver. In detail, the safety cam component within trigger assembly is no longer held against "cocked" firing pin assembly. The bolt lock, as in the Unlock Position, is rotated from engagement with bottom channel in bolt. The bolt is free to turn and unlock if handle is raised.

#### FIRING

(safety lock in "F" position) The firing cycle is simply the pull of trigger each time to release a spring-loaded or "cocked" firing pin to fire cartridge. In detail, this pull of trigger carries forward a connector component from beneath sear. This forward movement of connector leaves sear unsupported against "cocked" firing pin. With support removed, sear is cammed downward by the spring-urged firing pin. The mainspring then thrusts firing pin forward to strike cartridge.

Note: The design and movement of connector is to adjust for shortest possible pull of trigger with absolutely no over-travel.

#### UNLOCKING

The unlock cycle is the raising of bolt handle to disengage bolt from breech of barrel. In detail, this upward swing of bolt handle turns bolt to unseat locking lugs on head of bolt from recoil shoulders in receiver.

#### COCKING

The cocking cycle may be summarized as two movements: (1) The cocking of bolt which occurrs during unlocking cycle; and (2), The "cocking" of rifle which occurs during locking cycle. In detail, the first movement is the withdrawal and notching of firing pin against pressure of the tensed mainspring in bolt. The final movement is the holding or sustaining of the withdrawn or cocked pin until trigger is pulled.

The first or withdrawal movement is caused by turning of bolt as handle is raised. During the turning, a cam cut at rear of bolt forces firing pin assembly rearward, to locate in a notch on rear rim of bolt. The final or sustaining movement is simply the transfer of this "cocked" position of firing pin from bolt to sear in trigger assembly. This transfer to sear occurs as bolt handle is lowered in locking cycle.

The sear then holds firing pin or rifle "cocked" until trigger is pulled during firing cycle, or the bolt handle is raised to retransfer cocking of firing pin to bolt rim.

#### EXTRACTING

The extracting cycle consists of freeing of fired cartridge case (or live round) from cartridge chamber walls in barrel breech and pulling of case from chamber. In detail, as bolt handle is raised to unlock bolt, the final upturn motion engages a camming surface in receiver. This rearward camming motion of bolt will disengage fired case from tight contact with barrel chamber. Further rearward pull on bolt handle extracts fired case completely from chamber. During extraction cycle, fired case is gripped firmly to bolt face by an extractor component. This extractor is recessed within the rim on bolt head.

#### FEEDING

The feeding cycle is the lift and forward movement of the top most cartridge from magazine to barrel breech. In detail, as bolt clears the magazine opening, the top cartridge in magazine is pressed upwards by magazine spring and into feeding position. The return movement of bolt pushes against rear of cartridge. The bullet end of cartridge moves up bullet incline and the rear is leveled out free of feeding lip on receiver.

#### LOADING

The loading cycle is rather brief and comprises movement of free cartridge as it is pushed forward by bolt and loaded completely into barrel chamber.

#### LOCKING

The locking cycle occurs as the downward turn of bolt handle rotates bolt and locks it against chambered cartridge. In detail, four engagements are made by this locking cycle: (1) the two locking lugs on bolt head are firmly seated against recoil shoulders in receiver; (2) the base of loaded cartridge is recessed within bolt face, depressing ejector and flexing extractor to snap claw over base rim of cartridge; (3) the sear engages a camming surface to rear of firing pin, on firing pin head; and (4) the sear is supported from beneath by connector to hold firing pin back and rifle "cocked" until trigger is pulled.

# MALFUNCTIONS

### **Cause and Correction**

Note: For malfunctions not listed below, see Model 721-722 Manual.

SERVICE instructions for the Remington Model 725 and the Models 721 and 722 are very much alike in many respects (see M/721-722 Manual). Because of this design similarity only limited SERVICING is needed for the M/725: and other than damaged or missing components related to safety or hinged floor plate mechanisms, or stock, little, if any, servicing for the M/725 is necessary.

#### FLOOR PLATE MECHANISM

- 1. Floor Plate fails to lock bottom on stock. Service: Remove wood margin beneath floor plate.
- 2. Damaged or missing components. Service: Repair or replace floor plate, floor plate latch, floor plate latch spring.

#### SAFETY MECHANISM

 Damaged or missing components. Service: Repair or replace safety lock thumbpiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball, safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety cam assembly.

#### STOCK ASSEMBLY

- 1. Fails to target properly. Service: a. Adjust or a
  - a. Adjust or replace sights.
    - b. Check barrel bedding. Barrel should be free floating along receiver sides and along barrel length. Should seat evenly in barrel radius cut and have firm contact only at end of stock.
    - c. Replace stock, if damaged.

### REMINGTON FIELD SERVICE MANUAL

The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is similiar to the Models 721-722 or other bolt action repeating rifles. Therefore the **ASSEMBLY** and **SERVICING** instructions for the Model 725 will list only those parts of unlike design and operation. Unless otherwise described, all parts are interchangeable with no factory assembly or adjustment required.



Included will be the hinged floor plate for loading or unloading with the bolt closed, and the three (3) position safety switch lock. Additional instructions will cover stock swivels, grip cap and front sight components.

The Instruction Folder, RD 5359, is packaged with each new rifle shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instruction and instructions for care and maintenance of the rifle.

When handling the rifle for servicing or shipping make certain the rifle is empty with no rounds in the magazine or barrel chamber.

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Frigger Guard
Magazine
Bolt Final Assembly
Frigger Assembly
Cycle of Operation
Malfunctions

Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

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#### FRONT SIGHT COVER

To Disassemble – Spread Cover slightly and push forward in cover slots on either side of ramp. Disassemble from rifle.

To Reassemble – Spread slightly and slide along side slots and over front sight blade. Assemble in central location, straight end of cover to rear.

#### FRONT SIGHT BLADE

To Disassemble – Remove front sight cover. Support front ramp to prevent damage to barrel and drive out front sight pin. Pull out and disassemble front sight blade from the rifle.

To Reassemble – Support barrel to prevent damage and insert blade in slot in front sight ramp. Align holes and tap in front sight pin.

#### REAR SIGHT ASSEMBLY

To Disassemble – Unscrew rear sight screw and disassemble from rifle. Pull up and disassemble rear sight assembly from barrel. Remove loosened rear sight step.

To Replace – Interchangeable with no factory adjustment required. Replacement as assembly recommended. Rear sight assembly is factor y – listed to include: rear sight eyepiece, rear sight collar, rear sight leaf, rear sight windage screw. Special factory processes assemble the part.

To Reassemble – Assemble rear sight assembly in place with bottom ears of the sight aligned properly to rear sight base. Assemble rear sight screw and turn until tight. Lift rear sight eyepiece and assemble rear sight step beneath eyepiece.

#### REAR SIGHT STEP

To Disassemble – Lift or raise rear sight assembly by the eyepiece and slide rear sight step to the rear. Disassemble from barrel.

To Replace – Interchangeable with no factory adjustment required. Additional sight steps, marked for size, and available for range purpose.

To Reassemble – Lift eyepiece and slide rear sight step in place.

#### REAR SIGHT BASE

To Disassemble – Remove rear sight assembly and rear sight step. Unscrew and disassemble rear sight base screw (2). Disassemble rear sight base and rear sight washers (2) from barrel.

To Reassemble – Align to barrel screw holes, insert rear sight base screw (2) and rear sight washers (2), and turn screws to tighten base securely to barrel.

BARREL ASSEMBLY is designed as a rigid factory-assembled group with Receiver. BARREL BRACKET as a factoryassembled component of barrel assembly is designed to vertical recoil shoulder to transfer the back-thrust of the firing recoil against stock, FRONT SIGHT RAMP as another component of barrel assembly is factory-brazed to barrel and designed to establish the sight line and mount front sight blade.

Note: The barrel assembly, although somewhat different in design from the Model 721-722, mounts to other parts of the rifle in the same manner. See Model 721–722 Manual for necessary SERVICE instructions.

To Replace – Replacement as an assembly is recommended. However, the rifle must be returned to the factory for selective assembly. Return of rifle to factory for replacement of any components is also recommended (of barrel assembly).

#### STOCK ASSEMBLY

To Disassemble – Unscrew and disassemble front and rear trigger screws. Pull loosened stock assembly (and trigger guard assembly) from rifle.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock assembly is factory-listed to include: stock, butt plate, butt plate screw (2), grip cap, grip cap screw, stock swivel front assembly, stock swivel rear assembly, stock swivel nut, stock swivel screw bushing-front, and stock reinforcing screw.

To Reassemble – Mount trigger guard assembly to stock assembly, then assemble over trigger assembly and magazine. Hold firmly to receiver and assemble guard screws. Turn both guard screws evenly until tight.

#### STOCK SWIVEL FRONT ASSEMBLY

To Disassemble – Unscrew and disassemble stock swivel front assembly from stock.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended, Stock swivel front assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw-front.

To Reassemble – Assemble through stock swivel screw bushing-front, and thread into stock swivel nut. Turn until tight and adjust crosswise to stock.

#### STOCK SWIVEL REAR ASSEMBLY

**To Disassemble** – Unscrew and disassemble stock swivel rear assembly from stock.

To Replace – Interchangeable with no factory adjustment required. Replacement as an assembly recommended. Stock swivel rear assembly is factory-listed to include stock swivel, stock swivel pin, stock swivel screw-rear.

To Reassemble – Turn and thread into stock until tight. Adjust crosswise to stock.

#### STOCK SWIVEL NUT

To Disassemble – Remove stock assembly from rifle. Unscrew stock swivel front assembly partway from stock. Tap against stock swivel assembly until stock swivel nut pushes upward---- (take care to avoid damage to stock.) from barrel radius in

stock. Remove stock swivel front assembly and thread to barrel side of nut. Pull out and disassemble stock swivel nut from stock. Remove stock swivel from assembly from stock swivel nut.

To Reassemble – Reseat stock swivel nut to barrel radius cut in stock. Note taper angle on knurled outside of stock swivel nut. Locate small diameter of taper inward to stock when reassembling to stock. Tap nut gently into place, then rethread stock swivel front assembly from bottom face of stock. Turn swivel until stock swivel nut drawn downward and firmly into stock.

#### STOCK SWIVEL SCREW BUSHING FRONT

To Disassemble – Remove stock from rifle. Remove stock swivel front assembly. Remove stock swivel nut. Apply close fitting tool against bushing from barrel radius cut in stock. Tap against inner end of bushing until this stock swivel bushing, front can be disassembled from bottom face of stock. Avoid damage to stock.

To Reassemble – Locate properly to bottom face of stock and tap gently into stock until firmly in place.

#### BUTT PLATE

To Disassemble – Unscrew butt plate screw (2), Disassemble butt plate from end of stock.

To Replace – Interchangeable with no factory adjustment required. However, replacement part may need additional "surfacing" to end of stock wood, or edge of butt plate for proper match of butt plate to stock.

To Reassemble – Assemble butt plate to end of stock, align screw holes, assemble butt plate screw (2), and turn until butt plate is tight.

#### GRIP CAP

To Disassemble – Unscrew and remove grip cap screw. Disassemble loosened grip cap from stock.

To Replace – Interchangeable with no factory adjustment required. Additional "surfacing" of stock or edge of cap needed for proper matching effect.

To Reassemble – Locate and align grip cap to stock. Insert grip cap screw and tighten firmly until grip cap is assembled to stock.

TRIGGER GUARD ASSEMBLY of hinged design, permits loading or unloading of the fixed magazine box with a "closed" bolt.

To Disassemble – Remove bolt assembly. Unscrew and pull out guard screw, front and rear. Lift loosened stock assembly from trigger. Pull out and disassemble trigger guard from rifle.

Note: Magazine follower and magazine spring (assembled to floor plate) will also be removed from the stock assembly. To remove, unlatch floor plate, lift folded end of spring upwards, pull back and disassemble from floor plate. Magazine follower and magazine spring are same as for Model 721-722 (per respective calibers).

See Model 721–722 Manual for necessary SERVICE instructions.

To Replace – Interchangeable with no factory adjustment required. Replacement as assembly if desired. The trigger guard assembly is factory-listed to include floor plate, floor plate latch, floor plate latch pin, floor plate latch spring, floor plate latch pin, Trigger guard.

To Reassemble - Follow reverse order. Tighten guard screws firmly.

TRIGGER GUARD ASSEMBLY - COMPONENTS:

Remove trigger guard assembly. Remove magazine follower, magazine spring from floor plate.

Floor Plate

To Disassemble – Tap out and remove floor plate pivot pin from front of trigger guard. Disassemble floor plate from trigger guard.

Caution: Floor plate pivot pin is tight-fitting, therefore, support trigger guard properly to prevent damage to guard at front section.

To Reassemble – Follow reverse order. Make certain floor plate is free swinging and locks into floor plate latch properly.

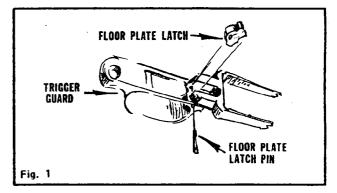
Floor Plate Latch Spring

To Disassemble – Remove triggerguard assembly from rifle. Unhook rear of floor plate latch spring from floor plate latch. Unhook front of latch spring from trigger guard. Disassemble loosened floor plate latch spring from trigger guard.

To Reassemble - Follow reverse order.

Floor Plate Latch

To Disassemble — Remove trigger guard assembly from rifle. Remove floor plate latch from trigger guard. Tap out floor plate latch pin, left to right. Disassemble floor plate latch pin, left to right. Disassemble floor plate latch from trigger plate (See Fig. 1).



To Reassemble – Follow reverse order.

### MODEL 725

#### TRIGGER GUARD

To Disassemble – Remove trigger guard assembly from rifle. Remove magazine follower and magazine spring from floor plate. Remove floor plate, floor plate latch spring, floor plate latch from trigger guard.

To Reassemble – Follow reverse order. Replace all assembly components to trigger guard before reassembly of trigger guard assembly to rifle.

#### MAGAZINE

Note: Magazine component, although slightly different in design from Model 721–722, assembles in the same manner. See Model 721–722 Manual for necessary SERVICE instructions.

#### BOLT FINAL ASSEMBLY

Note: Bolt final assembly, although slightly different in design also from the Model 721–722, assembles in the same manner. See Model 721–722 Manual for necessarySERVICE instructions.

To Replace – Bolt assembly component of BOLT FINAL AS-SEMBLY includes bolt body assembly, bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor, firing pin assembly, and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is required.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

### CYCLE OF OPERATION

The action cycle of the Model 725 may start as magazine is loaded and a cartridge locked by bolt in chamber. The trigger is pulled to fire each cartridge and the bolt handle is raised to turn and pull bolt rearward. The return of bolt forward to reload next cartridge and the handle turned down to lock bolt against chambered cartridge, completes operation cycle.

Each cycle is summarized briefly, then in detail the movement of related parts is described more fully, For reason of a safe operation cycle, the Three position Safety Switch Lock is explained to preface this Cycle.

#### SAFETY SWITCH LOCK

Safe "S" (mark on receiver) – The rifle cannot be fired nor bolt handle raised to unlock bolt from barrel when safety switch lock thumbpiece is rotated fully rearward to the "S" mark on receiver. In detail, the thumbpiece locks a safety cam component of trigger assembly up and against "cocked" firing pin assembly to prevent its forward release. A bolt lock component is also rotated into a bottom channel in locked bolt. This bolt lock prevents bolt and bolt handle from turning to unlock.

Unlock position (no mark on receiver) - The rifle cannot be fired; however, bolt handle can be raised to unlock and withdraw bolt, when safety switch lock thumbpiece is rotated to a stop position between the Safe "S" and Fire "F" mark on receiver; In detail, the firing pin assembly continued to be held "cocked" by safety cam component. However, the bolt lock is rotated from engagement with bottom channel in bolt and the bolt handle can be raised to turn and withdraw bolt.

Fire "F" (mark on receiver) – The rifle can be fired or bolt handle raised to turn and unlock bolt when safety switch lock thumbpiece is rotated fully forward to "F" mark on receiver. In detail, the safety cam component within trigger assembly is no longer held against "cocked" firing pin assembly. The bolt lock, as in the Unlock Position, is rotated from engagement with bottom channel in bolt. The bolt is free to turn and unlock if handle is raised.

#### FIRING (safety switch lock in "F" position)

The firing cycle is simply the pull of trigger each time to release a springloaded or "cocked" firing pin to fire cartridge. In detail, this pull of trigger carries forward a connector component from beneath sear. This forward movement of connector leaves sear unsupported against "cocked" firing pin. With support removed, sear is cammed downward by the springurged firing pin. The mainspring then thrusts firing pin forward to strike cartridge.

Note: The design and movement of connector is to adjust for shortest possible pull of trigger with absolutely no over-travel.

#### UNLOCKING

The unlock cycle is the raising of bolt handle to disengage bolt from breech of barrel. In detail, this upward swing of bolt handle turns bolt to unseat locking lugs on head of bolt from recoil shoulders in receiver.

#### COCKING

The cocking cycle may be summarized as two movements: (1) The cocking of bolt which occurs during unlocking cycle; and (2), The "cocking" of rifle which occurs during locking cycle. In detail, the first movement is the withdrawal and notching of firing pin against pressure of the tensed mainspring in bolt. The final movement is the holding or sustaining of the withdrawn or cocked pin until trigger is pulled. The first or withdrawal movement is caused by turning of bolt as handle is raised. During the turning, a cam cut at rear of bolt forces firing pin assembly rearward, to locate in a notch on rear rim of bolt. The final or sustaining movement is simply the transfer of this "cocked" position of firing pin from bolt to sear in trigger assembly. This transfer to sear occurs as bolt handle is lowered in locking cycle.

The sear then holds firing pin or rifle "cocked" until trigger is pulled during firing cycle, or the bolt handle is raised to retransfer cocking of firing pin to bolt rim.

#### EXTRACTING

The extracting cycle consists of freeing of fired cartridge case (or live round) from cartridge chamber walls in barrel breech and pulling of case from chamber, In detail, as bolt handle is raised to unlock bolt, the final upturn motion engages a camming surface in receiver. This rearward camming motion of bolt will disengage fired case from tight contact with barrel chamber. Further rearward pull on bolt handle extracts fired case completely from chamber. During extraction cycle, fired case is gripped firmly to bolt face by an extractor component. This extractor is recessed within the rim on bolt head.

#### FEEDING

The feeding cycle is the lift and forward movement of the top most cartridge from magazine to barrel breech. In detail, as bolt clears the magazine opening, the top cartridge in magazine is pressed upwards by magazine spring and into feeding position. The return movement of bolt pushes against rear of cartridge. The bullet end of cartridge moves up bullet incline and the rear is leveled out free of feeding lip on receiver.

#### LOADING

The loading cycle is rather brief and comprises movement of free cartridge as it is pushed forward by bolt and loaded completely into barrel chamber.

#### LOCKING

The locking cycle occurs as the downward turn of bolt handle rotates bolt and locks it against chambered cartridge. In detail, four engagements are made by this locking cycle: (1) the two locking lugs on bolt head are firmly seated against recoil shoulders in receiver; (2) the base of loaded cartridge is recessed within bolt face, depressing ejector and flexing extractor to snap claw over base rim of cartridge; (3) the sear engages a camming surface to rear of firing pin, on firing pin head; and (4) the sear is supported from beneath by connector to hold firing pin back and rifle "cocked" until trigger is pulled.

# MALFUNCTIONS

### Cause and Correction.

Note: For malfunctions not listed below, see Model 721-722 Manual.

SERVICE instructions for the Remington Model 725 and the Models 721 and 722 are very much alike in many respects (see M/721–722 Manual). Because of this design similarity only limited SERVICING is needed for the M/725: and other than damaged or missing components related to safety or hinged floor plate mechanisms, or stock, little, if any, servicing for the M/725 is necessary.

#### FLOOR PLATE MECHANISM

- 1. Floor Plate fails to lock bottom on stock. Service: Remove wood margin beneath floor plate.
- 2. Damaged or missing components. Service: Repair or replace floor plate, floor plate latch, floor plate latch spring.

#### SAFETY SWITCH MECHANISM

1. Damaged or missing components. Service: Return the firearm to the factory.

#### STOCK ASSEMBLY

- 1. Fails to target properly.
  - Service: a. Adjust or replace sights.
    - b. Check barrel bedding. Barrel should be free floating along receiver sides and along barrel length. Should seat evenly in barrel radius cut and have firm contact only at end of stock.
    - c. Replace stock, if damaged.

Rev. 382

AACHMENT "K"

MODEL 788

### REMINGTON FIELD SERVICE MANUAL

The Remington Model 788 is a center fire bolt action repeating rifle, chambered for varmint as well as big game calibers. Open front and rear factory sights are attached to barrel with sight screws. The receiver is drilled and tapped for additional sights or mounts at both top and fear side.

A detachable box magazine with 3 cartridge capacity (4 in 222 Rem.) is featured for this rifle. Extra magazines are available for fast reloading.

The Instruction Folder RD-5558 is packaged with each new rifle shipped from factory. Folders may also be obtained from dealer or by writing to the ARMS SERVICE DIVISION at Ilion, N. Y. This folder outlines the operating instructions and service or replacement part directions.

When handling rifle for servicing or shipping, make certain rifle is empty with no cartridges in magazine or barrel.

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Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Illion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602 Page

### MODEL 788

MAGAZINE ASSEMBLY - includes magazine, magazine release, magazine release button, magazine follower, magazine spring.

To Disassemble — Remove from rifle as an assembly by pressing magazine release button.  $\frac{1}{2}$ 

To Reassamble — Slide magazine into rifle along magazine guide bar until magazine clicks into locked position.

To Replace - Extra or replacement magazines are listed as a complete unit. Caliber maritings are on side of magazine.

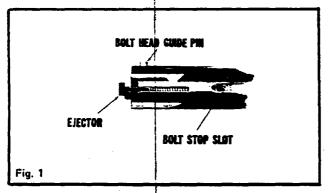
BOLT FINAL ASSEMBLY  $\frac{1}{2}$  is designed to include locking, firing, extracting, and cocking parts of the action and to close action against a chambered cartridge.

To Disassemble – Raise bolt handle and pull bolt rearward until halted by bolt stop. This opens action. Press safety switch forward beyond FIRE position and pull bolt from rifle.

To Reassemble — Two (2) types of bolt assemblies are designed for the M/788:  $\frac{1}{2}$ 

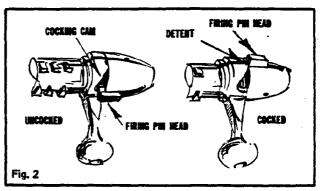
- Straight ling, two piece (rotating head) bolt used with rimmed caliber cartridges (30-30 and 44 Rem. Mag.).
- One piece bolt used with rimless caliber cartridges (222 Rem.and 22/250 Rem. 6mm.308, 243 Win.).

To reassemble straight line, two piece bolt assembly, align ejector (on bolt head) with bolt stop slot on bolt body (See Fig. 1). With bolt head guide pin in 9 o'clock position push bolt forward into receiver. For one piece bolt assembly, simply place bolt handle in 2 o'clock position and push into receiver.



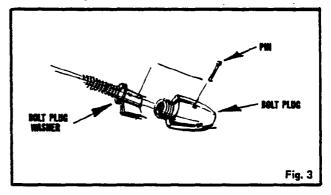
NOTE: Bolt must remain cocked to assemble into rifle. If bolt uncocks, firing pin head will snap forward into cocking cam in rear of bolt. To cock bolt hold firing pin head firmly to prevent movement. Use vise jaws if available. Raise bolt handle. Bolt will cam cocking surface (beneath handle) against firing pin head. Continue raising handle until cocking detent (See Fig. 2) on rear of bolt engages firing pin head. Bolt is then cocked and may be put into fifle.

BOLT FINAL ASSEMBLY + COMPONENTS (with bolt removed from rifle) - is factory listed to include bolt assembly, bolt assembly pin (2), bolt head assembly (rim cartridge type), bolt plug, firing pin assembly, ejector, ejector spring, ejector pin, extractor.



BOLT PLUG and FIRING PIN ASSEMBLY — includes bolt plug washer, firing pin, firing pin cross pin, firing pin head, mainspring.

To Disassemble — With bolt in cocked position, turn bolt plug out of cocking notch and turn further along perimeter of bolt. Insert small close fitting pin through small hole in bolt plug and through aligned hole in firing pin head. This small pin will hold firing pin head retracted into bolt plug.Bolt plug can then be unscrewed until firing pin assembly (and bolt plug) can be disassembled from bolt assembly. Press bolt plug to bolt plug washer against tension of mainspring. This will relieve tension on small pin. Pull out and remove small pin. Disassemble bolt plug from firing pin assembly. (See Fig. 3).



To Reassemble — Position bolt plug to firing pin head of firing pin assembly. Push bolt plug against bolt plug washer (under tension) to align small pin hole in bolt plug to firing pin head. Insert small pin through aligned holes and release bolt plug. Assemble combined bolt plug and firing pin assembly to bolt assembly and screw into bolt until firing pin head is aligned to cocking notch. (See Fig. 2). Release small pin to allow firing pin head to locate into cocking notch on bolt perimeter.

#### FIRING PIN ASSEMBLY - COMPONENTS

NOTE: Remove firing pin assembly from bolt and bolt plug. See FIRING PIN ASSEMBLY to disassemble.

**FIRING PIN** — not recommended for part replacement. Order as firing pin assembly for proper caliber replacement.

MAINSPRING - FIRING PIN HEAD - BOLT PLUG. WASHER.

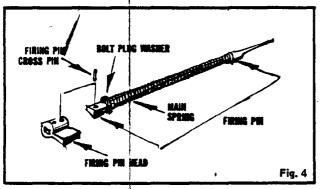
To Disassemble — Drive out firing pin cross pin. Caution: Mainspring is assembled under tension against bolt plug washer

1

-Use care. Disassemble firing pin head, bolt plug washer, and mainspring from firing pin.

NOTE: Mainspring, firing pin head, or bolt plug washer may be replaced to existing firing pin.

To Reassemble – Follow reverse order. Place firing pin head under tension of reassembled mainspring and bolt plug washer to align firing pin cross pin hole in both firing pin and firing pin head. Insert firing pin cross pin. (See Fig. 4).



BOLT ASSEMBLY – all bolts are marked with serial number of rifle. Selective assembly at factory is required to insure proper assembly to rifle.

EJECTOR - EJECTOR SPRING (rimless cartridge calibers)

To Disassemble – Drive out ejector pin. Disassemble ejector and ejector spring from face of bolt.

To Reassemble – Follow reverse order. Align ejector pin slot in assembled ejector to ejector pin hole in bolt. Drive ejector pin flush to bolt. Ejector must have free plunging motion in bolt.

EXTRACTOR - EXTRACTOR RIVET (rimless cartridge calibers)

To Disassemble – Remove ejector. Drive out extractor rivet..... from outside of bolt. Rémove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from bolt face.

To Reassemble – Use replacement rivet to secure extractor properly. Check tension of assembled extractor using fired case.

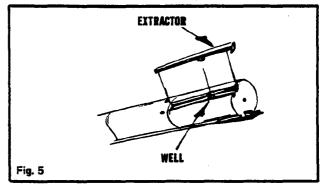
EJECTOR - EJECTOR SPRING (rim cartridge calibers)

To Disassemble – Drive but ejector pin (small open roll pin). Disassemble ejector and ejector spring from bolt face.

To Reassemble – Follow reverse order. Replacement ejector pin may be required to properly and securely reassemble ejector. Ejector must have a free plunging motion to function correctly in bolt.

EXTRACTOR (rim cartifidge calibers)

To Disassemble – Grasp claw of extractor and lift up carefully to free stud from locating well in bolt. Pull extractor forward to disassemble from bolt. To Reassemble – Align ejector to long bolt stop channel in bottom of bolt. Assemble extractor to bolt. Push extractor rearward in slot to allow tail of extractor to settle under bolt body (between two bolt head pins). Stud at mid-body of extractor should seat into well in slot. Flex extractor claw in and out to assure proper assembly motion. (See Fig. 5).



BOLT HEAD ASSEMBLY (rim cartridge calibers) – selective factory assembly of this type bolt head is required to insure proper function of rifle.

FRONT SIGHT - FRONT SIGHT WASHER - FRONT SIGHT SCREW

To Disassemble – Unscrew front sight screw. Lift off and disassemble front sight and front sight washer from barrel.

To Reassemble - Follow reverse order.

REAR SIGHT RIB-REAR SIGHT RIB SPACER-REAR SIGHT ASSEMBLY-REAR SIGHT SCREW (2) -

To Disassemble – Unscrew rear sight screw (2) and disassemble rear sight assembly from rear sight rib. Rear sight rib and rear sight rib spacer will also be loosened and can be disassembled from barrel.

To Reassemble - Locate rear sight assembly to aligned rear sight rib and rear sight rib spacer.

**NOTE:** Rear sight rib spacer must be located with bottom taper to matching barrel taper. Insert rear sight screw (2) and tighten rear sight assembly to barrel.

**REAR SIGHT ASSEMBLY – COMPONENTS –** Includes elevation screw, rear sight base, rear sight eyepiece, rear sight leaf, windage screw.

To Disassemble – Unscrew elevation screw and lift rear sight eyepiece to disassemble from rear sight leaf. Unscrew windage screw and slide rear sight leaf from rear sight base. Rear sight base may be disassembled by unscrewing both rear sight base screws, if needed. See REAR SIGHT ASSEMBLY.

To Reassemble - Follow reverse order

2

#### MODEL 788

STOCK ASSEMBLY - includes stock, butt plate, butt plate screw (2).

### FRONT GUARD SCREW-REAR GUARD SCREW-

To Disassemble – Remove box magazine. Unscrew front and rear guard screws. Stock assembly may then be disassembled from rifle.

NOTE: Trigger guard will be loosened as rear guard screw is removed.

To Reassemble – Assemble stock assembly to rifle making sure stock is guided carefully over magazine guide bar. Receiver of rifle should position and align correctly to stock. Turn both front and rear guard screws to tighten stock assembly and trigger guard to rifle.

#### FLOOR PLATE-FLOOR PLATE SCREW-

To Disassemble – Unscrew and remove screw and plate from stock.

To Reassemble - Follow reverse order.

MAGAZINE GUIDE BAR-MAGAZINE GUIDE BAR SCREW-

To Disassemble - Unscrew and remove from receiver.

To Reassemble - Follow reverse order.

TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

BARREL ASSEMBLY - Factory listed to include barrel, barrel bracket, receiver assembly. Special factory processes join the components of this assembly. Selective factory assembly is required for replacement of parts and to insure proper operation with bolt final assembly. Disassembly is not recommended. Replace as an assembly.

# CYCLE OF OPERATION

The Model 788 is a bolt action repeater with detachable box magazine. The operations cycle of this rifle follows the basic pattern of bolt action rifles. After firing, raising of bolt handle to unlock, then pulling bolt back will open action. Pushing bolt handle forward and down will close action and lock to complete the cycle. Each operation will be described in sequence and parts related to each are as follows:

#### FIRING

With safety switch in forward stop or FIRE position, rifle can be fired by pulling trigger. Pulling trigger will release a long spring-loaded firing pin. This pin, powered by a mainspring, thrusts forward to strike and fire the chambered cartridge. As trigger is pulled, support of trigger under sear is removed. With support removed, cocked engagement of sear against firing pin head is released. Sear is forced downward by forward movement of firing pin to fire cartridge. Re-engagement of sear to cock rifle occurs again only during locking cycle.

#### UNLOCKING

After firing, raising of bolt handle will unlock action. As bolt handle is raised, bolt is turned. This rotates multiple bolt lugs clear of rear lock-up against recoil lugs in receiver. A total bolt lift of approximately 68 degrees completes this cycle. Primary extraction and cocking of bolt also occurs during unlocking cycle. After unlocking, bolt can be pulled back to open action.

#### COCKING

During unlocking cycle as bolt handle is raised, bolt is cocked. When bolt rotates to unlock, a cam cut on rear of bolt forces firing pin back until firing pin head engages cocking notch on rear rim of bolt. This engagement holds until bolt handle is lowered again during locking cycle. Engagement is then transferred to sear to cock rifle.

**NOTE:** Bolt may be uncocked when removed from rifle. Turn bolt handle to disengage firing pin head from cocking notch on rim of bolt. Firing pin will then release forward to uncock bolt. To re-cock bolt; hold bolt plug and firing pin head from turning....then turn bolt handle until firing pin head re-enters cocking notch on bolt.

#### EXTRACTION

After firing cartridge, raising bolt handle and pulling bolt backward will extract fired cartridge case from cartridge chamber in barrel. Primary extraction occurs as the final lift of bolt handle cams bolt approximately 1/8" back from barrel. This movement unlocks bolt lugs from recoil lugs in receiver. Bolt can then be pulled backward to complete extraction cycle. During extraction cycle, extractor grips extractor groove on base of cartridge case and holds cartridge firmly against face of bolt. This extractor, under spring tension, slips into cartridge groove during locking cycle. Type of extractor variest with cartridge caliber. For rimless cartridge such as 222 Rent. and 22-250 Rem., a spring clip type extractor is assembled inside rim in bolt face. With rimmed cartridge such as 30-30 and 44 Rem., Mag., a straight hook type overhangs bolt face. The ejector is depressed flush to bolt face until ejection cycle occurs.

NOTE: Extraction functions with bolt fired or unfired cartridge.

#### EJECTION

As bolt is pulled back, the extraction cycle terminates. The cartridge case then clears the chamber and is ejected from ejection port of receiver. A spring powered ejector exerts constant pressure against base of cartridge. As cartridge clears chamber, this pressure is released, and cartridge case, guided by opposing rip of extractor, is ejected from rifle. Live cartridge will also follow same ejection cycle.

NOTE: Rimless cartridge rifles (222 and 22-250) have the spring loaded plunger type. For rimmed cartridge rifles (30-30 and 44) a spring loaded ber ejector is used.,

#### FEEDING

As ejection cycle is completed, bolt clears magazine and is halted by bolt stop. Next cartridge then is urged upwards by magazine spring and held in loading position by feeding lips of box magazine. This top cartridge is then carried forward by bolt and into loading cydle.

NOTE: Box magazine may be detached from rifle by pressing forward on magazine release. Reload magazine and insert back in rifle for feeding cycles.

#### LOADING

The bolt, in closing the action, pushes top cartridge from box magazine into barrel. The feeding lips on sides of magazine guide cartridge during load cycle until bullet end of cartridge enters cartridge chamber of barrel.

#### LOCKING

As boit completes load cycle, boit handle can be turned down to lock action closed. With bolt handle down, cartridge is securely locked into cantridge chamber of barrel. Three (3) other bolt engagements are made as lock cycle is completed. viz:

- 1. Multiple locking lugs on bolt are now securely supported against matching recoil lugs in rear of receiver.
- 2. Bolt face is seated against chambered cartridge with ejector depressed under tension and extractor snapped into extractor groove on base of cartridge.
- 3. Cocking engagement of firing pin head on rear rim of bolt is transferred to a sear engagement. Rifle is thus "cocked" for firing cartridge. Trigger can be pulled for firing cycle with safety pushed forward to FIRE position.

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#### SAFETY SWITCH

The thumb-operated safety switch, located at rear right of receiver has three (3) functions:

- 1. In rear stop SAFE position safety switch blocks sear. This prevents movements of sear to fire rifle.
- 2 In forward stop FIRE position, safety switch clears sear (which permits trigger to be pulled for firing rifle).
- 3. Further pressure of safety switch in forward position depresses bolt stop. This allows bolt to be removed from rifle.

top of tang of receiver adjacent to safety switch.

# MALFUNCTIONS

### **Cause and Correction**

#### OVER RIDE

Cause: 1. Magazine follower binds.

- 2. Damaged follower spring.
- 3. Magazine spring caught.
- 4. Follower bent.
- 5. Jumps magazine or follower falls out.
- **Correction:** 1. Adjust side angle on magazine box.
  - 2. Change spring.
  - 3. Correct.
  - 4. Straighten or replace follower.
  - 5. Magazine apart at rear-replace.

#### STEMS CHAMBER

Cause: 1

- 2. Rough ramp in receiver.
- 3. Magazine box loose or out of position.
- Magazine spring catches front corner, Box 4. 30-30 Cal.
- Front of magazine box tips down. 5.

Sharp edge-rear end of chamber.

- 6. Magazine removes hard.
- Correction: **Remove sharpness.** 1.
  - 2. Polish ramp.
    - Adjust. 3.
    - Clip corners of spring. 4.
    - 5. Adjust or replace magazine guide bar.
  - Relieve wood where binding. Line up mag-6. azine guide bar.

#### **BOLT CLOSES HARD OVER SHELLS**

Cause:

- Bolt interferes with shell rim. 1.
  - Extractor interferes with shell rim. 2.
  - 3. Ejector binds or fails to retract far enough. Burr at ejector hole on bolt. 4.
  - 5.
  - Sharp corners on bolt lugs.

### MODEL 788

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Correction:	1. 2.		nterference or change bolt. xtractor (grind relief in new ex-	BOLT OPEN	S HA	ARD
			hind claw).	Cause:	1.	See "Fails to Extract".
	3.	Free up o	r replace.		2.	Upset extraction cam on bolt handle.
	4.	Deburr.			3.	• • • • • • • • • • • • • • •
	5.	File radiu	! <b>3.</b>		4.	Blow or set back primer on shell.
	-		i i i i i i i i i i i i i i i i i i i		5.	Cocking piece binds in bolt plug.
FAILS TO E	XTR	ACT			6.	•
			4		7.	Firing pin binds in bolt.
Cause:	1.	Extractor	broken or damaged.		••	
	2.		sh hook space on extractor.	Correction:	1.	See "Fails to Extract".
	3.		claw not correct.		2.	Smooth up.
	4.	-	catches on rim of shell, extract-		3.	Deburr.
		ing 30-30			4.	Ream chamber if throat is shallow
					ч.	ammunition may be at fault.)
Correction:	1.	Fit new e	tractor.		5.	Free up or replace.
	2.	Fit new e			6.	Smooth up.
		Fit new e			7.	Replace firing pin.
	-		htly more clearance on fingernail			napiece ming pm.
		cut or rep		BOLT PULL	s ou	т
FAILS TO E				•		
FAILS TO E			· .	Cause:	1.	Bolt stop binds.
Cause:	1.	Burn at al	j Aseas bala in bala		2.	Bolt stop broken.
Cause:	• •	•	ector hole in bolt. inds or fails to retract far enough.		3.	Bolt stop slot in bolt upset.
	2. 3.	•	gh hook space 30-30, 44 Cal.			
			n nook space 30-30, 44 Car. nextractor broken, 30-30, 44 Cal.	Correction:	1.	Return firearm to the factory.
	4.	Elector of	textractor broken, 50-50, 44 Cal.		2.	Return firearm to the factory.
Correction:		Deburr.			3.	Return firearm to the factory.
Correction:	1.					
	2.	Free up o	• •			
	3.		rim or shell with extractor push-			
	4.	ed back in Replace.		SAFETY SW	/ TC	H WORKS TOO HARD OR TOO FREELY
			ł	-		
MISFIRES				Cause:	1.	
					2.	Plunger spring weak or missing (safety
Cause:	1.		njg pin. (Damaged)			switch works too freely).
	2.	÷ ·	iębinds. (Damaged)			
	3.		ng pin protrusion.	Correction:	1.	Return firearm to the factory.
	4.		ntrol out of adjustment.		2.	Return firearm to the factory.
	5.		timunition.			
	6.	Sear bind	Ś	FIRES ON	SAF	E OR SAFETY SWITCH WON'T GO ON
Correction:	1.	Replace.		Cause:	1.	Safety switch plunger missing.
		Free up o	replace.		2.	
			ning pin or bolt.			
	4.	-	rearm to the factory.	Correction:	1.	Return firearm to the factory.
	5.		inmunition.		2.	-
	6.		merm to the factory.			
	•••					
FOLLOWS D	OWN	ł		BULGES OF		JH3 CASES
_		_	1	Cause:	1.	Oversize chamber.
Cause:	1.		er engagement of sear.			Max, head space.
	2.		es not retract.			
	3.	Corners o	a sear of trigger rounded.	Correction:	1.	Replace barrel assembly.
		1			2.	
Correction:	1.		rearm to the factory.			
	2		rearm to the factory.			
	3.	Return fi	rearm to the factory.			

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#### BOLT BINDS

#### Cause:

- 1. Scope screws protrude into bolt track.
- 2. Bolt handle interference on stock.
- 3. Bolt head retaining pins protruding.
- Bolt head catches on rim of shell in mag-azine when extracting 30-30, 44 Cal. 4.

Correction: File ends of screws. 1.

- Correct stock or fit new stock. 2.
- Seat pins; stone slightly more. 3.
- 4. Stone slightly more clearance at fingernail cut or replace bolt.

#### FAILS TO GROUP

Cause:

- Bore damaged at crown. 1.
- Leading of bore. 2.
- Oversize bore. 3.
- 4. Improper bedding of barrel in stock.
- 5. Loose sights or scope mount.
- 6. Front stock screw bottoms in receiver.

Correction: 1.

- Recrown. 2. Lead or change barrel.
- З. Replace barrel.
- Correct bedding. 4.
- 5. Tighten or replace.
- 6. Shorten screw.

#### POINT OF IMPACT NOT CORRECT

- 1. Barrelinot straight. Cause:
  - 2.
  - Horns breaks, etc., in bore. З.
  - Improper or loose sights.

Correction:

- 1. Straighten, if possible, or replace. 2. Straighten, if possible, or replace.
- 3. Tighten or change sights.

NOTE: When loading 44 Rem. Mag. cartridges, make sure that rim of each cartridge remains forward of rim of each underlying cartridge.

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# REMINGTON FIELD SERVICE MANUAL

NOTE: The sale of barrels, bolts and receivers is restricted. Special equipment is required for assembly. Return rifle to factory.

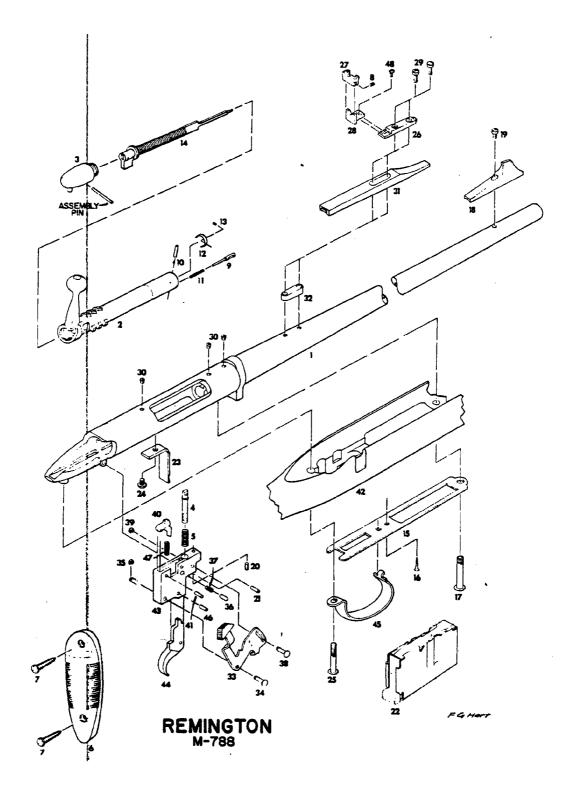
No	Part No	NAME OF PART		/iew Part No. No.	NAME OF PART
OTE	Basic 3	ROS caliber listed below. For other caliber	parts	29297	Firing Pin Assembly, 44 Rem. Mag.
		numbers, see additional calibers list.		29310	Floor Plate, 222 & 223 Rem.
				29311	Floor Plate, 22/250 Rem.
1		Barret Assembly		29312	Floor Plate, 30-30 Win.
		Bolt Assembly	1	29313	Floor Plate, 44 Rem. Mag.
		Bolt Final Assembly	1	29401	Frant Sight, 222 & 223 Rem.
			1	29402	Front Sight, 44 Rem. Mag.
	11336	Bolt Plug	(Description 4)	29535	
	14246	Buit Stop	(Restricted)		Magazine Assembly, 222 Rem.
	14024	Bolt Stop Spring	(Restricted)	29542	Magazine Assembly, 223 Rem.
	14245	Butt Plate		29536	Magazine Assembly, 22/250 Rem.
	25440	Butt Plate Screw	1	29540	Magazine Assembly, 243 Win.
	14236	Elevation Screve		29541	Magazine Assembly, 6mm Rem.
	14.11	Elector		29537	Magazine Assembly, 30-30 Win.
	17676	Ejector Pin		29538	Magazine Assembly, 44 Rem. Mag.
	14214	Elector Spring		29345	Magazine Guide Bar, 222 & 223 Rem.
	14669	Extractor	1	29347	Magazine Guide Bar, 30-30 Win. & 44 Rem. Mag.
	27340	Extractor Rivet	Í	29385	Stock Assembly, 222,223 Rem. & 30-30 Win.
			1	29386	Stock Assembly, 44 Rem. Mag.
	34351	Firing Pin Assembly		34885	
	29314	Floor Plate	1	34669	Stock Assembly, 22/250 Rem.
	14099	Floor Plate Screw	1		
	14224	Front Guard Screw	1		· · ·
	29400	Front Sight (also .22/.250 Rem.)			
	29396	Front Sight Screw			
	14250	Front Sight Washer			SERVICE PARTS
	14027	Housing Lock Screw	(Restricted)		
	14031	Housing Pin	(Restricted)		Bolt Assembly, 222 & 223 Rem. (old style)
	29539	Magazine Assembly			Bolt Assembly, 22/250 Rem. (old style)
		Magazine Guide Bar			Bolt Assembly, 308 Win., 243 Win., 6mm Rem.
	29346		1		
	14234	Magazine Guide Bar Screw	1		(DIG SCHIE)
	14235	Rear Guard Screw	1		Bolt Final Assembly, 222 & 223 Rem. (old style)
	29350	Rear Sight Assembly	1		Bolt Final Assembly, 22/250 Rem. (old style)
	14237	Rear Sight Base			Boit Final Assembly,308 Win.,243Win., 6mm Rem.
	14238	Rear Signt Eveniece			(old style)
	15728	Rear Sight Leaf		14217	Bolt Plug (old style)
	29395	Rear Sight Screw		29295	Firing Pin Assembly, 222, 223 & 22/250 Rem.
	14242	Receiver Plug Screw	1		(old style)
	91041	Rib (Rear Sight )	1	29298	Firing Pin Assembly, 308, 243 Win., 6mm Rem.
				23230	(old style)
	14244	Rib Spacer (Rear Sight)	(Reserved)		
	29370	Safety Switch Assembly	(Restricted)		Bolt Assembly, LH (old style)
	14015	Safety Switch Plvot Pin	(Restricted)		Bolt Final Assembly, LH (old style)
	14044	Safety Switch Plvot Pin Retaining Washer		14467	Boit Plug, LH (old style)
	14497	Safety Switch Detent	(Restricted)	29971	Firing Pin Assembly, LH (old style)
	14498	Safety Switch Detent Spring	(Restricted)		
	91370	Safety Switch Retainer Pin	(Restricted)		LEFT HAND CALIBERS
	14044	Safety Switch Retainer Pin Retaining			NOTE: Parts not listed same as Standard Caliber
		Washer	(Restricted)		
	14503	Sear	(Restricted)		Barrel Assembly, 6mm Rem., LH
	24477	Sear Pin	(Restricted)	•	Barrel Assembly, 308 Win., LH
			(Treathie (CO)		Boit Assembly, LH
	34891	Stock Assembly	(Dentries-1)		Bolt Final Assembly, LH
	29365	Trigger Housing Assembly	(Restricted)	01227	
	14026	Trigger Housing	(Restricted)	91337	Bolt Plug, LH
	14033	Trigger	(Restricted)	34135	Firing Pin Assembly, LH
	14971	Trigger Guard		30482	Stock Assembly, LH
	14031	Trigger Pin	(Restricted)	30330	Trigger Housing Assembly, LH (Restricted)
	14045	Trigger Spring	(Restricted)		
	14240	Windage Screw			ACCESSORY
		ADDITIONAL CALIBERS			
		NOTE: Parts not listed same as 308 calibe	<b>r</b> .	25571	Sling Strap Assembly and Mountings, Complete
		Barrel Assembly	<u>ا</u>		
		Bolt Assembly			
		Bolt Final Assembly			
	14225	Boit Assembly Pin, 30-30 & 44 Rem. Mag.			
	29290	Boit Head Assembly, 30-30 Win. & 44 Rer	n. Mag. 🛛 🚶		
	14210	Ejector, 222 & 223 Rem.			
	14212	Elector, 30-30 Win. & 44 Rem.Mag.			
	14213	Ejector Pin.30-30 Win. & 44 Rem.			
	14215	Ejector Spring,30-30 Win. & 44 Rem.	1		
		Extractor, 222 & 223 Rem.	1		
	15850				
	14216	Extractor, 30-30 Win. & 44 Rem. Mag.	1		
	27342	Extractor Rivet, 222 & 223 Rem.	_		
	34350	Firing Pin Assembly, 222, 223 & 22/250	Rem.		
	2926 <b>6</b>	Firing Pin Assembly, 30-30 Win.			

7

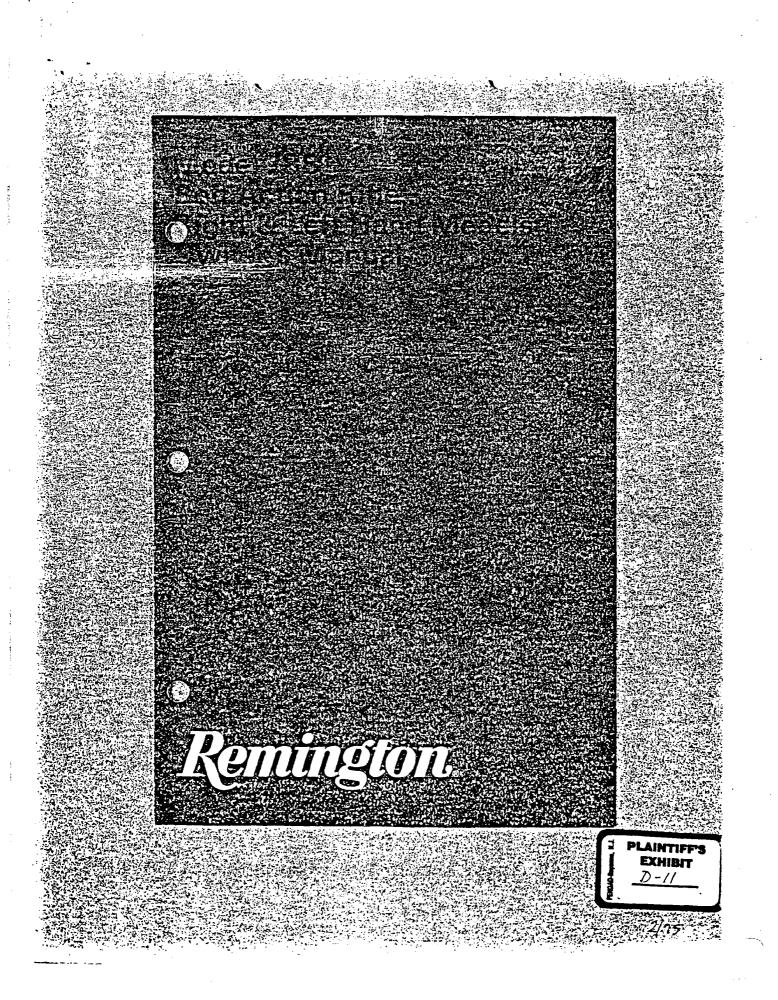
# REMINGTON FIELD SERVICE MANUAL

EXPLODED

VIEW



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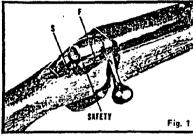


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# MODEL 788

# BOLT ACTION HIGH POWER RIFLE

THE REMINGTON MODEL 788 is a high power rifle with an extremely strong action. The full length, Monte Carlo stock has a form fitting pistol grip. The receive fitted with removable plug screws for receiver sights and telescope mounts. The build can be removed easily for take-down. The Model 788 is also available in Left Hand Action model for specified calibers. Maintenance is same as standard model, TO PUT BOLT IN RIFLE – Your model 788 is shipped from the factory with bolt removed from rifle. For right hand models, place bolt into receiver with bolt handle in 2 o'clock position. For left hand models, bolt handle should be in 10 o'clock pos-



 Ition. Push bolt forward into rifle.
 TO COCK BOLT -- Bolt must remain to cocked to put into rifle. If bolt "uncocks", firing pin head will snap forward into cocking cam in rear of head (Fig. 2) firmly to prevent movement. Use vise jaws if available. Raise bolt handle. Bolt will cam cocking surface (beneath handle) against firing pin head. Continue raising handle until cocking detent on rear of bolt engages firing pin head. Bolt is them cocked and ready for re-entry to rifle.
 Fig. 1 TO REMOVE BOLT - Raise bolt

handle to unlock bolt and pull bolt rearward to bolt stop. Rotate and hold safety forward and withdraw bolt from rifle.

CAUTION: While handling, carrying, loading or unloading rifle, make sure that muzzla is pointed in a safe direction.

SAFETY (Fig. 1) — Close bolt and push safety to rear stop position, marked "S"  $I_{\rm eff}$  receiver. Bolt handle will be locked down, and trigger cannot be pulled to fire rifle. FIRE — Push safety to front stop position marked "F" on receiver. Trigger can be pulled to fire rifle.

CAUTION: Before firing make sure barrel is clear-free of heavy oil, grease or any

TO SINGLE LOAD - Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load cartridge directly into chamber. Close bolt and lower bolt handle to lock action closed. Rille is now ready to fire.

TO UNLOAD CHAMBER - Pull bolt rearward carefully until bullet tip clears chamber, Lift cartridge from rifle.

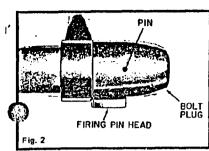
CAUTION: Open action and check chamber in breech of barrel to make sure no round remains in rille.

TO MAGAZINE LOAD - Grasp front and rear of magazine between thumb and forefinger, Press magazine release and pull magazine from rifle. Load cartridges into magazine. Magazine capacity for all calibers other than 222 or 223 Rem. is three [3] cartridges. When fully loaded, 222 or 223 Rem. magazine will hold four (4) cartridges. To replace magazine, press magazine evenly into rifle until it clicks into

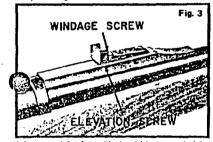
position. TO UNLOAD MAGAZINE - Lift bolt handle, pull bolt rearward and re-

TO UNLOAD MAGAZINE - Lift boit handle, pull boit realward and we move cartridge from chamber. Leave bolt in open (rear) position and remove magazine from rifle. Carefully slide cartridges forward and out of magazine.

SIGHT ADJUSTMENT - Factory sights on Remington high power rifles are targeted at 100 yards and carefully adjusted at factory for aver shooters. If your rifle does not appear to shoot accurately it does not no essarily mean that sights are improperly sligned. Individual differences in eyesight or method of shooting may require sight realignment. Before attempting to re-align sights it should be realized that the greater the group size the more difficult it becomes to determine where rifle is shooting (center of impact). A consistent method of holding rifle, alming and squeezing trigger will aid in obtaining a small group size. Different sight settings are required for each cartridge type, bullet type and weight, barrel length, each range and wind condition and, most likely, each individual shooter. To test rifle for securecy plece large target in safe area at desired



range. (Before testing at a longer range it is advisable to fire a few rounds at 50 yards. At this range, bullets will generally hit somewhere on target). Shoot from a prone or sitting position giving body and elbows solid support. Fire four or live shots per group, using ammunition with which you plan to hunt. Shoot carefully and deliberately. If groups are at desired point, sights are correctly adjusted, if not, you should adjust sights. If shots are too high, loosen elevation screw and lower rear sight. If shots are too fow, rear sight should be raised. If rifle shoots



left, rear sight (Fig. 3) should be moved right. Should rifle shoot to right, move rear sight to left. (Turn windage screw to loosen sight teaf). Always move rear sight in direction you want rifle to shoot. Information about trajectory or ballistics of your favorite load may be found in the Remington Firearms and Ammunition Catalog. A free copy may be obtained from Remington dealers or by writing to Remington Arms Co., Inc., 939 Barnum Ave., Bridgeport, Conn. 06600.

CLEANING AND CARE - Caution: Before cleaning make sure rifle contains no live ammunition. To make cleaning of barrel and bolt easier, bolt should be removed from rifle. To clean barrel use lightly oiled, soft cloth and gena from breech to muzzle. Scrub barrel bore cartridge chamber with a good bore soltic, it necessary. Wipe dry and re-oil bore and chamber very lightly. Brush face of bolt to remove shooting residue. Wipe dry and re-oil very lightly. Additional care and cleaning of bolt parts can be done, if necessary.

ACTION CARE AND DISASSEMBLY – Remove stock and bolt if necessary to clean action or replace parts. Unscrew and remove front and rear guard screws. Trigger guard may then be moved by pivoting downward until it pulls 14 of floor plate. Lift stock away from action barrel, Clean bolt and action in solvent wipe clean. Reverse procedure to reassemi.

TO DISASSEMBLE BOLT PARTS - B: assembly may be cleaned and oiled as a u-Should disassembly be required, proceed follows: With bolt cocked (handle down), in:pin (close fitting through holes in both sides bolt plug (Fig. 2). Lift handle and remove bofrom rifle. Unscrew and remove bolt plug - fuing pin assembly. To reassemble, screw asserbly into bolt until firing pin head contacts reof bolt. Back off (counter-clockwise) until fuing pin head snaps into detent on rear edge c bolt. Replace bolt into rifle. With handle down remove pin from bolt plug.

LUBRICATION - Your Remington Model 78: will remain clean longer if little or no oil is user on parts of action. Lubricate cam surfaces or bolt to prevent wear. Wash action and but parts with a good grade of petroleum solven: dry and re-oil very lightly. After handling, winbarrel, receiver and all steel parts to preven rusting, Invisible "prints" of moisture can cause rust unless removed. After using in wet weather dry and wipe steel parts with oil to prevent rust ing. Abrupt changes in temperature can cause condensation and wetness, Therefore, special care is needed to interior steel parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite in necessary to lubricate metal parts.

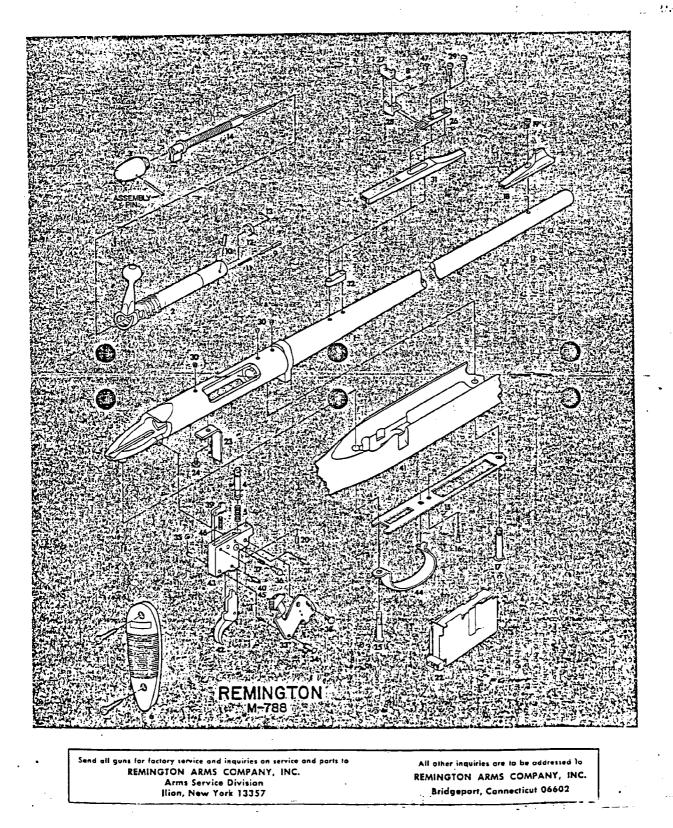
MAINTENANCE – Rifle should be checked periodically by a competent gunsmith to ensure proper inspection and any necessary replace ment of worn or damaged parts.

IMPORTANT — Remington firearms are de signed, manufactured and proof tested to stand ards based on factory loaded ammunition Improperty loaded handloads can be dengerous Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

This gun has been manufactured to Remington specifications and shipped from the factory suitable for use. Remington does not recommend and is not responsible for any alteration or modification to the gun not mathby Remington factory personnel, nor the re placement of worn or damaged parts with those not of Remington manufacture.

SHOOTING GLASSES - Smart shooters always wear good, impact-resistant shooting glasses to protect eyes against ricochet, possible powder blowback or branch and twig whiplash In addition to eye safety, green or gray glasses keep eyes fresh on bright, glary days, while yel low lenses aid in spotting game in dim or fadinc light.

EAR PROTECTION - Proper ser protection in the form of ear plugs or hearing guards should be utilized whenever practical. MODEL 788 BOLT ACTION HIGH POWER RIFLE



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MODEL 788 BOLT ACTION PARTS LIST HIGH POWER RIFLE NOTE: Prices for barra See. NOTE: Prices for barrais and botts will be quoted upon application: Fectory assembly required, SEE INSTRUCTIONS FOR ORDERING PARTS SEE INISTON View of Portivity States The States NAME OF PARTIES Port A PART A PART A PART A PART 
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 NOTE:
 Basic: 308 caliber listed below. For other caliber parts

 Inditional caliber listed below.
 For other caliber parts

 1
 Barro Assembly:

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 Bait Assembly:

 3
 14217
 ADDITIONAL CALIBERS NOTE: Part Not-Listed Same at 308 Caliber Barrer Assembly, 222 Rem P Berrel Assembly, 223 Rem, 22 Barrel Assembly, 5mm, Rem. \$ 1.30 Bolt Pring Bolt Final Assembly 22/250 Rem Bolt Final Assembly 222/223 Rem Elector, 222/223 Rem Extractor, 222/223 Rem .90 4 14246 Bolt Stop .35 5 14024 Butt Plate 14245 ŗ .50 6 But Plate Screw Elevation Screw .35 25410 14210 s .50 7 .35 14236 8 15850 1.90 Extractor, 222/223 Rem. Extractor River, 222/223 Rem. Fining Pin Assembly, 222/227 - 22/250 Rem. Floor Plate, 222/223 Rem. 14211 .50 27342 .35 9 WARES AND BALLING LAND .35 Efector Pte 10 17676 29295 5.20 Ejector Pla .35 11 14214 29310 1.15 Floor Plate 22/250 Rem Harris Harris Harris Harris 12 14669 1.90 1.15 Extractor 29311 ביישר טור ביר איי איי ביי אישר איידי Extractor River 27340 .35 13 29402 .90 Magazine Assembly: 222 Rem Firing Pin Assembly 14 29298 5.20 29535 5.20 Magazine Assembly, 223 Rem. Assembly, 22/250 Rem. Floor Plate 15 29314 1.15 5.20 29542 Floor Plats Screw 14099 .35 16 5.20 29536 Magazine Assembly, Z43 Wine Magazine Assembly, Grim Hern Megazine Assembly, Grim Hern .35 17 14224 29540 5.20 22 1 4 . A . A . . . . . Front Sight (also (22/250 Ren) 18 29400 .90 29541 5.20 Front Sight Screw Megazina Guide Bar, 222/223 Remain Stoct: Assembly (222/223 Remained) Stock: Assembly, 22/250 Remained Stock: Assembly, 22/250 Rem .35 19 29396 .65 29345 From CWasher House Ock Screw .35 14250 34.50 29385 .35 20 14027 34.50 29387 LEFT, HAND CALIBER NOTE: Part Not Listed Same as Str. dicalibe Housing The Assembly and the Assembly an 21 14031 Housin .35 G . NOTE: Part Not Listed Same as Steller di Caliber Barrei Assembly, 6mm Rem. L. H. Barri Assembly 308 Wirr. L. H. Bolt Assembly 109 Hore to the second 22 29539 5.20 Magazine Guide Bar Screw 23 29346 .65 Magazine Guide Den Alter and Alter and Alter Alt 24 14234 .35 25 14235 .35 29350 2.55 26 14237 .90 The search and the stand Rear Sign Eveneer Rear Sign Control of the state of the s 27 14238 14467 1.30 \$ 1.30 28 15728 .50 29971 5.20 29 29395 .35 30482 Rear Sight Screw 34.50 30 14242 .35 30330 6.25 31 14243 .65 29370 1.30 32 14244 .50 ACCESSOR M Safety Assembly 33 29370 1.30 Safety Plvot Pln Fetaning Washer Safety Plvot Pln Fetaning Washer Safety Plunger Safety Plunger Safety Plunger Spring Safety Plunger Spring Safety Plunger Spring Safety Plunger Spring 14015 34 .35 35 14044 .35 36 14032 .35 Assembly and M 25571 \$ 6.25 14029 37 .35 38 14254 .35 Sear The Second 39 14503 i and the second 40 91126 .35 41 29388 34.50 6.25 29365 42 14033 43 14026 29010 3.35 44 14248 1.15 Trigger Plate Manuer Law and Walk Soul - State 45 14031 .35 Tripger Spring 46 14045 .35 idage Server 47 14240 35 

ARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE '

# INSTRUCTIONS FOR ORDERING PARTS

#### (PLEASE READ CAREFULLY)

Please give model number, part number and name. Give serial number and state caliber or gauge and choke. Identify parts from list, picture or exploded view. List interchangeable shotgun barrels on separate order form to speed shipment.

Cover only one subject in letter or order. Do not order parts and give repair instructions in same letter.

Please do not ship sample parts if they may be identified otherwise. See shipping instructions below.

The sale of center fire rifle barrels, bolts and receivers is restricted. Special tools and gauges are required for assembly. Parts will be supplied for discontinued models if available. Parts cannot be supplied nor guns repaired if not listed in complete line parts list. Parts, being made to close dimensions, may to quire slight adjustment or fitting to assure per function of arm. IMPORTANT: Do not combine Part Orders

with Gun Service Orders, Please send Part Orders direct to:

REMINGTON ARMS COMPANY, INC. PARTS DEPT. ARMS SERVICE DIVISION Ilion, New York 13357

# INSTRUCTIONS FOR FACTORY SERVICE

#### (PLEASE READ CAREFULLY)

Please package carefully. Use plenty of cushioning material to prevent movement of gun or parts in package. Please do not ship gun in a gun case, or special container that must be returned. Return of gun or parts will be speeded if properly packaged in a throw-away carton. Clearly mark forwarding and return address on gun package as well as on attached letter. Securely attach complete letter of information

Securely attach complete letter of information on outside of each package returned to factory for repairs. Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to factory with gun shipment. Give full details of contents. State if complete gun or part, List model number, part number and name, serial number and caliber or gauge. Give full condition of contents — any parts missing or damaged, etc. This will enable us to accurately list needed repairs.

pairs. Do not order parts and give repair instructions in same letter. To avoid delay in starting work, please include in first order or letter the trouble to be corrected, changes desired or parts to be replaced. If an estimate is required please advise. Otherwise work will proceed and a statement of cost will be sent. This will speed serUnless specified otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages. Remington gun parts are not interchangeable with those of any other make. For this reason the Remington Arms Company, Inc., cannot service any gun ot of its manufacture. Repairs will be made on discontinued models as long as supply of parts is available. However, repairs cannot be made for models which are not listed in Complete Line Parts Lists. IMPORTANT: IT IS A FEDERAL OFFENSE TO SHIP FIREARMS AND AMMUNITION TO-GETHER, BEFORE PACKAGING FIREARMS FOR RETURN TO FACTORY, ALL LIVE AMMUNITION SHOULD BE REMOVED. If live ammunition is included in package, shipment cannot be made by Insured Mail, All other shipments may be made by Insured Mail, Please send repairs direct to:

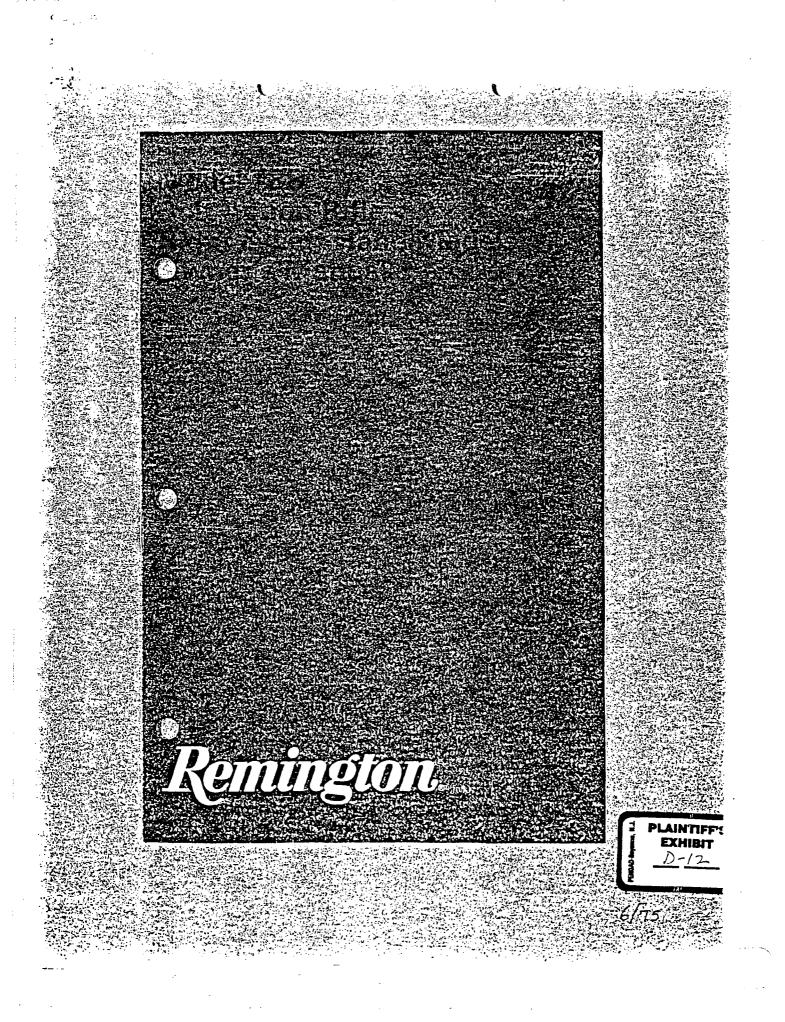
REMINGTON ARMS COMPANY, INC. ARMS SERVICE DIVISION Ilion, New York 13357



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Printed in U.S.A.

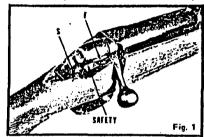
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# ODEL 788

## BOLT ACTION HIGH POWER RIFLE

THE REMINGTON MODEL 788 is a high power rifle with an extremely strong action. The full length, Monte Carlo stock has a form fitting pistol grip. The receiver is fitted with removable plug screws for receiver sights and telescope mounts. The bolt can be removed easily for take-down. The Model 788 is also available in Left Hand Action model for specified calibers. Maintenance is same as standard model TO PUT BOLT IN RIFLE – Your model 788 is shipped from the factory with USA removed from rifle. For right hand models, place bolt into receiver with bolt handle in 2 o clock position. For left hand models, bolt, handle should be in 10 o'clock pos-



ition. Push bolt forward into rifle. TO COCK BOLT – Bolt must remain cocked to put into rifle. If bolt "uncocks", firing pin head will snep forward into cocking cam in rear of bolt. To cock bolt, hold firing pin head (Fig. 2) firmly to prevent movement. Use vise Jaws if available. Raise bolt handle. Bolt will cam cocking surface Ibeneath handle) against firing pin head. Continue raising handle until cocking detent on rear of bolt engages firing pin head. Bolt is them Fig. 1 CO REMOVE BOLT – Raise bolt

handle to unlock bolt and pull bolt rearward to bolt stop. Rotate and hold safety forward and withdraw bolt from rifle.

CAUTION: While handling, carrying, loading or unloading rifle, make sure that muzzle is pointed in a safe direction.

SAFETY (Fig. 1) - Close bolt and push salety to rear stop position, marked "S" on receiver. Trigger cannot be pulled to fire rifle.

FIRE – Push safety to front stop position marked "F" on receiver. Trigger car

CAUTION: Before firing make sure barrel is clear-free of heavy oil, grease or any obstruction.

TO SINGLE LOAD - Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load cartridge directly into chamber. Close bolt and lower bolt handle to lock action closed. Rifle is now ready to fire.

TO UNLOAD CHAMBER - Pull bolt rearward carefully until bullet tip clears chamber, Lift cartridge from rille.

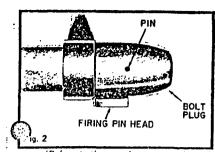
CAUTION: Open action and check chamber in breech of barrel to make sure no round remains in rifle.

TO MAGAZINE LOAD — Grasp front and rear of magazine between thumb and forefinger. Press magazine release and pull magazine from rille. Load cartridges into magazine. Magazine capacity for all calibers other than 222 or 223 Rem. is three (3) cartridges. When fully loaded, 222 or 223 Rem. magazine will hold four (4) cartridges.

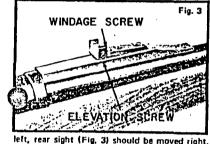
To replace magazine, press magazine evenly into rifle until it clicks into position.

TO UNLOAD MAGAZINE – Lift bolt handle, pull bolt rearward and remove cartridge from chamber. Leave bolt in open (rear) position and remove magazine from rifle. Carefully slide cartridges forward and out of magazine.

SIGHT ADJUSTMENT - Factory sights on Remington high power rifles are targeted at 100 yards and carefully adjusted at factory for average shooters. If your rifle does not appear to shoot accurately it does not necessarily mean that sights are improperly aligned. Individual differences eyesight or method of shooting may require sight realignment. Before tempting to re-align sights it should be realized that the greater the grdf size the more difficult it becomes to determine where rifle is shooting (center of impact). A consistent method of holding rifle, aiming and squeezing trigger will aid in obtaining a small group size. Different sight settings are required for each cartridge type, bullet type and weight, barrel length, each range and wind condition and, most likely, each individual shooter. To test rifle for accuracy place large target in safe area at desired



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Should rille shout to right, move rear sight to left. (Turn windage screw to loosen sight leaf). Always move rear sight in direction you want rille to shoot. Information about trajectory or ballistics of your favorite load may be found in the Remington Firearms and Ammunition Catalog. A free copy may be obtained from Remington dealers or by writing to Remington Arms Co., Inc., 939 Barnum Ave., Bridgeport, Conn. 06600.

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ACTION CARE AND DISASSEMBLY - Remove stock and bolt if necessary to clean action or replace parts. Unscrew and remove front and rear guard screws. Trigger guard may then be moved by pivoting downward until it pulls trof floor plate. Lift stock away from action barrel. Clean bolt and action in solvent a wipe clean. Reverse procedure to reassent.

TO DISASSEMBLE BOLT PARTS - Bo' assembly may be cleaned and oiled as a un Should disassembly be required, proceed follows: With bolt cocked (handle down), inspin (close fitting through holes in, both sides bolt plug (Fig. 2). Lift handle and remove bolt from rifle. Unscrew and remove bolt plug - fir ing pin assembly. To reassemble, screw assem bly into bolt until firing pin head contacts rear of bolt. Back off (counter-clockwise) until fiing pin head snaps into detent on rear edge or bolt. Replace bolt into rifle. With handle down remove pin from bolt plug.

LUBRICATION - Your Remington Model 788 will remain clean longer if little or no oil is used on parts of action. Lubricate cam surfaces or bolt to prevent wear. Wash action and bolt parts with a good grade of petroleum solven: dry and re-oil very lightly. After handling, winr barrel, receiver and all steel parts to preven: rusting. Invisible "prints" of moisture can cause rust unless removed. After using in wet weather dry and wipe steel parts with oil to prevent rust ing. Abrupt changes in temperature can cause condensation and wetness. Therefore, special care is needed to interior steel parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphile if necessary to lubricate metal parts.

MAINTENANCE — Rifle should be checked periodically by a competent gunsmith to ensure proper inspection and any necessary replacement of worn or damaged parts.

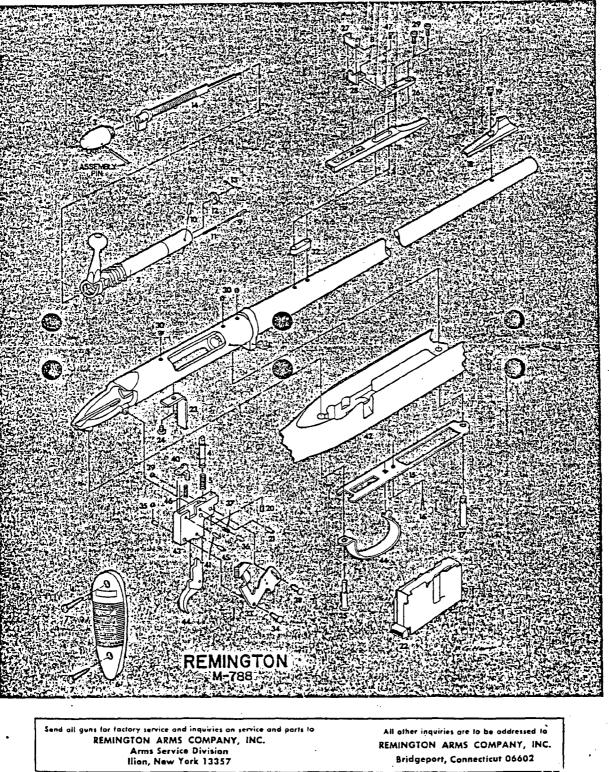
IMPORTANT - Remington firearms are designed, manufactured and proof tested to stand ards based on factory loaded ammunition Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

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SHOOTING GLASSES - Smart shooters always wear good, impact-resistant shooting glasses to protect eyes against ricochet, possible powder blowback or branch and twig whiplash. In addition to eye safety, green or gray glasses keep eyes fresh on bright, glary days, while yellow lenses aid in spotting game in dim or fading light.

EAR PROTECTION - Proper ear protection in the form of ear plugs or hearing guards should be utilized whenever practical.

MODEL 788 **BOLT ACTION HIGH POWER RIFLE**  L



Bridgeport, Connecticut 06602

VI U		HIGH NOTE: Prices for barrels and bolts w	POW	CTION ER RIFLE
	14217 14246 14024 14245 25410 14236 14211 17676 14214 14669 27340 29298 29314	Ejector Pin Ejector Spring Extractor Extractor Rivet Fring Pin Assembly Floor Plate Floor Plate Screw Front Guard Screw Front Sight Ialso ,22/250 Rem Front Sight Screw	\$ 1.30 90 35 50 35 50 35 50 35 520 1.15 35 5.20 1.15 35 35 90 35	ADDITIONAL CALIBERS         NOTE: Part Not: Listed., Same, as: 308         Barrel Assembly, 222 Rem.         Barrel Assembly, 223 Rem.         Barrel Assembly, 222/250 Rem.         Barrel Assembly, 22/250 Rem.         Bolt Assembly, 22/250 Rem.         Bolt Assembly, 22/250 Rem.         Bolt Assembly, 22/250 Rem.         Bolt Assembly, 22/250 Rem.         Bolt Assembly, 22/250 Rem.         Bolt Assembly, 22/250 Rem.         Bolt Final Assembly, 22/250 Rem.         Bolt Final Assembly, 22/250 Rem.         Bolt Final Assembly, 22/250 Rem.         Bolt Final Assembly, 22/250 Rem.         Bolt Final Assembly, 22/250 Rem.         14210         Ejector, 222/223 Rem.         Bolt Final Assembly, 22/250 Rem.         1550         Extractor, Rivet, 222/223 Rem.         29295         Fining Pin Assembly, 222/223 Rem.         29310         Floor Plate, 222/223 Rem.         29311         Floor Plate, 222/223 Rem.         29535         Magazine Assembly, 223 Rem.         29536         Magazine Assembly, 223 Rem.         29535         Magazine Assembly, 223 Rem.         29540         Magazine Assembly,
20 21 22 23	14027 14031 29539 29346	Managing Lock Screw	5.00	29387 Stock Assembly, 22/250 Rem LEFT HAND CALCARS Solution NOTE: Part Not Listed Same Landerd Caliber

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21 22 23	14031 29539 29346	Magazine Guide Bar	5. <u>.</u> 65		NOTE: Part Not Listed Same Janderd Caliber Barret Assembly, Gmm Flem, L.H.	
24 15	14234 14235	and the second second second second second second second second second second second second second second second	.35		Barrel Assembly, 308 Win, L. H.	
	29350	Rear Sight Assembly Rear Sight Assembly Rear Sight Base Rear Sight Eyepiece Rear Sight Leaf	.35 2.55		Bolt Final Assembly, L.H.	
26	14237	Rear Sight Base	.90		S Bolt Finel Assembly L H	
27	14238	Rear Sight Eyepiece	1.30	14467	Bolt Plug, L. H.	\$ 1.30
28	15728	Rear Sight Leaf	.50	29971	a Firing Pin Final Assembly/ L. H.	5.20
29	29395	Rear Sight Screw	.35	30482	Stock Assembly, L. H.	34.50
30	14242	Respire Flug Screw	.35	30330	Trigger Housing Assembly, L. H.	6.25
31	14243	Rib (Rear Sight)	.65	29370	Safety Assembly, L.H.	1.30
32	14244	Rib Spacer (Rear Skint)	.50			
33	29370	Safety Assembly	1.30			
34	14015	Safaty Pivot Pin	.35		ACCESSORY	
.35	14044	Sefery Pivot Pig Retaining Washer	.35			
36	. 14497	And the Delivery of the second s	.35	25571		\$ 6.25
37	14498	Safety Detent Spring	.35			
38	14015	Safety Detent Spring	.35			
39	14044		.35			
-:0	14503	the second of the second strategy and the second strategy and the second strategy at the	1.30			
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:3	14026	Trigger Housing	2.55			
:4	14033	Trigger Housing	1.15			<b>.</b>
:5	14031		.35			\$
:6	14045	Filingger Spring	.35	•		1
17	14240	Windage Screw	.35			1

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE , BY SALE OF A COMPANY OF THE SARE F.O.B. LION, N.Y., BE SALE

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Please do not ship sample parts if they may be identified otherwise. See shipping instructions below.

The sale of center fire rifle barrels, bolts and receivers is restricted. Special tools and gauges are required for assembly. Parts will be supplied for discontinued models if available. Parts cannot be supplied nor guns repaired if not listed in complete line parts list. Parts, being made to close dimensions, may require slight adjustment or fitting to assure proper function of arm.

IMPORTANT: Do not combine Part Ord with Gun Service Orders, Please send Part of ders direct to:

REMINGTON ARMS COMPANY, INC. PARTS DEPT ARMS SERVICE DIVISION Ilion, New York 13357

# INSTRUCTIONS FOR FACTORY SERVICE

#### (PLEASE READ CAREFULLY)

Please package carefully. Use plenty of cushioning material to prevent movement of gun or parts in package. Please do not ship gun in a gun case, or special container that must be returned. Return of gun or parts will be speeded if properly packaged in a throw-away carton. Clearly mark forwarding and return address on gun package as well as on attached letter

package as well as on attached letter. Securely attach complete letter of information on outside of each package returned to factory for repairs. Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to factory with gun shipment. Give full details of contents. State if complete gun or part. List model number, part number and name, serial number and caliber or gauge. Give full condition of contents — any parts missing or damaged, etc. This will enable us to accurately list needed repairs.

pairs. Do not order parts and give repair instructions in same letter. To avoid delay in starting work, please include in first order or letter the trouble to be corrected, changes desired or parts to be replaced. If an estimate is required please advise. Otherwise work will proceed and a statement of cost will be sent. This will speed service. Unless specified otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages. Remington gun parts are not interchangeable with those of any other make. For this reason the Remington Arms Company, Inc., cannot service any gun not of its manufacture.

Repairs will be made on discontinued models as long as supply of parts is available. However, repairs cannot be made for models which a not listed in Complete Line Parts Lists. IMPORTANT: IT IS A FEDERAL OFFENSE TO SHIP FIREARMS AND AMMUNITION TO-GETHER. BEFORE PACKAGING FIREARMS FOR RETURN TO FACTORY, ALL LIVE AMMUNITION SHOULD BE REMOVED. If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail, Please send repairs direct to:

REMINGTON ARMS COMPANY, INC. ARMS SERVICE DIVISION Ilion, New York 13357

Printed in U.S.A.

Form RD 5558 Rev. 675

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# REMINGTON FIELD SERVICE MANUAL

The Remington XP-100 is a single shot, high power, bolt action pistol for extreme accuracy and long range shooting. The basic operations of bolt, loading, extracting and ejection are similar to most bolt action rifles.



Instruction Folders RD-5469 for the 221 and RD-5761 for the 7mm BR Rem. are packaged with each new pistol shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and instructions for care and maintenance of the pistol.

When handling pistol for servicing and shipping, make certain that the pistol is empty with no rounds in barrel chamber.

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WARNING: The Trigger Balance and Trigger Balance Spring are integral parts of the trigger mechanism which help protect against accidental discharge if the pistol is dropped.

DO NOT use this pistol without these parts.

DO NOT install the barreled action on a new stock without these parts.

Send all guns for factory service and inquiries on service and parts to REMINGTON ARMS COMPANY, INC. Arms Service Division Ilion, New York 13357

All other inquiries are to be addressed to REMINGTON ARMS COMPANY, INC. Bridgeport, Connecticut 06602

### MODEL XP-100

#### BOLT FINAL ASSEMBLY

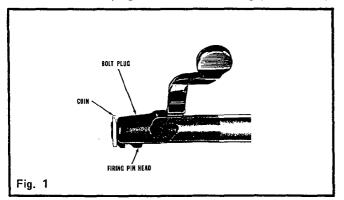
To Disassemble – With safety switch lever forward, lift bolt handle upward as far as it will go and pull bolt rearward until it is blocked by the bolt stop. Insert small tool into space between bolt and receiver and push down against angle on bolt stop. When bolt stop is depressed pull bolt rearward from receiver.

To Replace – Bolt assembly components of BOLT FINAL ASSEMBLY includes bolt body assembly and bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor and firing pin assembly and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is necessary.

To Reassemble — With safety switch lever in forward position, align bolt lugs with slots in receiver with bolt handle facing up. Push bolt forward as far as it will go and rotate bolt handle downward completely.

#### **BOLT COMPONENTS**

To Disassemble – Pull firing pin head rearward until coin or similar piece can be inserted in slot near back edge of firing pin head. (See Fig. 1). This can be done by catching the notch in the firing pin head on a sharp corner or placing it in a vise. Unscrew the bolt plug to remove the firing pin assembly.



Drive out firing pin cross pin with a punch, leaving punch in the hole to hold parts together to prevent mainspring tension from stripping off firing pin head and bolt plug forcefully. Compress the mainspring with the bolt plug until coin, punch and firing pin head can be removed. Release mainspring tension carefully, removing firing pin head, bolt plug and mainspring. Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until tension is relieved from spring. Remove ejector and spring.

With pointed tweezers inserted in holes provided in end of extractor, compress ends together until extractor can be removed from face of bolt.

To Reassemble – With pointed tweezers inserted in extractor holes, compress ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not attempt to assemble by forcing extractor into bolt face with fingers. Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin. Assemble mainspring and bolt plug. Grasp bolt plug and compress mainspring. Assemble firing pin head, align holes in firing pin head and firing pin, and insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

Assemble firing pin assembly in rear end of bolt.

#### STOCK ASSEMBLY (with bolt removed)

To Disassemble – Unscrew receiver screw from bottom of stock. Unscrew rear receiver screw up through receiver and remove stock assembly.

To Replace – All parts completely interchangeable with no factory adjustment required. Replace as an assembly. Stock assembly is a welded nylon unit factory-listed to include: Fore end tip, fore end tip spacer, fore end diamond, forward receiver screw escutcheon, grip diamond, rear receiver screw escutcheon; stock half, left; stock half, right; trigger guard. Five (5) cavities are provided inside fore end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights.

WARNING: THE TRIGGER BALANCE AND TRIGGER BALANCE SPRING ARE INTEGRAL PARTS OF THE TRIGGER MECHANISM WHICH HELP PROTECT AGAINST ACCIDENTAL DISCHARGE IF THE PISTOL IS DROPPED.

DO NOT USE THIS PISTOL WITHOUT THESE PARTS.

DO NOT INSTALL THE BARRELED ACTION ON A NEW STOCK WITHOUT THESE PARTS.

To Reassemble – Make sure that front and rear receiver screw washers (nylon) are in place in bottom of receiver and that trigger balance is in place and central in stock assembly, Insert forward receiver screw into stock from bottom to align forward escutcheon. Reassemble stock assembly to pistol, making certain receiver and barrel are well seated into stock and tighten forward receiver screw. Trigger should work freely. Should trigger not be central with clearance slot in trigger guard, loosen forward receiver screw and rotate receiver assembly slightly until trigger clears in slot. Retighten forward receiver screw. Insert and tighten rear receiver screw.

#### TRIGGER BALANCE (with stock removed)

To Disassemble- Grasp top of trigger balance between thumb and forefinger and, lifting up, remove from stock assembly. Disassemble trigger balance pin and spring from trigger

To Replace - All parts interchangeable - no factory adjustment required.

WARNING: THE TRIGGER BALANCE AND TRIGGER BALANCE SPRING ARE INTEGRAL PARTS OF THE TRIGGER MECHANISM WHICH HELP PROTECT AGAINST ACCIDENTAL DISCHARGE IF THE PISTOL IS DROPPED.

DO NOT USE THIS PISTOL WITHOUT THESE PARTS.

DO NOT INSTALL THE BARRELED ACTION ON A NEW STOCK WITHOUT THESE PARTS.

To Reassemble – Hold trigger balance with stem facing up and large angle on bottom facing forward. Hook trigger balance spring around stem of trigger balance so that opening in spring faces forward and coils are face up. (See exploded view.) Align holes in spring with hole in trigger balance and slide in trigger balance pin. Reassemble trigger balance into stock assembly. Both ends of trigger balance pin should be seated in slots (about 1" rearward of forward receiver screw escutcheon) in stock. Bent ends of spring should face against walls ahead of trigger balance pin and tension should force bottom of trigger balance forward.IMPORTANT: Make sure trigger balance is central with stock assembly.

#### REAR SIGHT ASSEMBLY

To Disassemble- Unscrew the two sight screws from rear sight base and remove rear sight assembly. The rear sight nut is used to secure the rearmost rear sight screw to the rib. This nut is located between rib and barrel, accessible only when rib is removed from barrel. See instructions for rib. Unscrew rear sight elevation screw from right side of rear sight eyepiece and remove eyepiece. Unscrew small rear sight windage screw from top of rear sight leaf and remove rear sight leaf from rear sight base. The small socket wrench shipped with each pistol is used for this purpose.

To Reassemble — Place rear sight leaf on rear of rear sight base, align holes and screw in rear sight windage screw. Line up slot in rear sight eyepiece with rear sight leaf and slide eyepiece down on leaf and screw in rear sight elevation screw. For easiest reassembly of rear sight assembly the rib should be removed.

#### FRONT SIGHT

To Disassemble – Unscrew and remove two sight screws and remove front sight.

To Reassemble - Follow reverse order.

#### RIB (with sights removed)

To Disassemble – Unscrew two rib screws and remove rib and rear sight nut from barrel.

To Reassemble – Place rear sight nut in recess provided in bottom, of rib, place rear sight assembly on top of rib so that rear hole aligns with small hole in rib and rear sight nut, and screw lightly together. Do not tighten at this time. Place rib over into studs on barrel behind and ahead of rear sight assembly. Do not tighten at this time. Reassemble front sight (see Front Sight Assembly). See that rib is fitted to contour of barrel properly and tighten all screws.

#### TRIGGER HOUSING ASSEMBLY

NOTE: FACTORY SERVICE IS REQUIRED FOR ALL TRIGGER HOUSING ASSEMBLY RELATED PROBLEMS. RETURN THE FIREARM TO THE FACTORY FOR SERVICE.

### **MALFUNCTIONS**

### Cause and Correction

FAILS TO EXTRACT

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Cause:	<ol> <li>Broken or worn extractor.</li> <li>Fouled or rusted barrel chamber.</li> </ol>
Correction:	<ol> <li>Fit new extractor.</li> <li>Clean, lightly polish or replace barrel.</li> </ol>

#### FAILS TO EJECT

Cause:	<ol> <li>Ejector stuck in bolt.</li> <li>Fouling.</li> <li>Broken or worn extractor.</li> </ol>
Correction:	<ol> <li>Free or replace ejector.</li> <li>Clean bolt face and ejector.</li> <li>See "Fails To Extract".</li> </ol>

#### FAILS TO COCK

Cause:	1. B	roken, worn or improperly adjusted sear
	0	r sear block, or both.
	2. F	iring Pin follows down.

Correction: 1. Return the firearm to the factory.2. Fit new firing pin or return the firearm to the factory.

STOCK

Listed below is the recommended method of restoring the finish on the Nylon stock.

Scratches:Use finely powdered pumice stone and oil.<br/>Rub with felt pad, Wipe clean and dry.Abrasion:Use DuPont auto rubbing compound.

Rub with cloth pad. Wipe clean and dry.

For Polishing: Use DuPont auto waxes.

To Clean Checkering: (and striations) Use stiff toothbrush.

CAUTION: Phenol is used in the weld assembly of nylon components. Use all necessary acid handling precautions.

Follow numbered sequence:

- 1. Swab both joining surfaces with phenol. Take care that acid applied to contact surfaces only.
- 2. Two (2) applications should be sufficient.
- 3. Allow swabbed surfaces to saturate thoroughly for at least five (5) minutes before joining.
- 4. Join saturated surfaces and hold in place. Use tape or clamps.

### MODEL XP-100

NOTE: Care should be taken that acid in excess is not applied to joining surfaces. Excess acid, squeezed or extruded from joined surfaces, must be removed immediately, Blemished areas will appear on unjoined areas if acid saturation is allowed to develop.

5. Allow at least one (1) hour for joined surfaces to weld together. Then remove tape or clamps.

To remove slight abrasions or blemishes in weld areas, use a good grade of auto rubbing compound.

Rev. 382

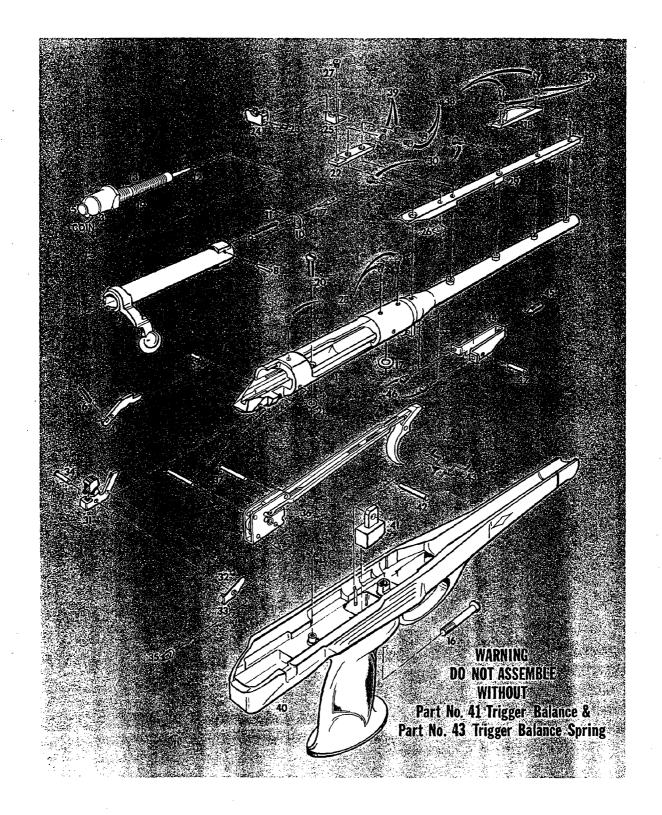
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EXPLODED VIEW

REMINGTON FIELD SERVICE MANUAL



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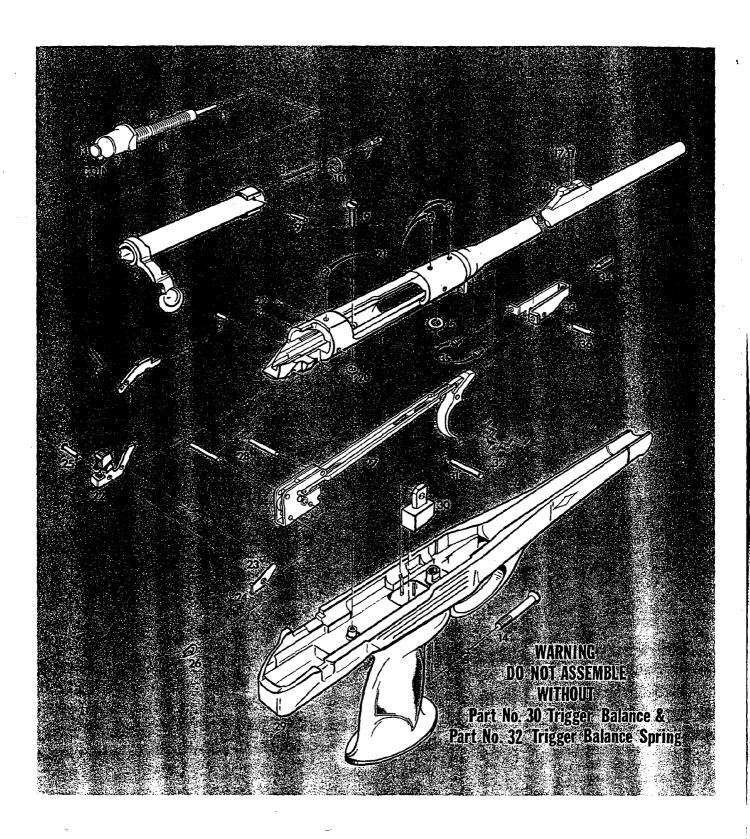
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# REMINGTON FIELD SERVICE MANUAL

iew No.	Part No.	NAME OF PART		View Part No. No.	NAME OF PART	
1		Barrel Assembly, 221 Rem. "Fireball"				
2		Bolt Assembly, 221 Rem. "Fireball"			SUPERSEDED and SERVICE PARTS	
		Bolt Final Assembly, 221 Rem. "Fireba	all''			
3	15676	Bolt Plug		20467	Extractor	
4	15446	Bolt Stop	(Restricted)	15850	Extractor, Riveted	
5	24484	Bolt Stop Pin	(Restricted)	27342	Extractor Rivet	
6	15413	Bolt Stop Spring	(Restricted)			
7	17017	Ejector				
8	17019	Ejector Spring				
9	17676	Ejector Pin				
10	91906	Extractor				
12	15410	Firing Pin	(Restricted)			
13	28600	Firing Pin Assembly				
4	17022	Firing Pin Cross Pin				
5	23321	Firing Pin Head	(Restricted)			
16	15447	Forward Receiver Screw				
17	15485	Forward Receiver Screw Washer				
18	154 <b>49</b>	Front Sight				
19	15411	Main Spring				
20	15450	Rear Receiver Screw				
21	15484	Rear Receiver Screw Washer				
	26840	Rear Sight Assembly				(
22	15 <b>727</b>	Rear Sight Base				
23	15733	Rear Sight Elevation Screw	4			
24	15725	Rear Sight Eyepiece				
25	15728	Rear Sight Leaf				
26	15418	Rear Sight Nut				
27	15732	Rear Sight Windage Screw				
	15778	Rear Sight Wrench (Not shown)				
28	17034	Receiver Plug Screw				
29	26785	Rib				
30	15417	R ib Screw				
31	914 <b>96</b>	Safety Switch Assembly	(Restricted)			
32	23222	Safety Switch Detent Ball	(Restricted)			
33	15432	Safety Switch Detent Spring	(Restricted)			
34	17043	Safety Switch Pivot Pin	(Restricted)			
35	17044	Safety Switch Snap Washer	(Restricted)			
36	26790	Sear Housing Assembly	(Restricted)			
37	24476	Sear Pin		-		
38	15416	Sight Screw				
39	16968	Sight Washer				
40	26805	Stock Assembly				
41	15470	Trigger Balance				
42	15471	Trigger Balance Pin				
43	15472	Trigger Balance Spring				
44	15472	Trigger Housing	(Restricted)			
45	15469	Trigger Housing Screw, Front	(Restricted)		7	
46	15474	Trigger Housing Screw, Rear	(Restricted)			
	107/4					
47	24483	Trigger Pin	(Restricted)			(

EXPLODED VIEW MODEL XP-100 7mm BR REM.

# REMINGTON FIELD SERVICE MANUAL



MODEL XP-100 7mm BR REM. Second Second Second

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# REMINGTON FIELD SERVICE MANUAL

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View No.	Part No.	NAME OF PART		View No.	Part No.	NAME	OF	PART	
1		Barrel Assembly, 7mm BR Rem.	(Restricted)						
2		Bolt Assembly, 7mm BR Rem.	(Restricted)	}					
-		Bolt Final Assembly, 7mm BR Rem.	(Restricted)						
3	15676	Bolt Plug		I					
4	91761	Bolt Stop	(Restricted)						
5	24484	Bolt Stop Pin	(Restricted)	ł					
6	15413	Bolt Stop Spring	(Restricted)						
7	17017	Ejector	(11111111111111111111111111111111111111						
8	17019	Ejector Spring							
9	17676	Ejector Pin							
10	91816	Extractor							
11	51010	Firing Pin	(Restricted)						
12	28600	Firing Pin Assembly	(nestrolog)	1					
13	20000	Firing Pin Head	(Restricted)						
14	15447	Forward Receiver Screw	(nestricted)						
14	15485	Forward Receiver Screw Washer							
	91763	Forward Receiver Screw Washer Front Sight Ramp							
16 17		•							
18	28505 15411	Front Sight Ramp Screw		1					
		Main Spring							
19	15450	Rear Receiver Screw		I.					
20	15484	Rear Receiver Screw Washer		l I					
21	17034	Receiver Plug Screw	(Doot-lot al)						
22	91496	Safety Switch Assembly	(Restricted)	1					
23	23222	Safety Switch Detent Ball	(Restricted)	I					
24	15432	Safety Switch Detent Spring	(Restricted)						
25	17043	Safety Switch Pivot Pin	(Restricted)						
26	17044	Safety Switch Snap Washer	(Restricted)						
27	26790	Sear Housing Assembly	(Restricted)	l l					
28	24476	Sear Pin	(Restricted)						
29	91765	Stock Assembly		1					
30	15470	Trigger Balance							
31	15471	Trigger Balance Pin							
32	15472	Trigger Balance Spring		1					
33	15473	Trigger Housing	(Restricted)	1					
34	15469	Trigger Housing Screw, Front	(Restricted)						
35	15474	Trigger Housing Screw, Rear	(Restricted)						
36	24483	Trigger Pin	(Restricted)	l					
			···••.						
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