

MODEL 600 - FIELD SERVICE MANUAL

ORIGINAL

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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.

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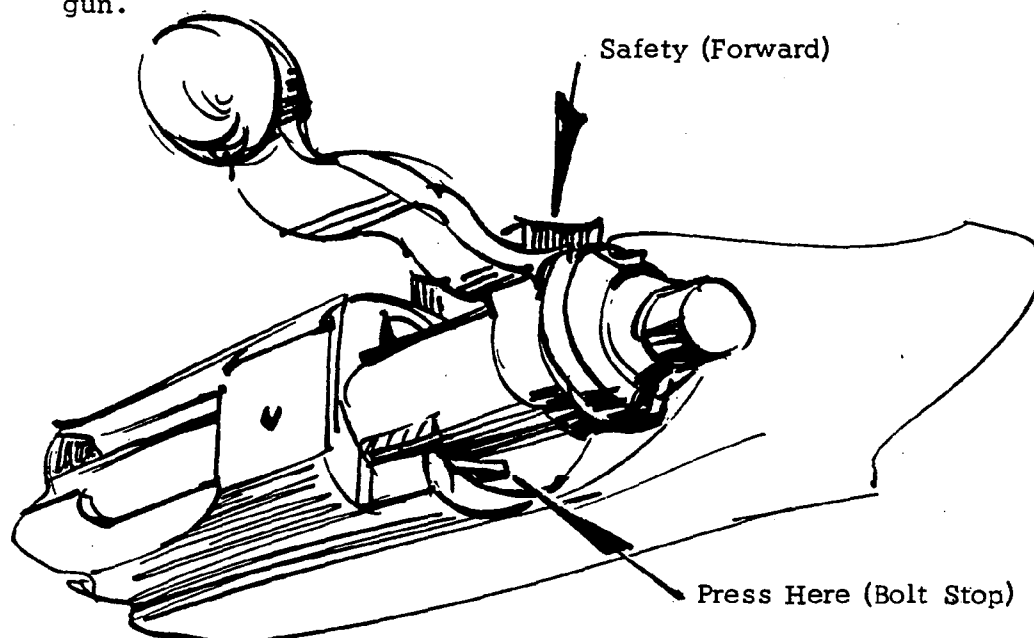
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

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 sketch below. 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; 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.

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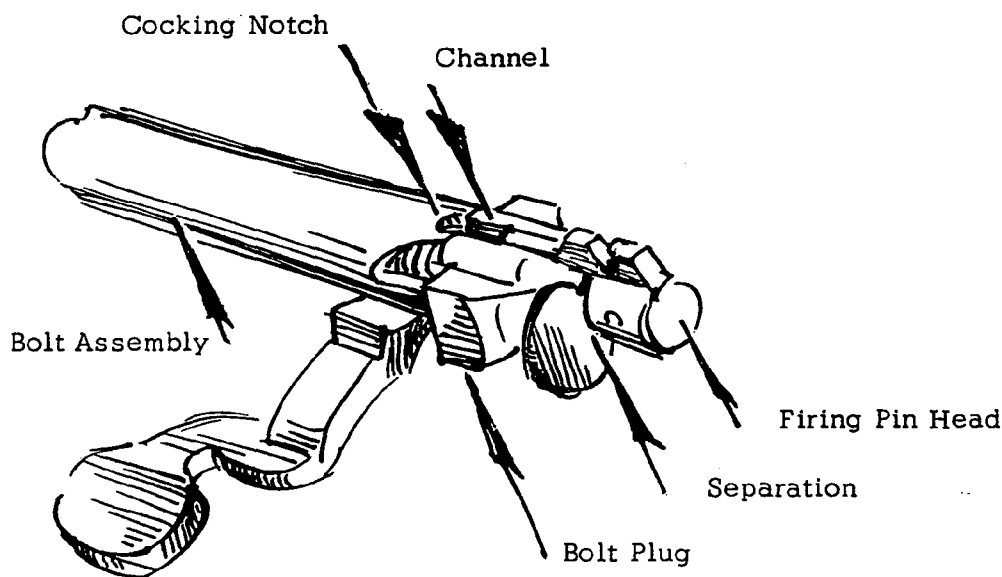
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

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 sketch below). 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.

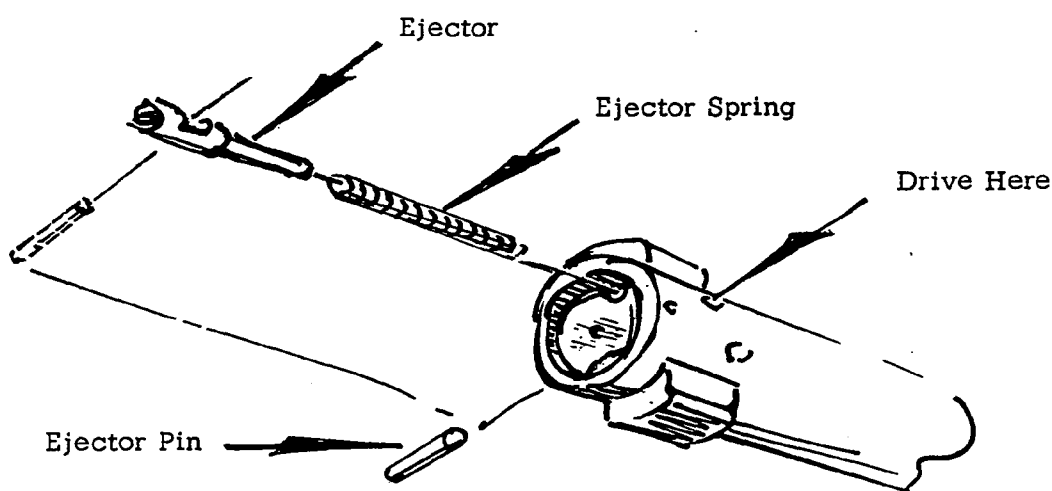


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BOLT FINAL ASSEMBLY - COMPONENTS Continued

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.

To Disassemble - 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.

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.

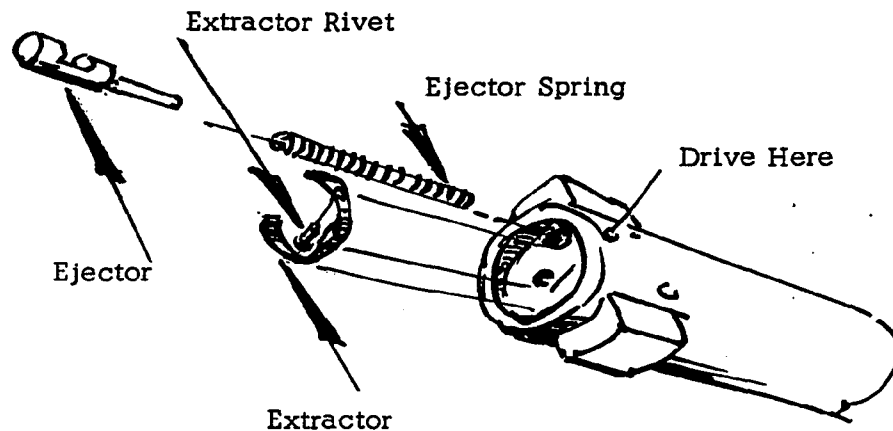
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

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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.

To Disassemble - 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.



To Service - 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.

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.

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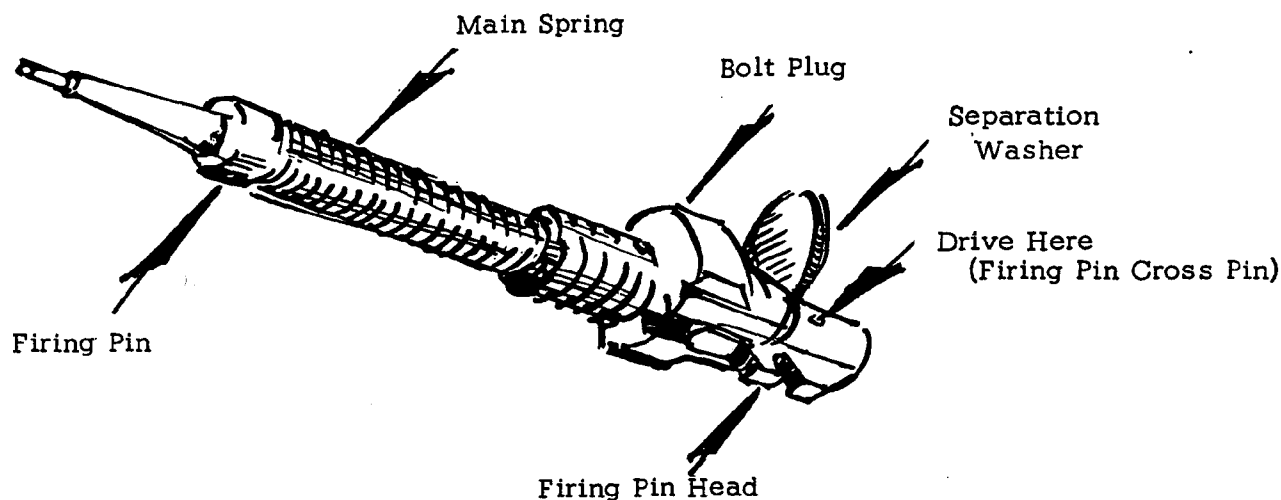
BOLT FINAL ASSEMBLY - COMPONENTS Continued

FIRING PIN ASSEMBLY - COMPONENTS include:

Firing Pin, Main Spring, Bolt Plug, Firing Pin Head,
Firing Pin Cross Pin (In Firing Pin Assembly)

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. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



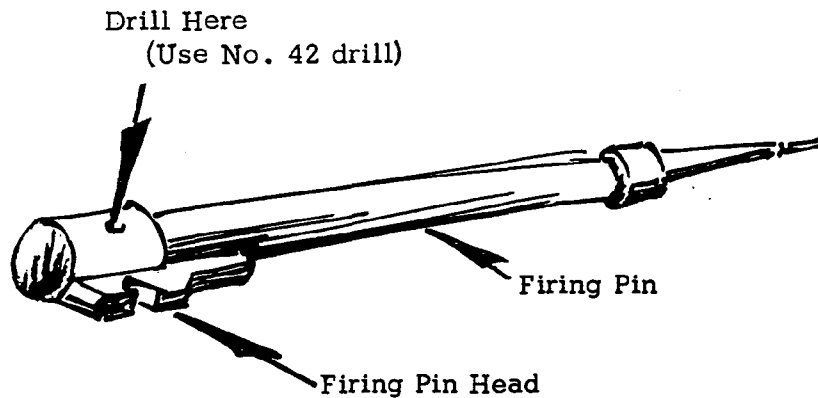
To Service - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

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

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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.



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.

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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 front 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 and 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.

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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.

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

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

To Service - 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.

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 Service - Rib is interchangeable with no adjustment required.

To Reassemble - 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.

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 Service - Interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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.

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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 Service - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

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

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 Service - Interchangeable as replacement. No adjustment required.

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 screw.

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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 Service - Interchangeable as replacement. No adjustment required.

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 Sectional View.

To Service - 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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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. See Sectional View.

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. See Sectional View.

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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 - 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".

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

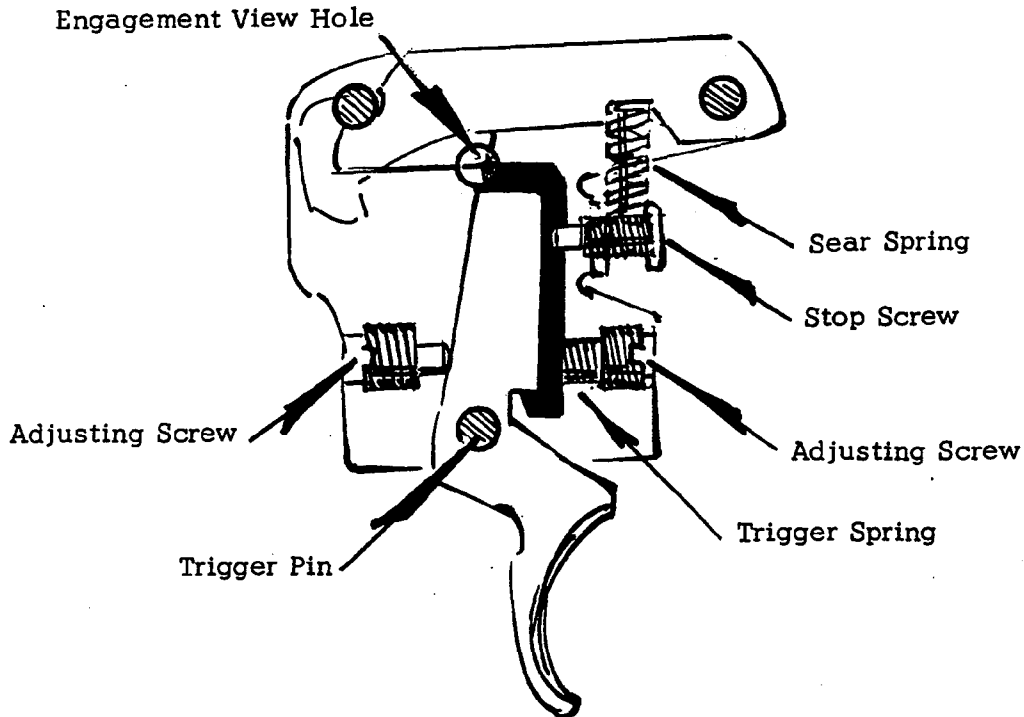
To Disassemble - Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.

To Service - Trigger housing interchangeable as replacement. No factory assembly required.

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To Reassemble - 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.

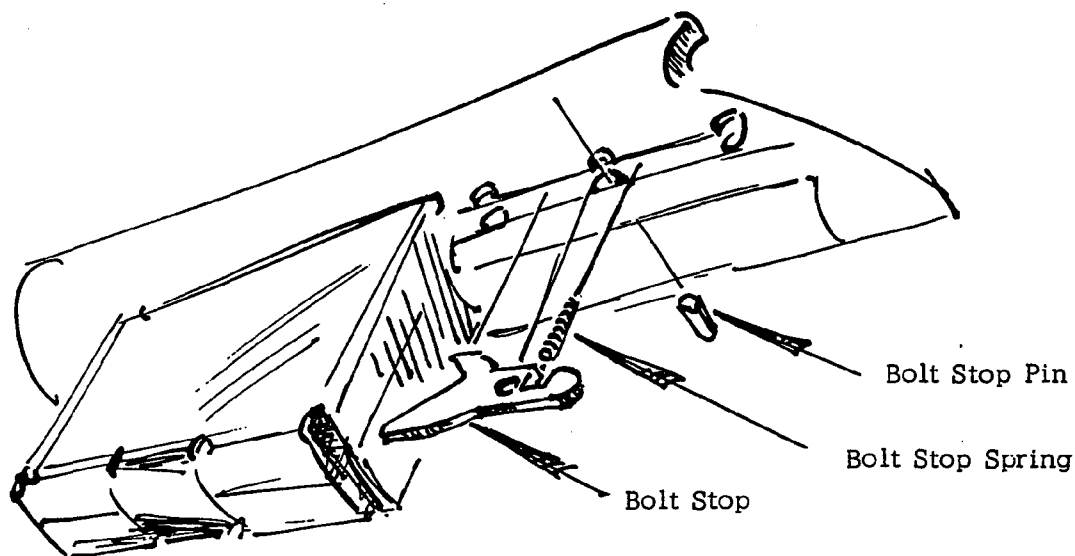
Pull of Trigger - is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight of pull.

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.

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

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 sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Service - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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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.

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.

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

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) 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.

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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.

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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

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.

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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

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Firing	<ol style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. 	<ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition.
Unlocking	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault.
Extraction	<ol style="list-style-type: none"> 1. Fouled, rough, or enlarged chamber.. 2. Extractor broken or damaged. 3. Not enough hook space on extractor. 4. Height of claw not correct. 	<ol style="list-style-type: none"> 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.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

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

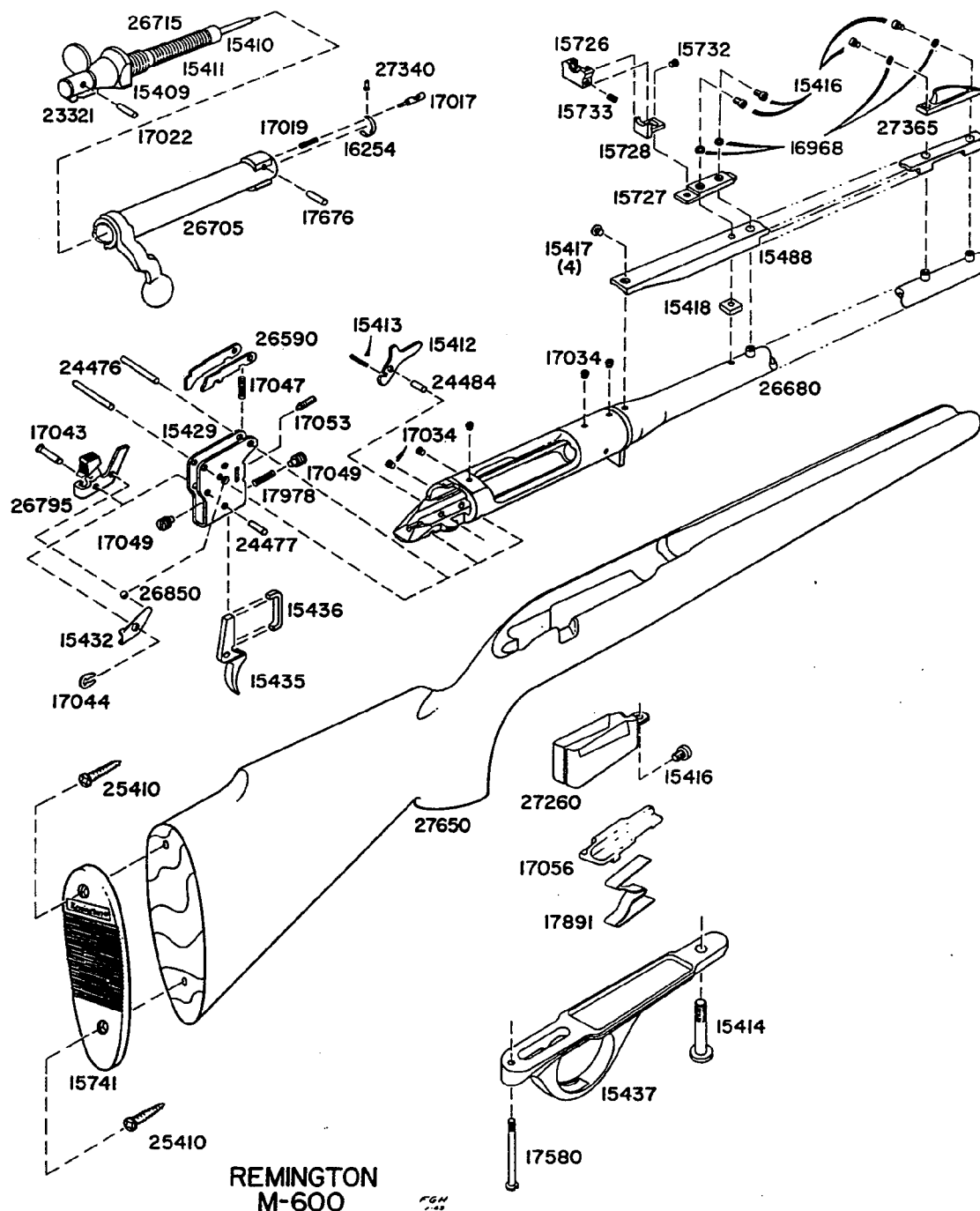
MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Locking	1. Shallow throat.	1. Ream.
	2. Min. head space.	2. Re-head.
	3. Damaged chamber.	3. 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 Blows Cases	1. Oversize chamber.	1. Replace barrel assembly.
	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 reseal in safety pivot pin slot.
	3. Safety damaged.	3. Replace safety.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Accuracy		
- Group Size	1. Crown of barrel damaged.	1. Recrown.
	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	1. Barrel not straight.	1. Straighten or replace barrel.
	2. Improper or loose sights.	2. Tighten or change 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.



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.



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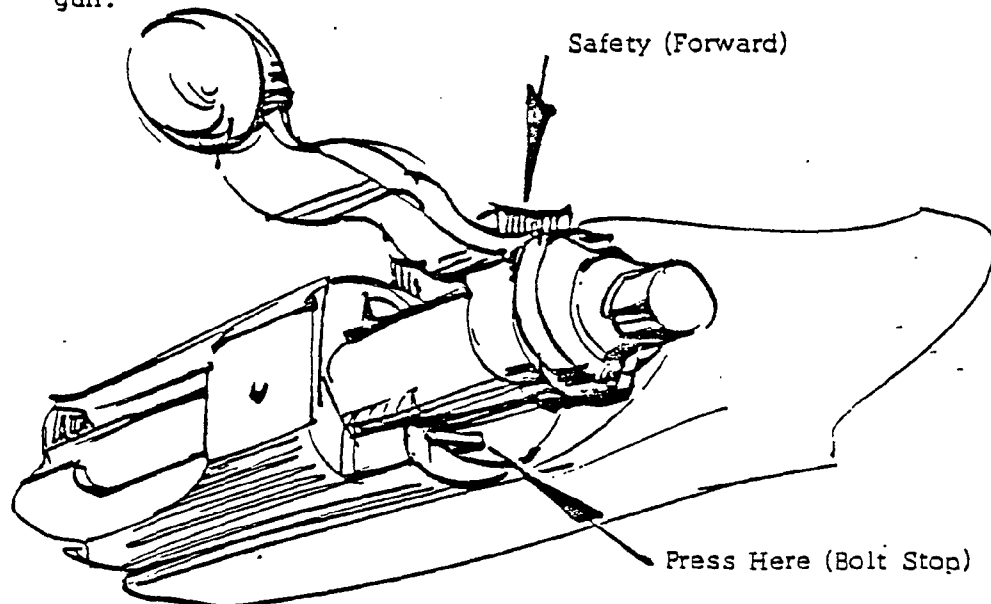
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

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 sketch below. 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; 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.

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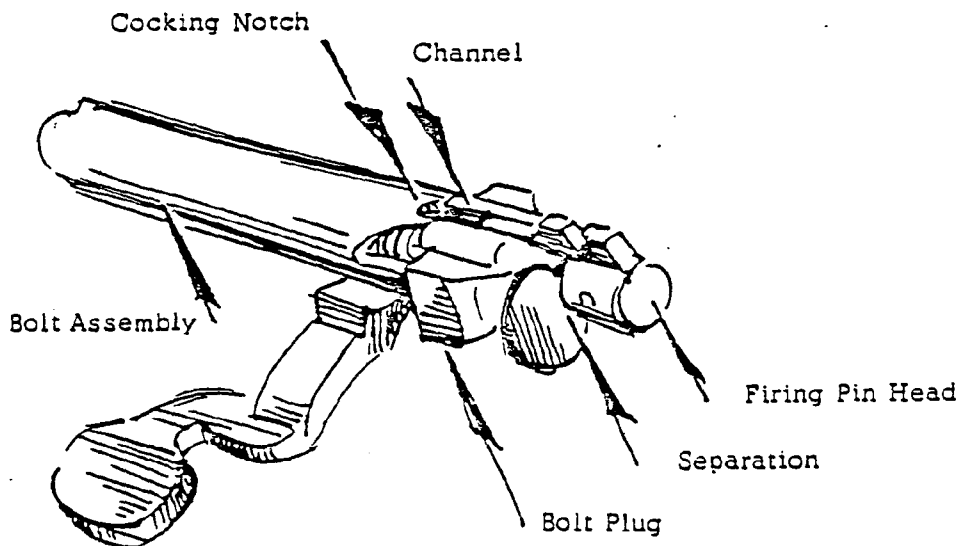
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

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 sketch below). 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.



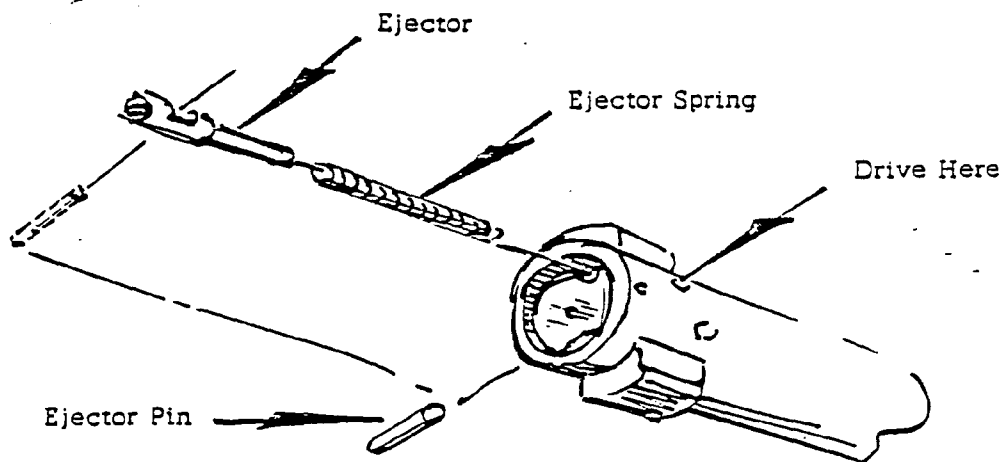
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BOLT FINAL ASSEMBLY - COMPONENTS Continued

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.

To Disassemble - 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.

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.

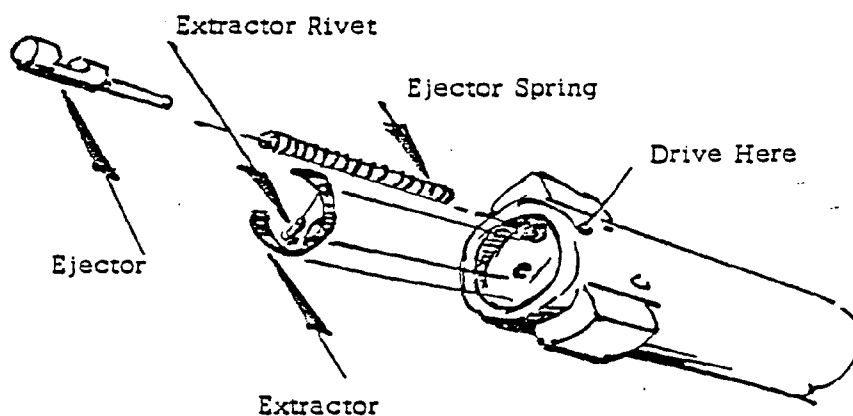
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

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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.

To Disassemble - 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.



To Service - 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.

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.

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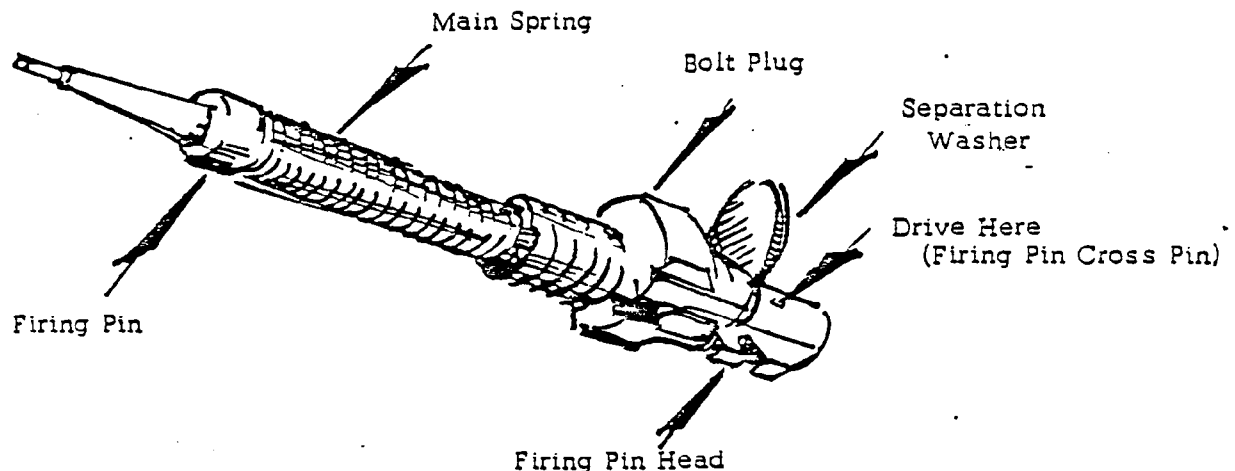
BOLT FINAL ASSEMBLY - COMPONENTS Continued

FIRING PIN ASSEMBLY - COMPONENTS include:

Firing Pin, Main Spring, Bolt Plug, Firing Pin Head,
Firing Pin Cross Pin (In Firing Pin Assembly)

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. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



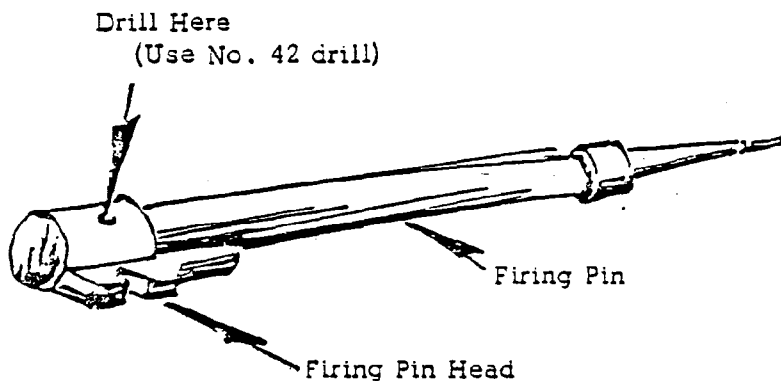
To Service - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

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

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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.



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.

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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 front 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 and 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.

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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.

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

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

To Service - 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.

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 Service - Rib is interchangeable with no adjustment required.

To Reassemble - 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.

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 Service - Interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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.

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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 Service - Interchangeable as replacement. No adjustment required.
Magazine assembly is factory listed to include magazine and magazine
support.

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

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 Service - Interchangeable as replacement. No adjustment required.

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 screw.

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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 Service - Interchangeable as replacement. No adjustment required.

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 Sectional View.

To Service - 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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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 - 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".

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

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.

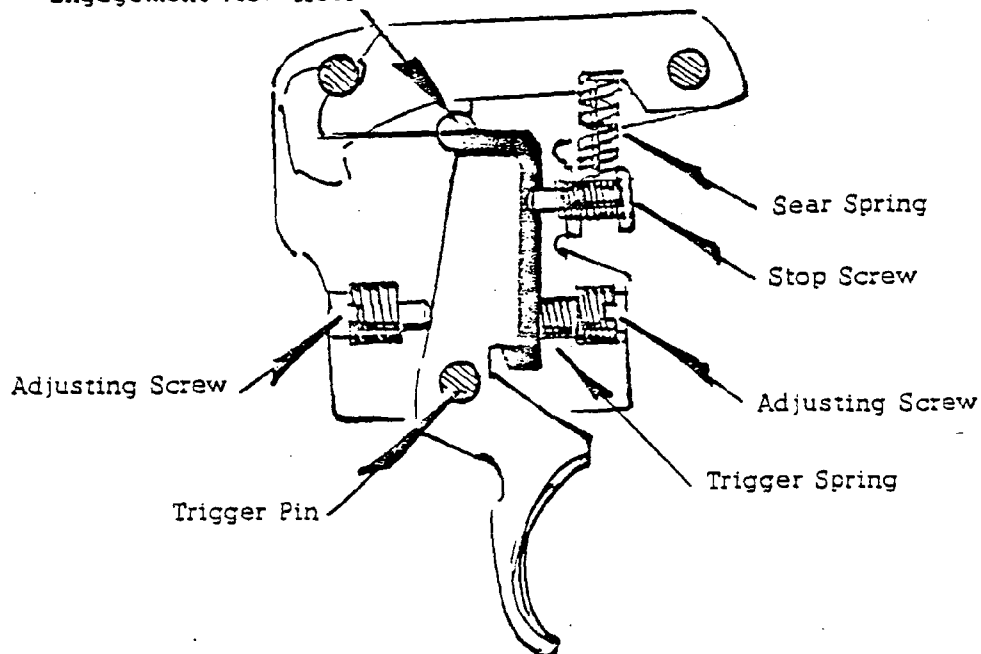
To Service - Trigger housing interchangeable as replacement. No factory assembly required.

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

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

Engagement View Hole



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.

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 of pull.

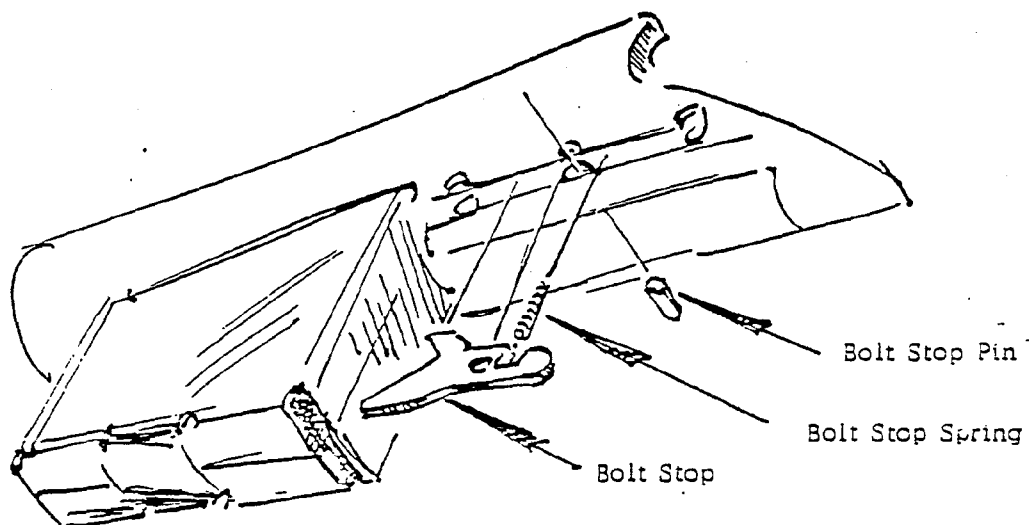
Travel of Trigger - is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off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

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MODEL 600
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BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

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 sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Service - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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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.

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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MODEL 500
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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

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.

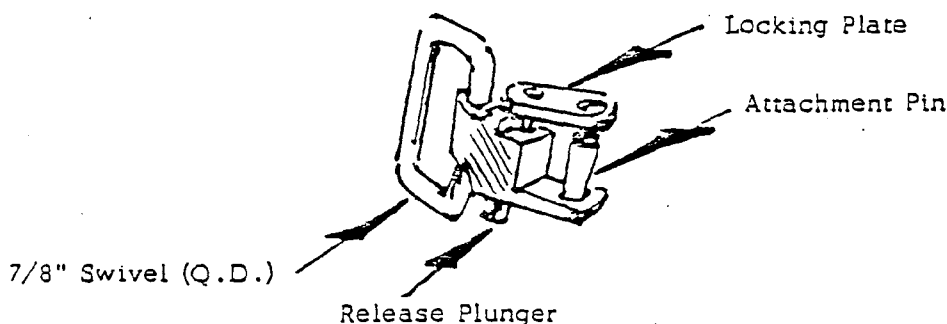
Front Swivel Screw - Use No. 13 drill

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) 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.

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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.

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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

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.

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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.

- - - - -

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>Cause</u>	<u>Correction</u>
Firing	<ol style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. 	<ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition.
Unlocking	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault.
Extraction	<ol style="list-style-type: none"> 1. Fouled, rough, or enlarged chamber. 2. Extractor broken or damaged. 3. Not enough hook space on extractor. 4. Height of claw not correct. 	<ol style="list-style-type: none"> 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.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

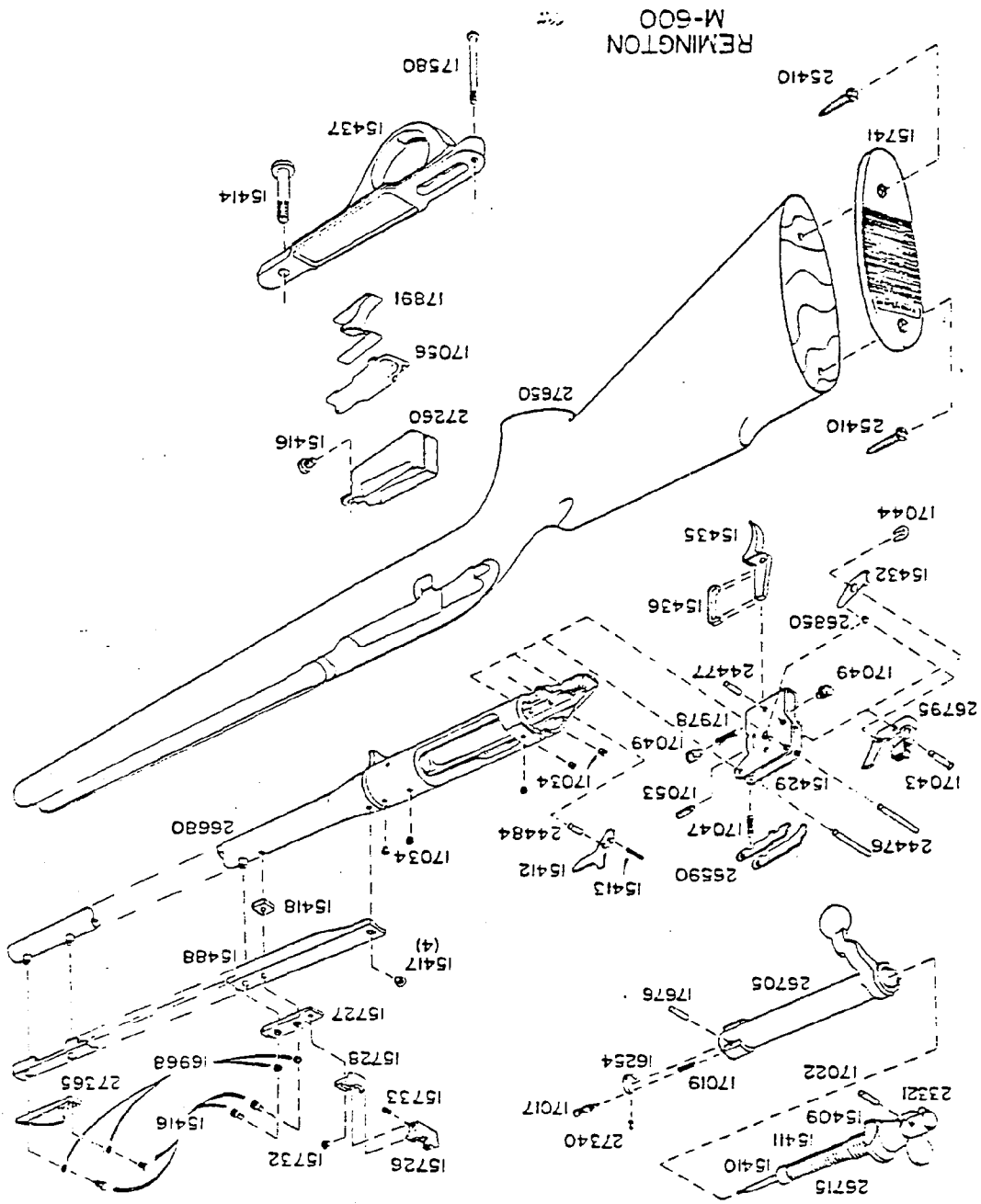
<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Bolt Binds	<ol style="list-style-type: none"> 1. Guard screws protrude into bolt track. 2. Receiver plug screws protrude into bolt track. 3. Bolt handle interferes in stock. 4. Damage at rear of bolt lugs. 	<ol style="list-style-type: none"> 1. File ends of screws. 2. File ends of screws. 3. Clear stock or fit new stock. 4. Store to blend. Check head space.
Ejection	<ol style="list-style-type: none"> 1. Burr at ejector hole in bolt. 2. Ejector binds or fails to retract far enough. 3. Extractor binds. 	<ol style="list-style-type: none"> 1. Deburr. 2. Free up or replace. 3. Adjust or fit new extractor (and rivet).
Bolt Pulls Out	<ol style="list-style-type: none"> 1. Bolt stop or bolt release binds. 2. Bolt stop or bolt release broken. 3. Bolt stop spring damaged. 	<ol style="list-style-type: none"> 1. Free up. 2. Replace. 3. Replace.
Feeding	<ol style="list-style-type: none"> 1. Magazine follower binds. 2. Weak or defective follower spring. 3. Magazine spring caught under guard. 4. Damaged chamfer on bolt head. 5. Tabs on follower bent. 	<ol style="list-style-type: none"> 1. Adjust side angle on magazine. 2. Replace spring. 3. Correct. 4. Replace bolt, or stone smooth. 5. Straighten or replace follower.
Loading	<ol style="list-style-type: none"> 1. Damaged receiver rails. 2. Sharp edge - rear end of chamber. 3. Rough loading ramp in receiver. 	<ol style="list-style-type: none"> 1. Polish or reshape. 2. Remove sharpness. 3. Polish ramp.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION
(Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Locking	1. Shallow throat.	1. Ream.
	2. Min. head space.	2. Re-head.
	3. Damaged chamber.	3. 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 Blows Cases	1. Oversize chamber.	1. Replace barrel assembly.
	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 reseal in safety pivot pin slot.
	3. Safety damaged.	3. Replace safety.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Accuracy		
- Group Size	1. Crown of barrel damaged.	1. Recrown.
	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	1. Barrel not straight.	1. Straighten or replace barrel.
	2. Improper or loose sights.	2. Tighten or change sights.



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Sectional View
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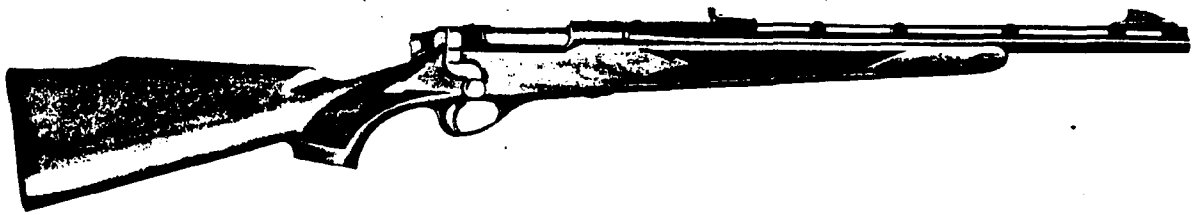
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MODEL 600

1963

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 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.

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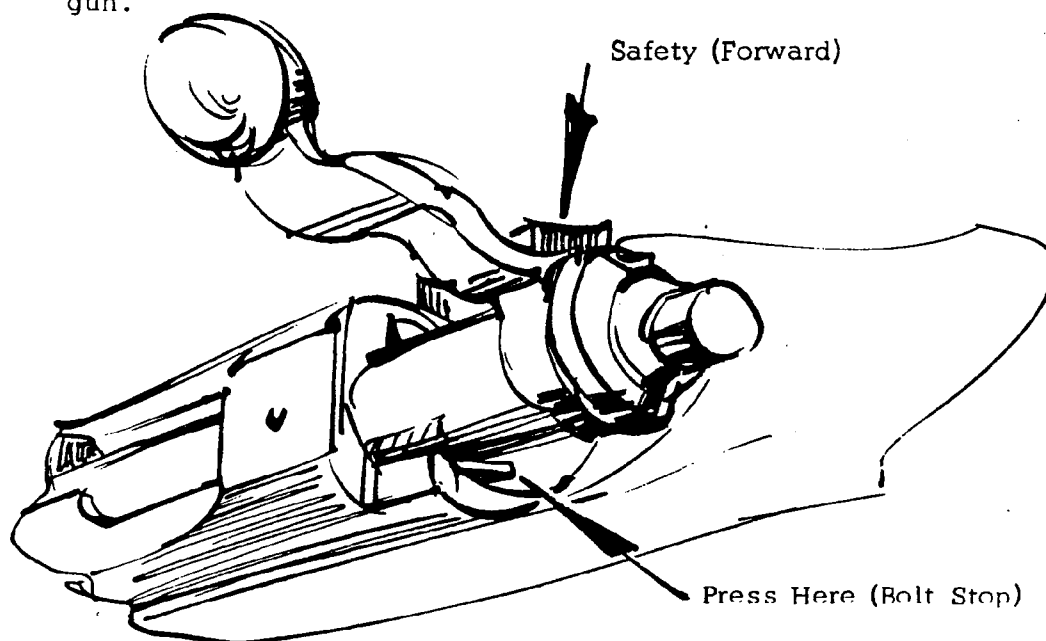
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

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 sketch below. 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; 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.

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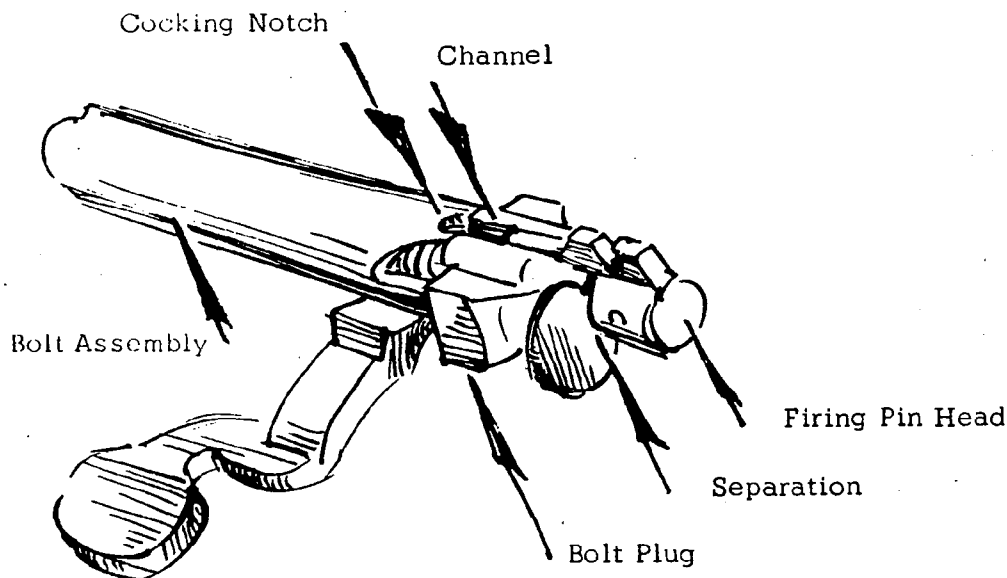
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

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 sketch below). 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.



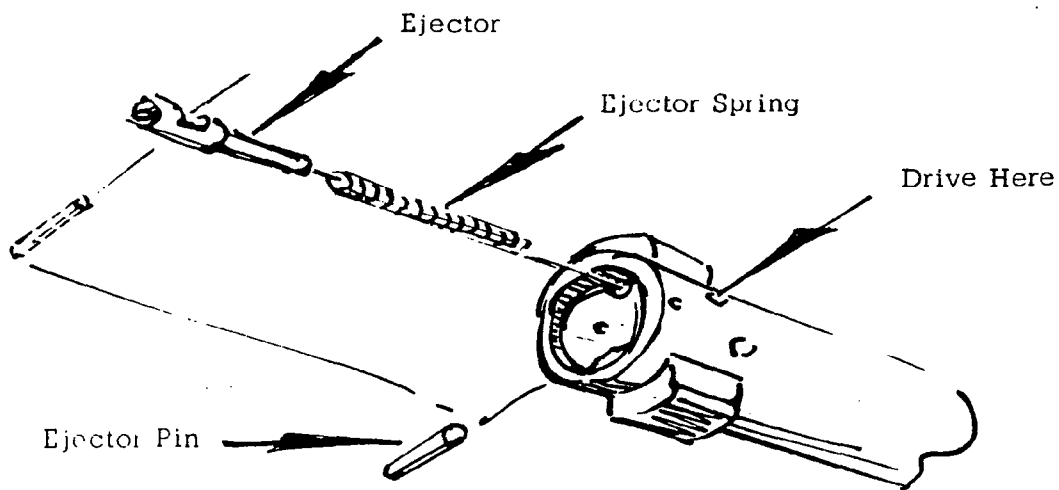
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BOLT FINAL ASSEMBLY - COMPONENTS Continued

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.

To Disassemble - 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.

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.

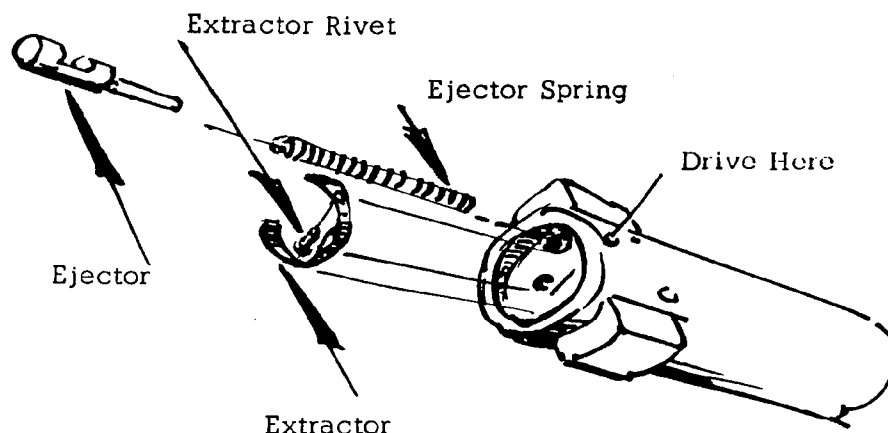
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

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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.

To Disassemble - 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.



To Service - 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.

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.

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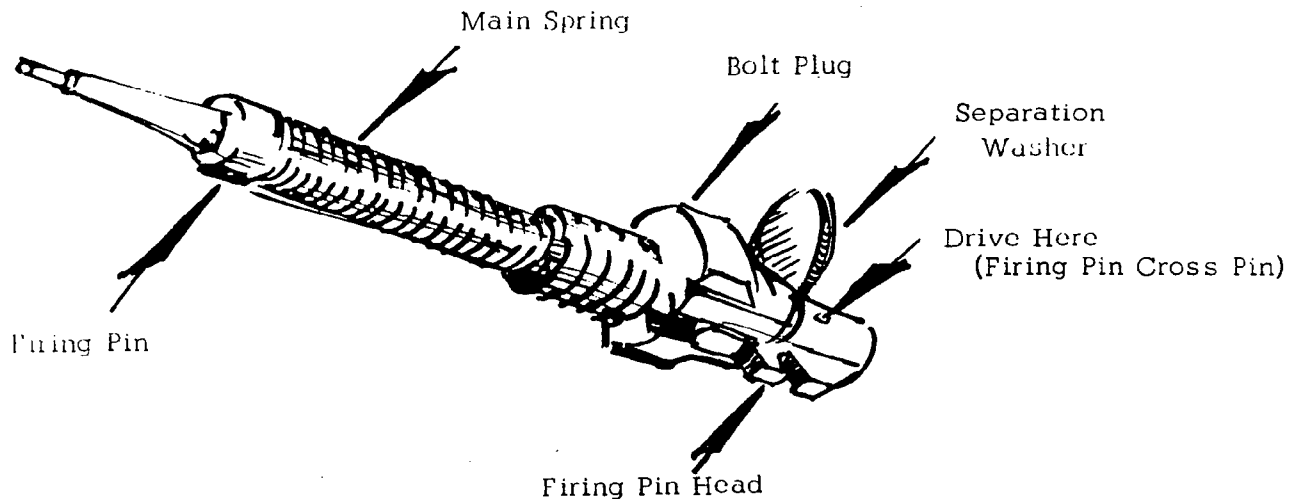
BOLT FINAL ASSEMBLY - COMPONENTS Continued

FIRING PIN ASSEMBLY - COMPONENTS include:

Firing Pin, Main Spring, Bolt Plug, Firing Pin Head,
Firing Pin Cross Pin (In Firing Pin Assembly)

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. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



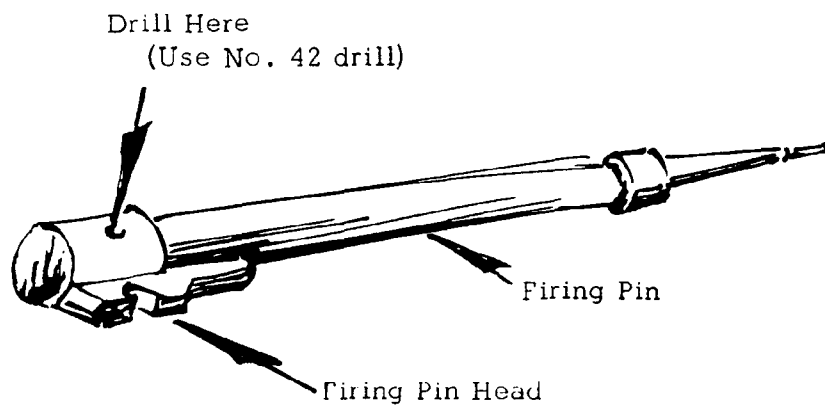
To Service - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

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

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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.



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.

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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 front 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 and 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.

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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.

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

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

To Service - 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.

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 Service - Rib is interchangeable with no adjustment required.

To Reassemble - 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.

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 Service - Interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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.

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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 Service - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

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

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 Service - Interchangeable as replacement. No adjustment required.

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 screw.

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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 Service - Interchangeable as replacement. No adjustment required.

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 Sectional View.

To Service - 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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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. See Sectional View.

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. See Sectional View.

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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 - 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".

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

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.

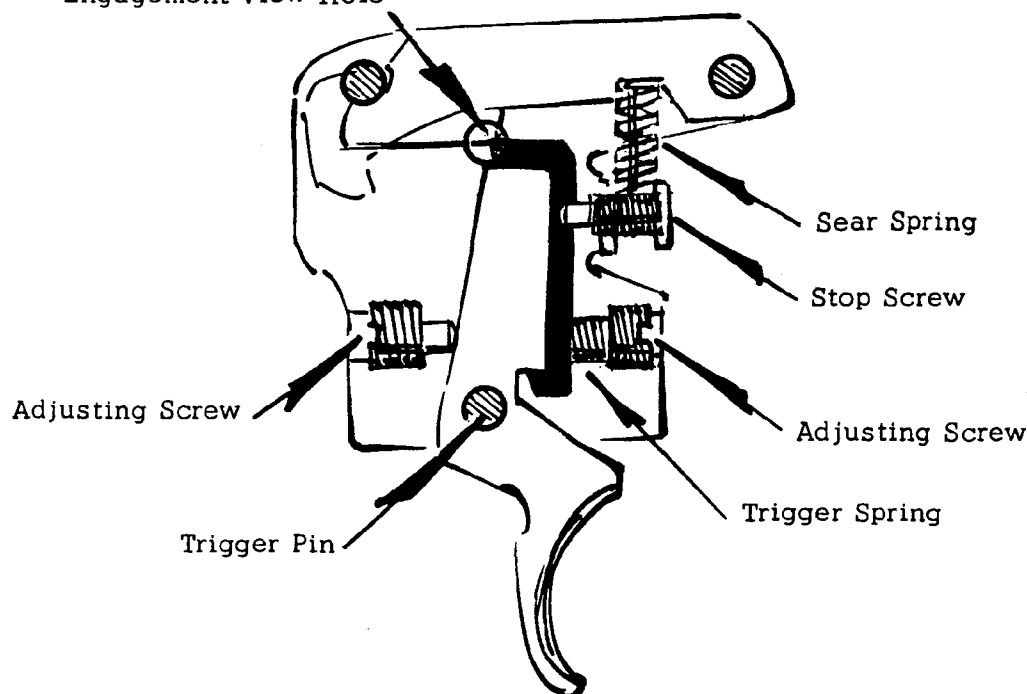
To Service - Trigger housing interchangeable as replacement. No factory assembly required.

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

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

Engagement View Hole



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.

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 of pull.

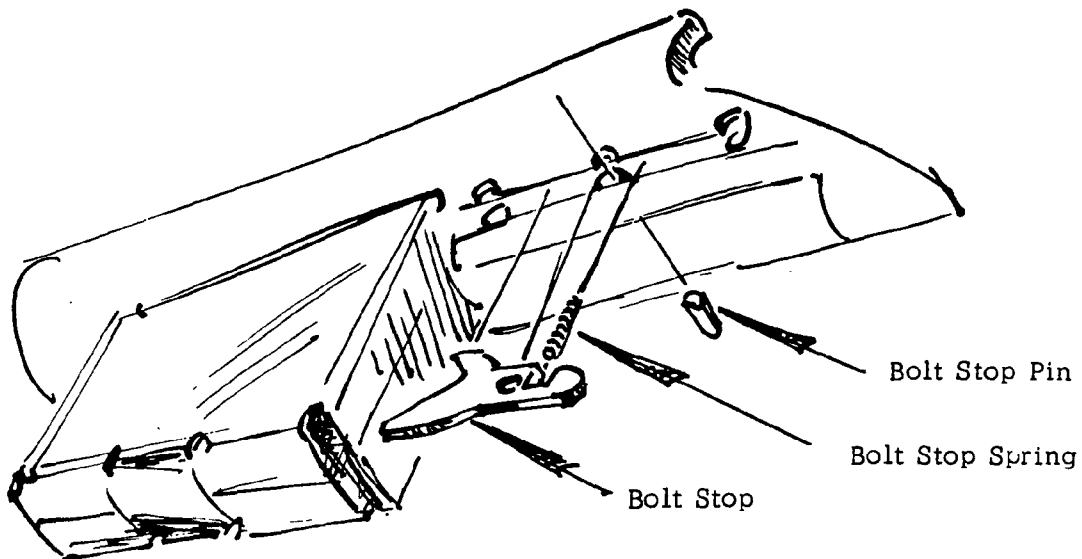
Travel of Trigger - is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off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

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

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 sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Service - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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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.

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.

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

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) 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.

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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.

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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

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.

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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.

- - - - -

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>Cause</u>	<u>Correction</u>
Firing	<ol style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. 	<ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition.
Unlocking	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault.
Extraction	<ol style="list-style-type: none"> 1. Fouled, rough, or enlarged chamber. 2. Extractor broken or damaged. 3. Not enough hook space on extractor. 4. Height of claw not correct. 	<ol style="list-style-type: none"> 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.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Bolt Binds	<ol style="list-style-type: none"> 1. Guard screws protrude into bolt track. 2. Receiver plug screws protrude into bolt track. 3. Bolt handle interferes in stock. 4. Damage at rear of bolt lugs. 	<ol style="list-style-type: none"> 1. File ends of screws. 2. File ends of screws. 3. Clear stock or fit new stock. 4. Stone to blend. Check head space.
Ejection	<ol style="list-style-type: none"> 1. Burr at ejector hole in bolt. 2. Ejector binds or fails to retract far enough. 3. Extractor binds. 	<ol style="list-style-type: none"> 1. Deburr. 2. Free up or replace. 3. Adjust or fit new extractor (and rivet).
Bolt Pulls Out	<ol style="list-style-type: none"> 1. Bolt stop or bolt release binds. 2. Bolt stop or bolt release broken. 3. Bolt stop spring damaged. 	<ol style="list-style-type: none"> 1. Free up. 2. Replace. 3. Replace.
Feeding	<ol style="list-style-type: none"> 1. Magazine follower binds. 2. Weak or defective follower spring. 3. Magazine spring caught under guard. 4. Damaged chamfer on bolt head. 5. Tabs on follower bent. 	<ol style="list-style-type: none"> 1. Adjust side angle on magazine. 2. Replace spring. 3. Correct. 4. Replace bolt, or stone smooth. 5. Straighten or replace follower.
Loading	<ol style="list-style-type: none"> 1. Damaged receiver rails. 2. Sharp edge - rear end of chamber. 3. Rough loading ramp in receiver. 	<ol style="list-style-type: none"> 1. Polish or reshape. 2. Remove sharpness. 3. Polish ramp.

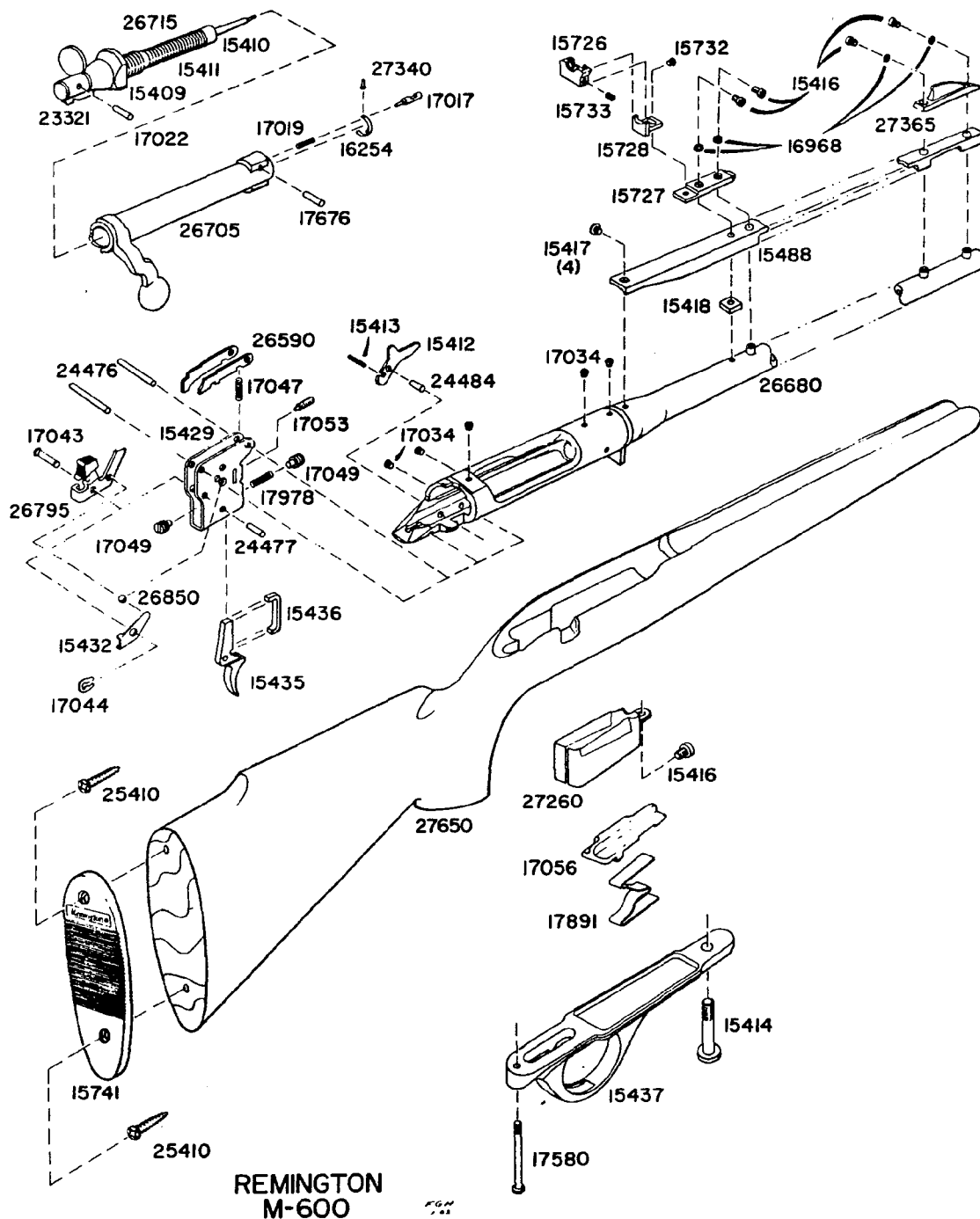
MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Locking	1. Shallow throat.	1. Ream.
	2. Min. head space.	2. Re-head.
	3. Damaged chamber.	3. 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 Blows Cases	1. Oversize chamber.	1. Replace barrel assembly.
	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 reseal in safety pivot pin slot.
	3. Safety damaged.	3. Replace safety.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Accuracy		
- Group Size	1. Crown of barrel damaged.	1. Recrown.
	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	1. Barrel not straight.	1. Straighten or replace barrel.
	2. Improper or loose sights.	2. Tighten or change sights.

REMINGTON FIELD SERVICE MANUAL



REMINGTON
M-600

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MODEL 600 - FIELD SERVICE MANUAL

JUNE - 1965

6-65
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 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.

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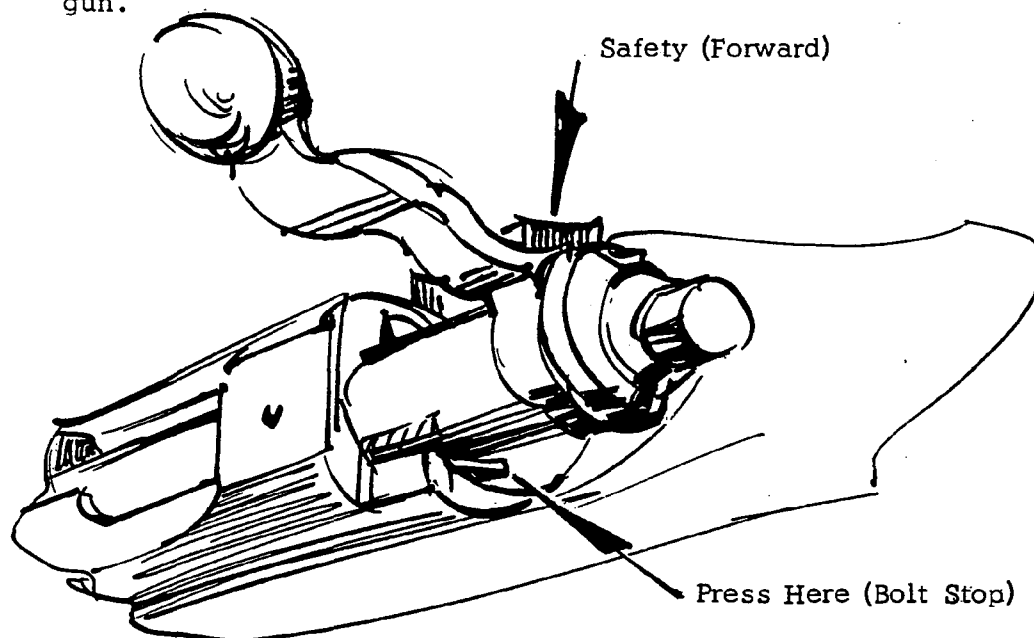
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

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 sketch below. 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; 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.

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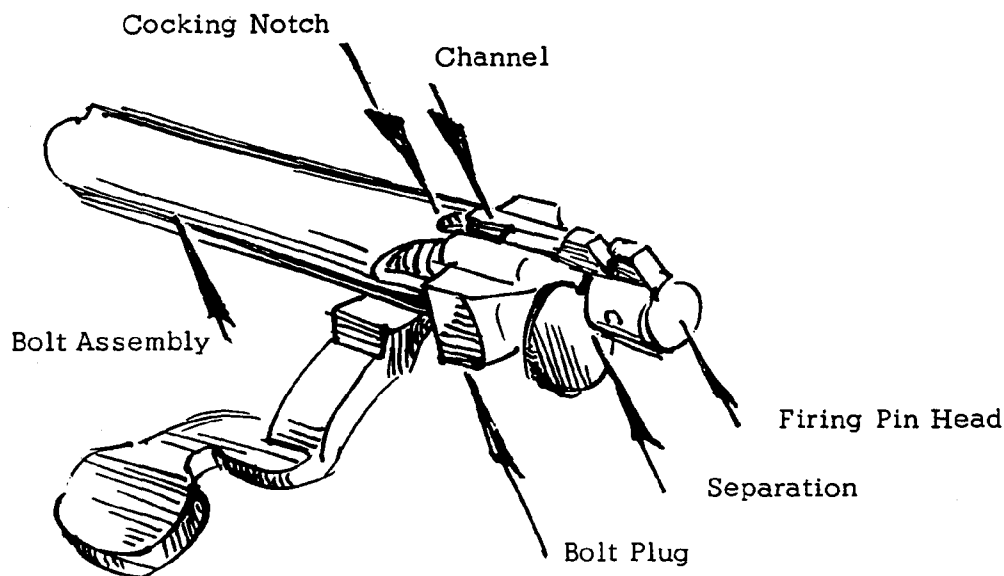
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

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 sketch below). 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.

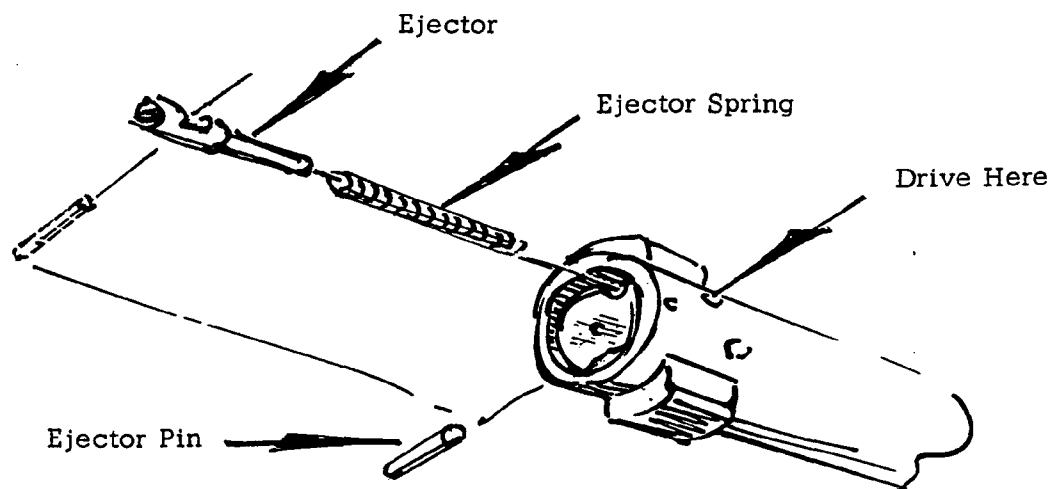


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BOLT FINAL ASSEMBLY - COMPONENTS Continued

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.

To Disassemble - 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.

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.

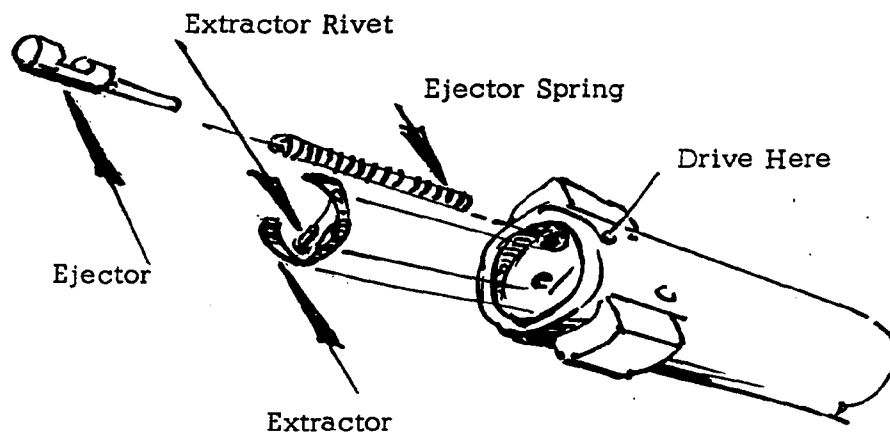
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

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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.

To Disassemble - 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.



To Service - 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.

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.

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MODEL 600
Assembly
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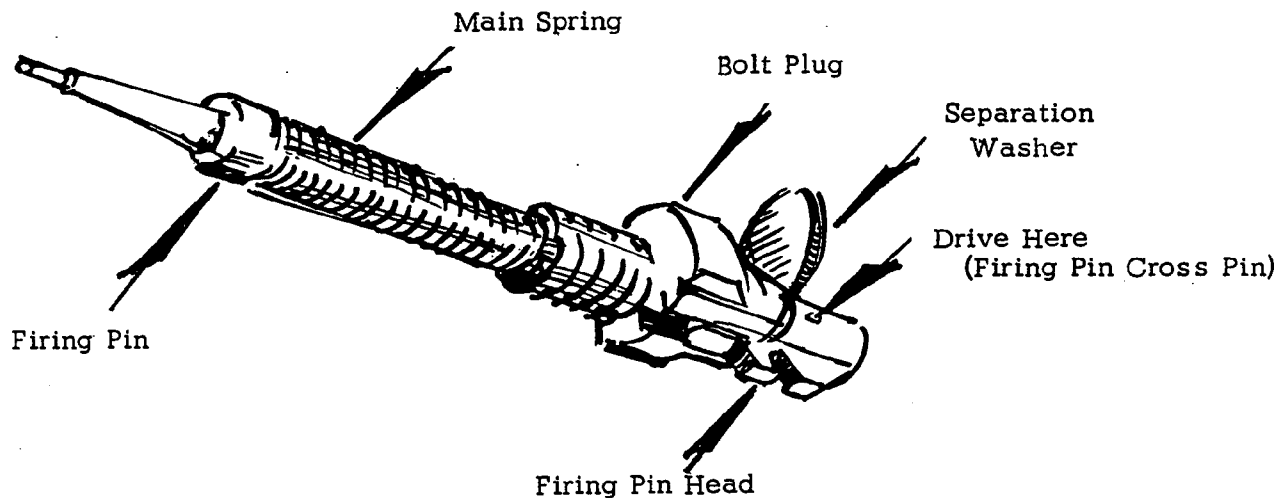
BOLT FINAL ASSEMBLY - COMPONENTS Continued

FIRING PIN ASSEMBLY - COMPONENTS include:

Firing Pin, Main Spring, Bolt Plug, Firing Pin Head,
Firing Pin Cross Pin (In Firing Pin Assembly)

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. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



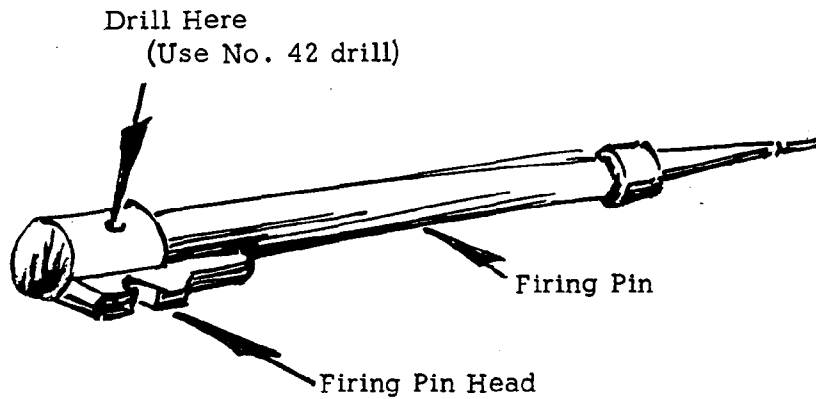
To Service - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

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

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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.



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.

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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 front 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 and 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.

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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.

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

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

To Service - 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.

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 Service - Rib is interchangeable with no adjustment required.

To Reassemble - 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.

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 Service - Interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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.

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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 Service - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

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

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 Service - Interchangeable as replacement. No adjustment required.

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 screw.

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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 Service - Interchangeable as replacement. No adjustment required.

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 Sectional View.

To Service - 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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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. See Sectional View.

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. See Sectional View.

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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 - 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".

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.

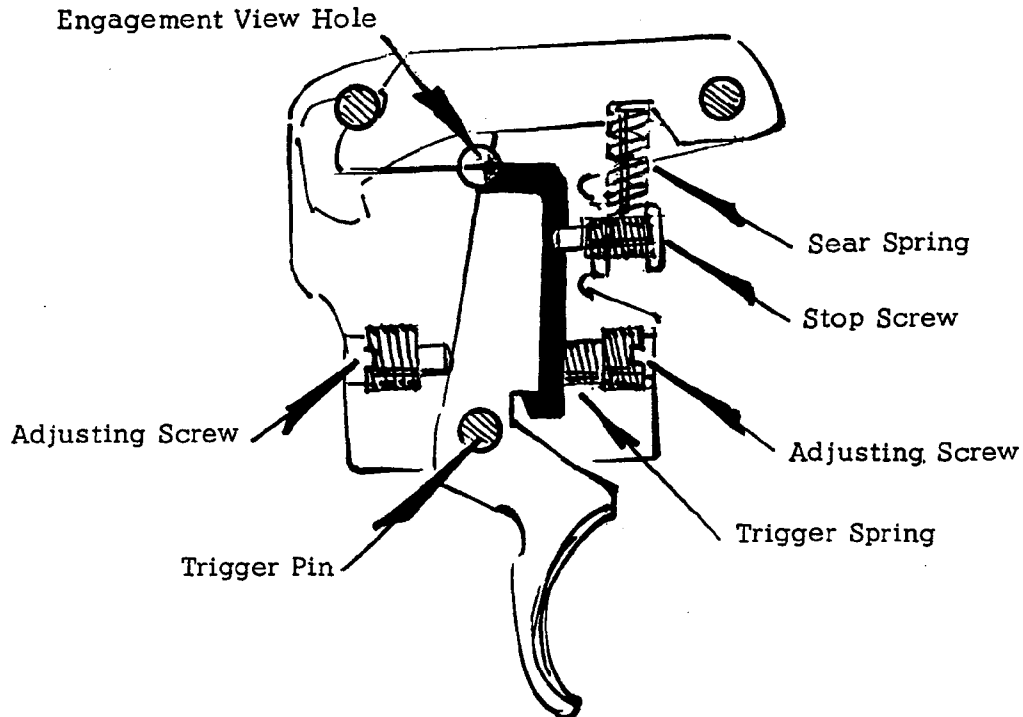
TRIGGER HOUSING - is designed to "house" the components of the Trigger Assembly.

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 Service - Trigger housing interchangeable as replacement. No factory assembly required.

To Reassemble - 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.

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 of pull.

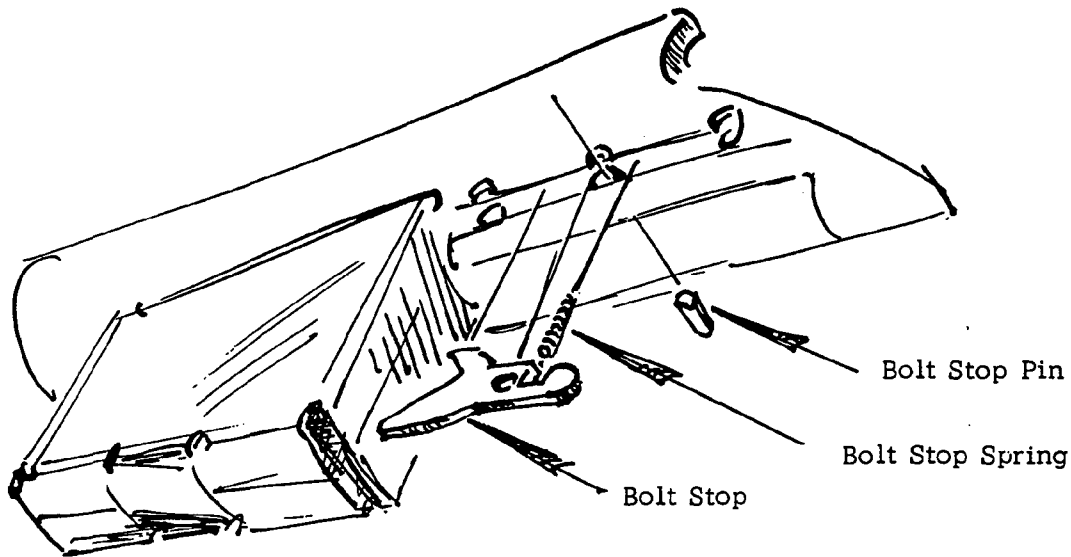
Travel of Trigger - is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off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

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

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 sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Service - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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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.

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.

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.

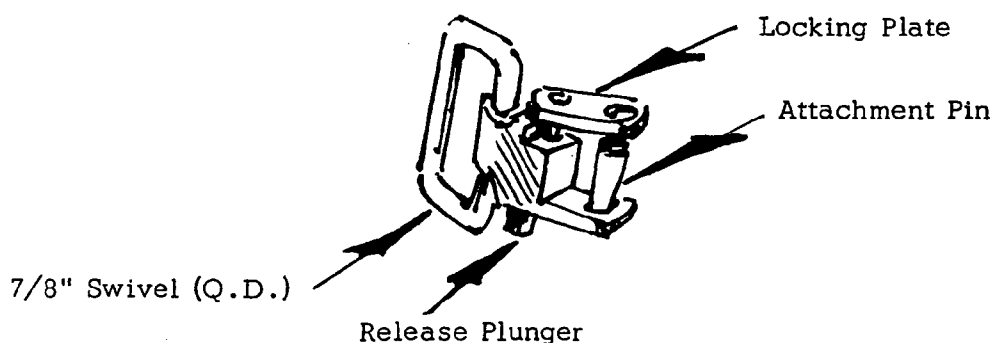
Front Swivel Screw - Use No. 13 drill

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) 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.

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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.

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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

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.

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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.

- - - - -

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>Cause</u>	<u>Correction</u>
Firing	<ol style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. 	<ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition.
Unlocking	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault.
Extraction	<ol style="list-style-type: none"> 1. Fouled, rough, or enlarged chamber. 2. Extractor broken or damaged. 3. Not enough hook space on extractor. 4. Height of claw not correct. 	<ol style="list-style-type: none"> 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.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Bolt Binds	<ol style="list-style-type: none"> 1. Guard screws protrude into bolt track. 2. Receiver plug screws protrude into bolt track. 3. Bolt handle interferes in stock. 4. Damage at rear of bolt lugs. 	<ol style="list-style-type: none"> 1. File ends of screws. 2. File ends of screws. 3. Clear stock or fit new stock. 4. Stone to blend. Check head space.
Ejection	<ol style="list-style-type: none"> 1. Burr at ejector hole in bolt. 2. Ejector binds or fails to retract far enough. 3. Extractor binds. 	<ol style="list-style-type: none"> 1. Deburr. 2. Free up or replace. 3. Adjust or fit new extractor (and rivet).
Bolt Pulls Out	<ol style="list-style-type: none"> 1. Bolt stop or bolt release binds. 2. Bolt stop or bolt release broken. 3. Bolt stop spring damaged. 	<ol style="list-style-type: none"> 1. Free up. 2. Replace. 3. Replace.
Feeding	<ol style="list-style-type: none"> 1. Magazine follower binds. 2. Weak or defective follower spring. 3. Magazine spring caught under guard. 4. Damaged chamfer on bolt head. 5. Tabs on follower bent. 	<ol style="list-style-type: none"> 1. Adjust side angle on magazine. 2. Replace spring. 3. Correct. 4. Replace bolt, or stone smooth. 5. Straighten or replace follower.
Loading	<ol style="list-style-type: none"> 1. Damaged receiver rails. 2. Sharp edge - rear end of chamber. 3. Rough loading ramp in receiver. 	<ol style="list-style-type: none"> 1. Polish or reshape. 2. Remove sharpness. 3. Polish ramp.

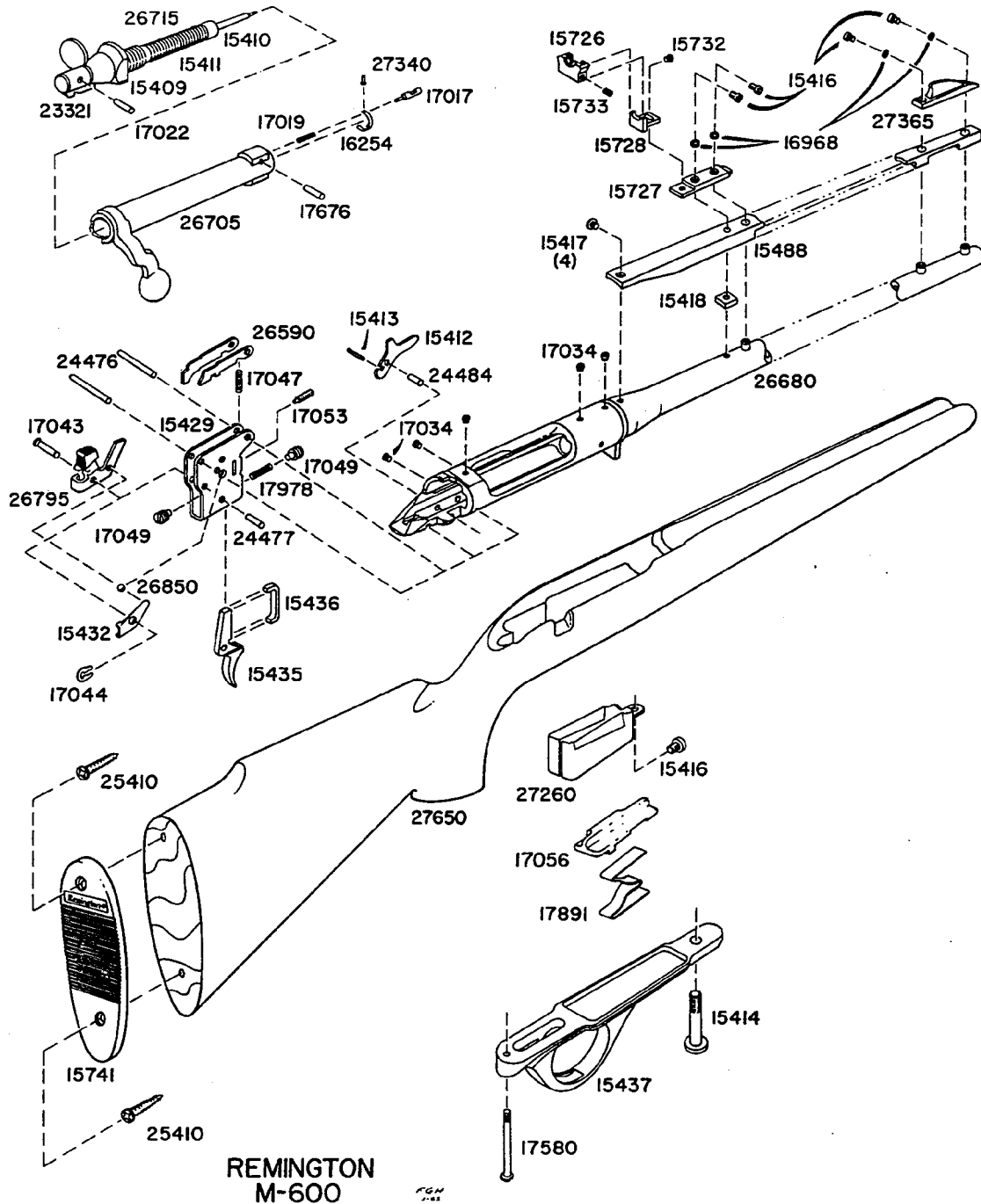
MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Locking	1. Shallow throat.	1. Ream.
	2. Min. head space.	2. Re-head.
	3. Damaged chamber.	3. 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 Blows Cases	1. Oversize chamber.	1. Replace barrel assembly.
	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 reseal in safety pivot pin slot.
	3. Safety damaged.	3. Replace safety.

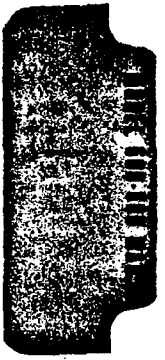
MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Accuracy		
- Group Size	1. Crown of barrel damaged.	1. Recrown.
	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	1. Barrel not straight.	1. Straighten or replace barrel.
	2. Improper or loose sights.	2. Tighten or change sights.

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1965

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 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.

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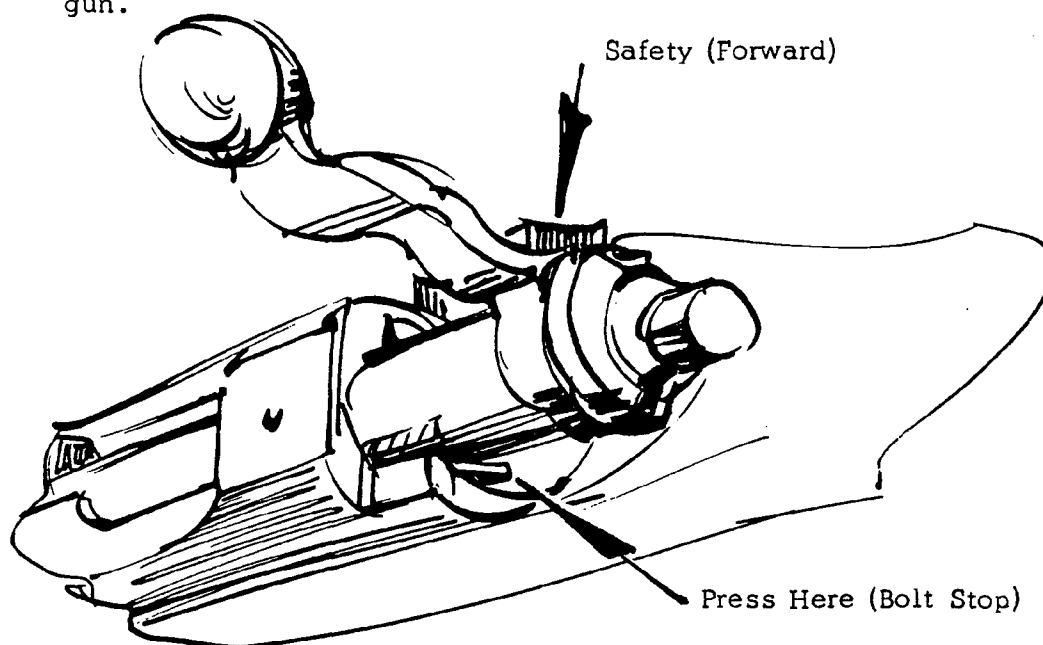
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

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 sketch below. 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; 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.

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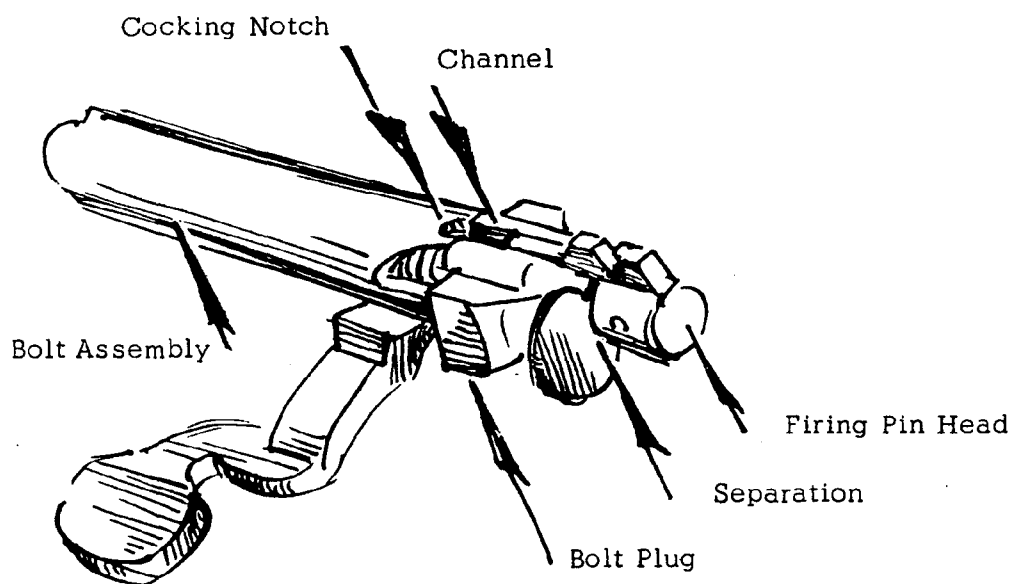
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

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 sketch below). 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.



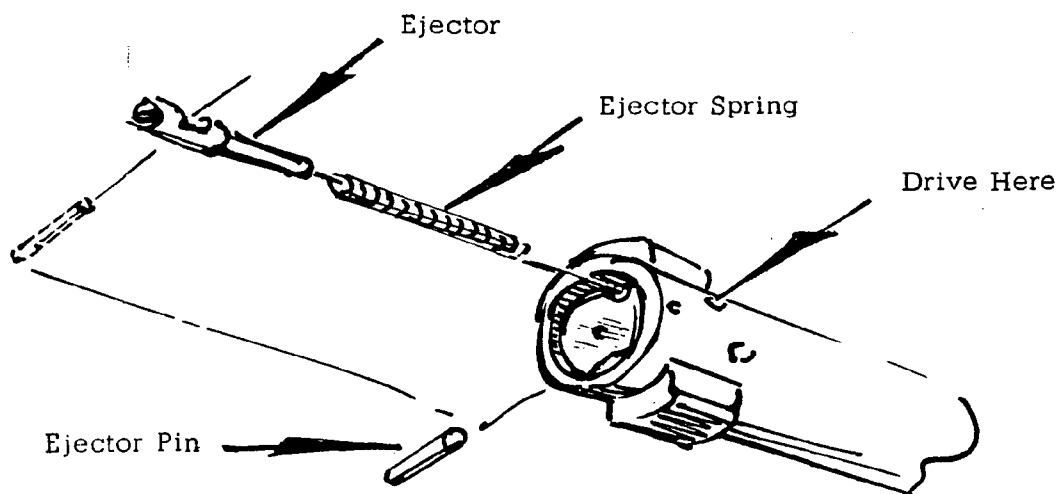
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BOLT FINAL ASSEMBLY - COMPONENTS Continued

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.

To Disassemble - 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.

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.

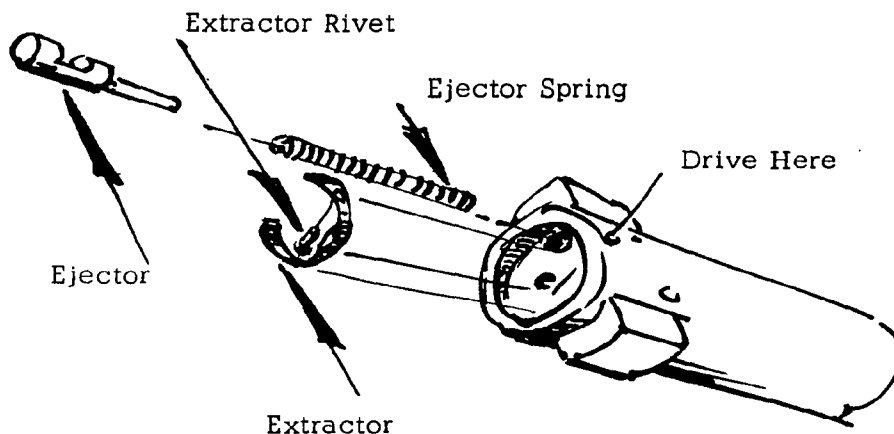
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

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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.

To Disassemble - 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.



To Service - 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.

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.

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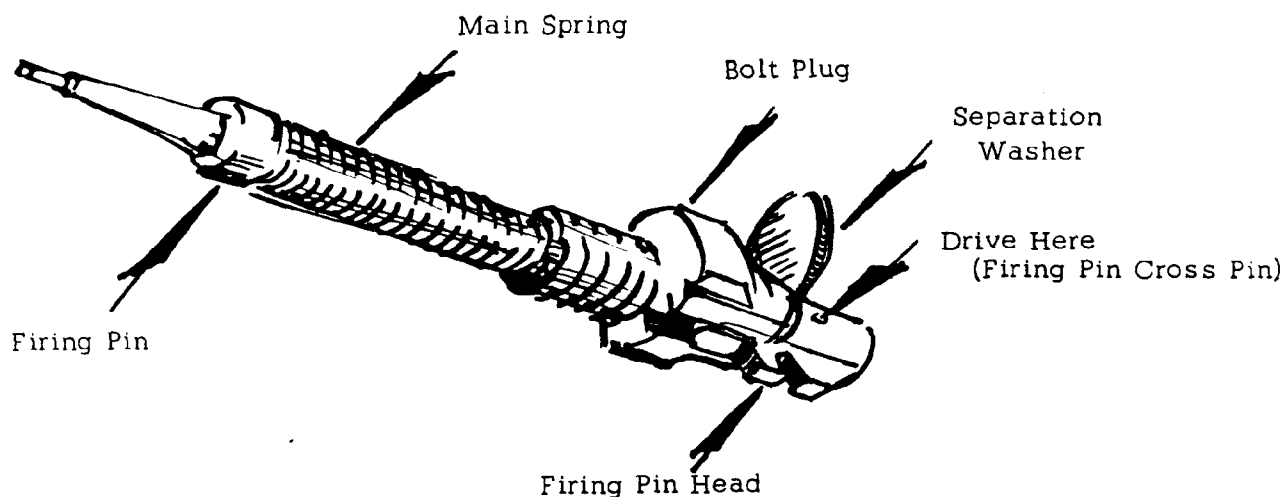
BOLT FINAL ASSEMBLY - COMPONENTS Continued

FIRING PIN ASSEMBLY - COMPONENTS include:

Firing Pin, Main Spring, Bolt Plug, Firing Pin Head,
Firing Pin Cross Pin (In Firing Pin Assembly)

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. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



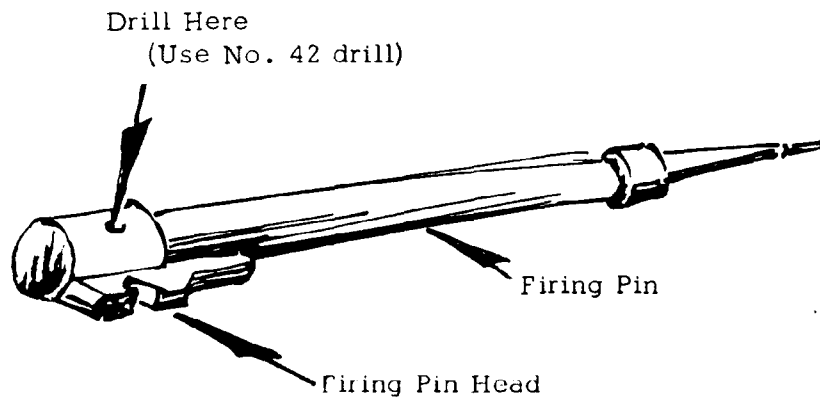
To Service - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

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

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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.



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.

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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 front 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 and 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.

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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.

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

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

To Service - 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.

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 Service - Rib is interchangeable with no adjustment required.

To Reassemble - 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.

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 Service - Interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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.

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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 Service - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

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

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 Service - Interchangeable as replacement. No adjustment required.

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 screw.

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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 Service - Interchangeable as replacement. No adjustment required.

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 Sectional View.

To Service - 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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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. See Sectional View.

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. See Sectional View.

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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 - 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".

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

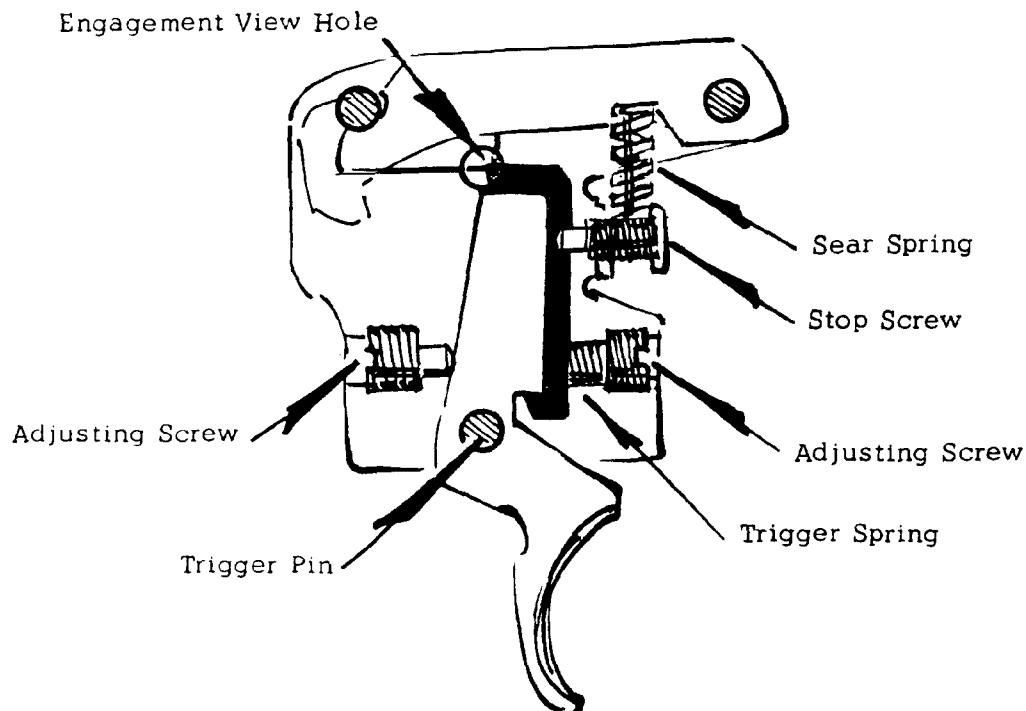
To Disassemble - Remove stock assembly. Remove sear pins to disassemble trigger assembly from receiver. Disassemble safety assembly, sear and safety cam assembly, sear spring, trigger, trigger connector, trigger spring, trigger adjusting screw (2), trigger stop screw.

To Service - Trigger housing interchangeable as replacement. No factory assembly required.

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To Reassemble - 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.

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 of pull.

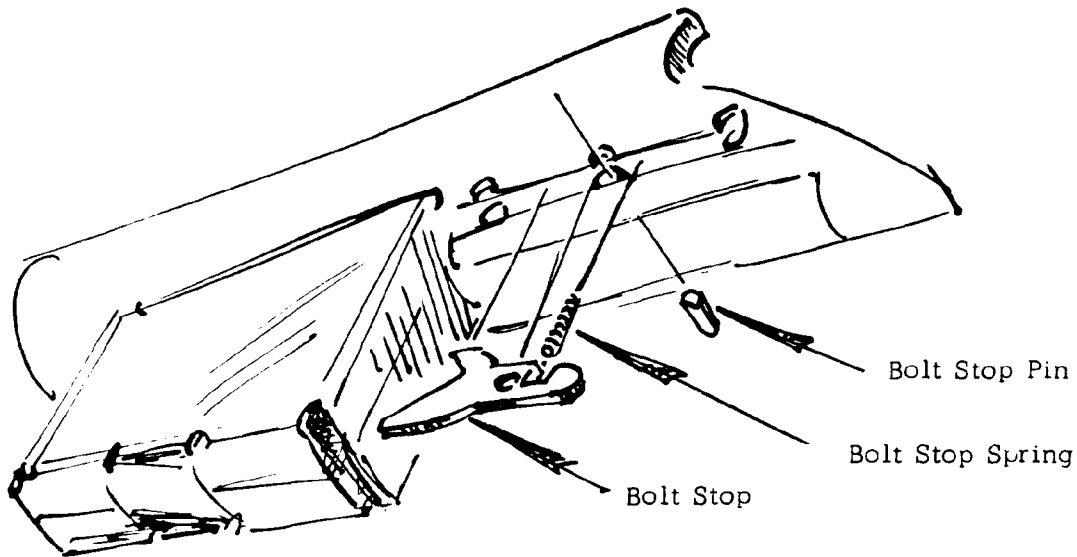
Travel of Trigger - is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off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

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MODEL 600
Assembly
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BOLT STOP - is designed to limit rearward travel of bolt final assembly in receiver as action is opened.

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 sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Service - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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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.

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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MODEL 600
Assembly
17

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

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

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) 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.

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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.

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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

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.

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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

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Firing	<ol style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. 	<ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition.
Unlocking	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault.
Extraction	<ol style="list-style-type: none"> 1. Fouled, rough, or enlarged chamber. 2. Extractor broken or damaged. 3. Not enough hook space on extractor. 4. Height of claw not correct. 	<ol style="list-style-type: none"> 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.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Bolt Binds	<ol style="list-style-type: none"> 1. Guard screws protrude into bolt track. 2. Receiver plug screws protrude into bolt track. 3. Bolt handle interferes in stock. 4. Damage at rear of bolt lugs. 	<ol style="list-style-type: none"> 1. File ends of screws. 2. File ends of screws. 3. Clear stock or fit new stock. 4. Stone to blend. Check head space.
Ejection	<ol style="list-style-type: none"> 1. Burr at ejector hole in bolt. 2. Ejector binds or fails to retract far enough. 3. Extractor binds. 	<ol style="list-style-type: none"> 1. Deburr. 2. Free up or replace. 3. Adjust or fit new extractor (and rivet).
Bolt Pulls Out	<ol style="list-style-type: none"> 1. Bolt stop or bolt release binds. 2. Bolt stop or bolt release broken. 3. Bolt stop spring damaged. 	<ol style="list-style-type: none"> 1. Free up. 2. Replace. 3. Replace.
Feeding	<ol style="list-style-type: none"> 1. Magazine follower binds. 2. Weak or defective follower spring. 3. Magazine spring caught under guard. 4. Damaged chamfer on bolt head. 5. Tabs on follower bent. 	<ol style="list-style-type: none"> 1. Adjust side angle on magazine. 2. Replace spring. 3. Correct. 4. Replace bolt, or stone smooth. 5. Straighten or replace follower.
Loading	<ol style="list-style-type: none"> 1. Damaged receiver rails. 2. Sharp edge - rear end of chamber. 3. Rough loading ramp in receiver. 	<ol style="list-style-type: none"> 1. Polish or reshape. 2. Remove sharpness. 3. Polish ramp.

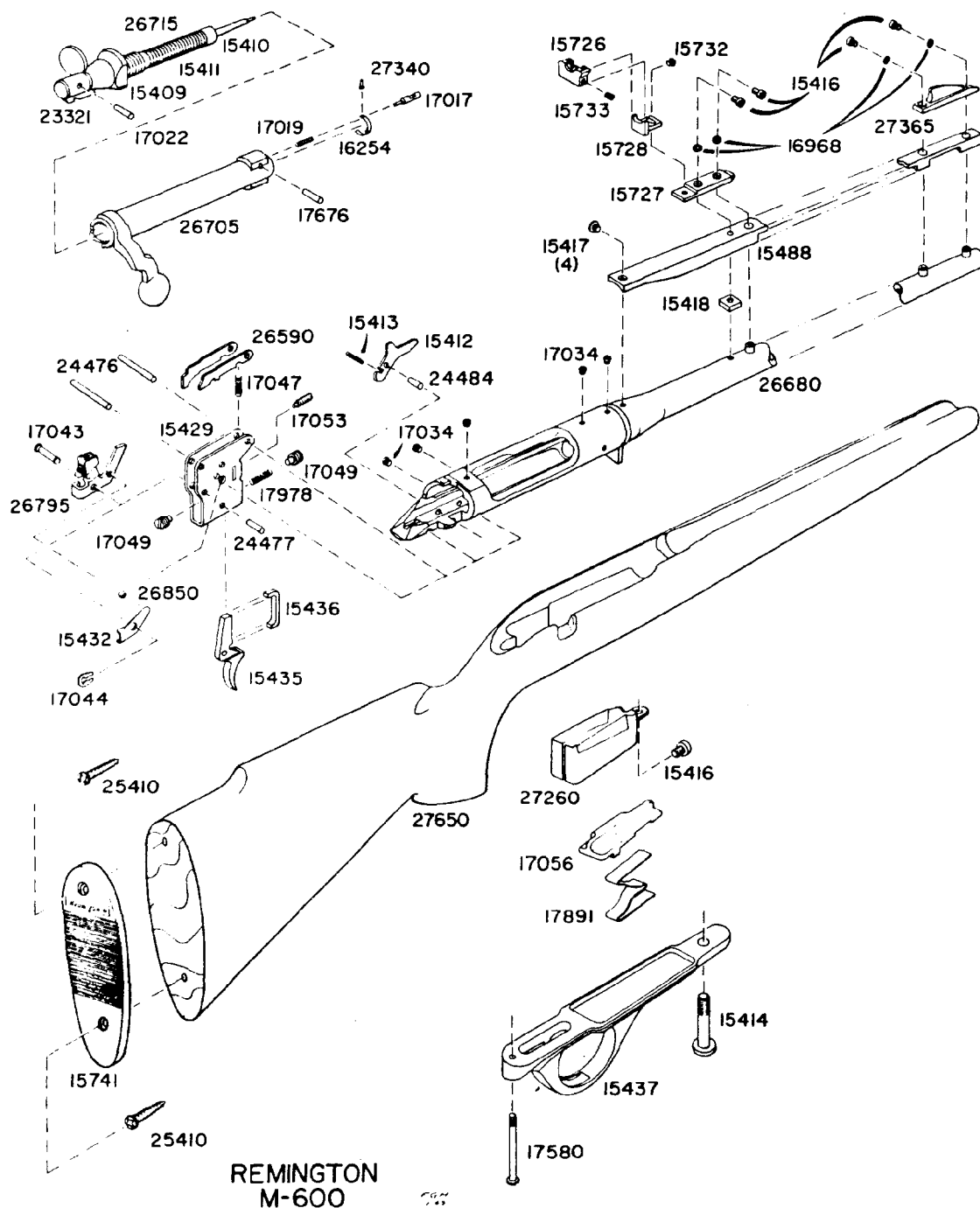
MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Locking	1. Shallow throat.	1. Ream.
	2. Min. head space.	2. Re-head.
	3. Damaged chamber.	3. 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 Blows Cases	1. Oversize chamber.	1. Replace barrel assembly.
	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 reseal in safety pivot pin slot.
	3. Safety damaged.	3. Replace safety.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

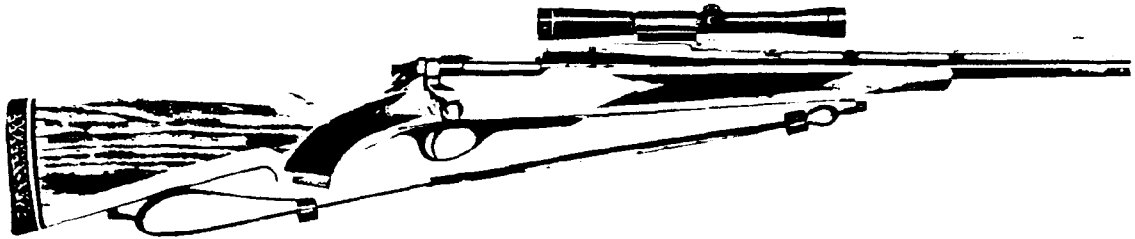
<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Accuracy		
- Group Size	1. Crown of barrel damaged. 2. Barrel bore fouled. 3. Enlarged bore. 4. Improper bedding of barrel in stock. 5. Loose sights.	1. Recrown. 2. Lead or replace barrel. 3. Replace barrel. 4. Refloat barrel. 5. Tighten or replace.
-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

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.

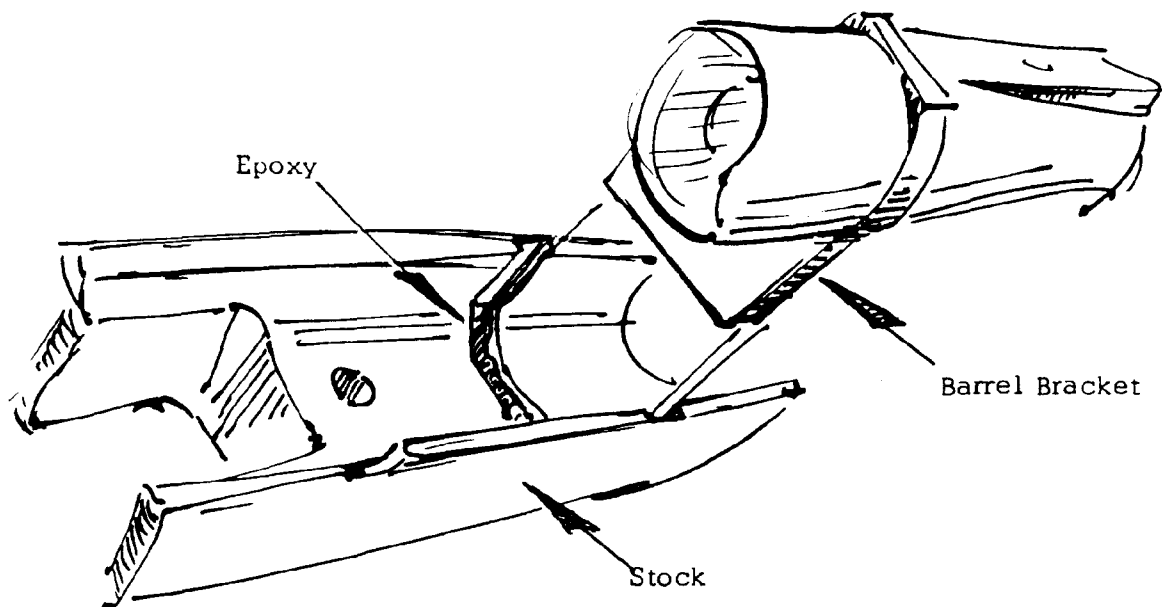
MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

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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. See Sketch.



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.

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STOCK ASSEMBLY - Continued

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. 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.

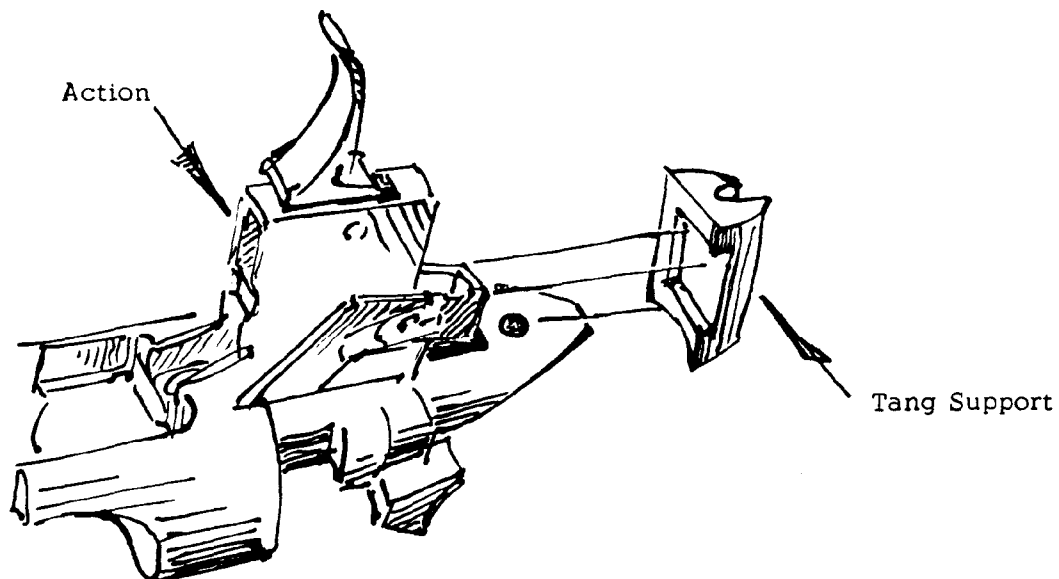
To Disassemble - Remove stock assembly. Remove loosened tang support from rear of action.

To Service - Replacement tang supports are interchangeable with no adjustment required.

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TANG SUPPORT - Continued

To Reassemble - 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.

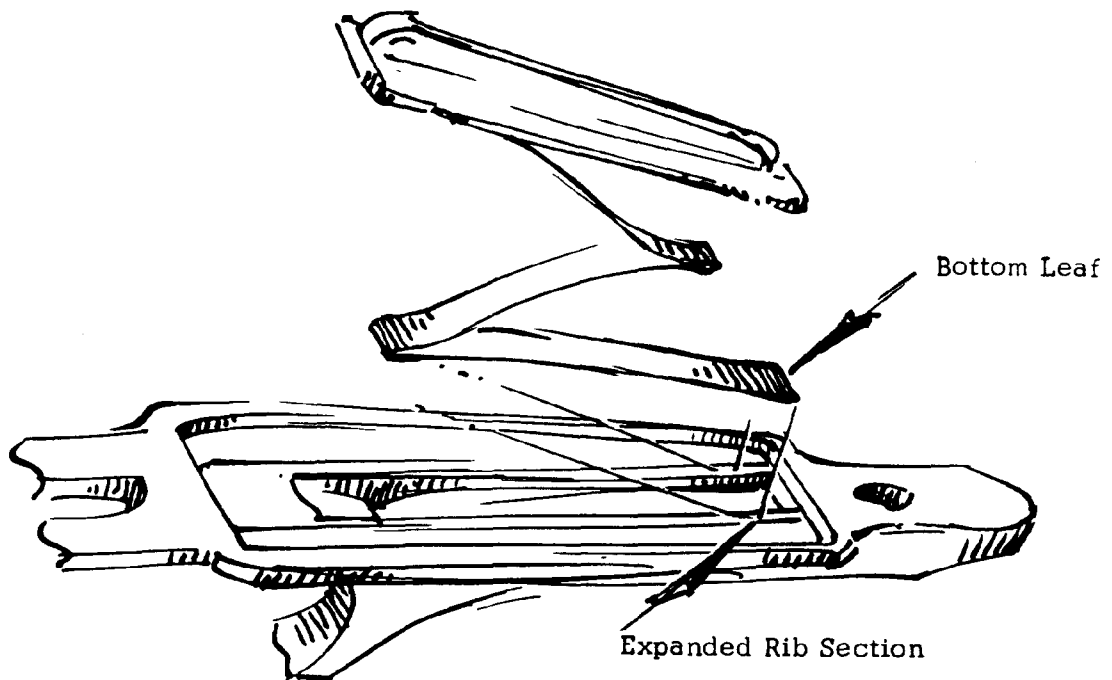
To Disassemble - Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

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 without expanded rib section on Standard Model 600.

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TRIGGER GUARD - Continued

To Reassemble - 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.

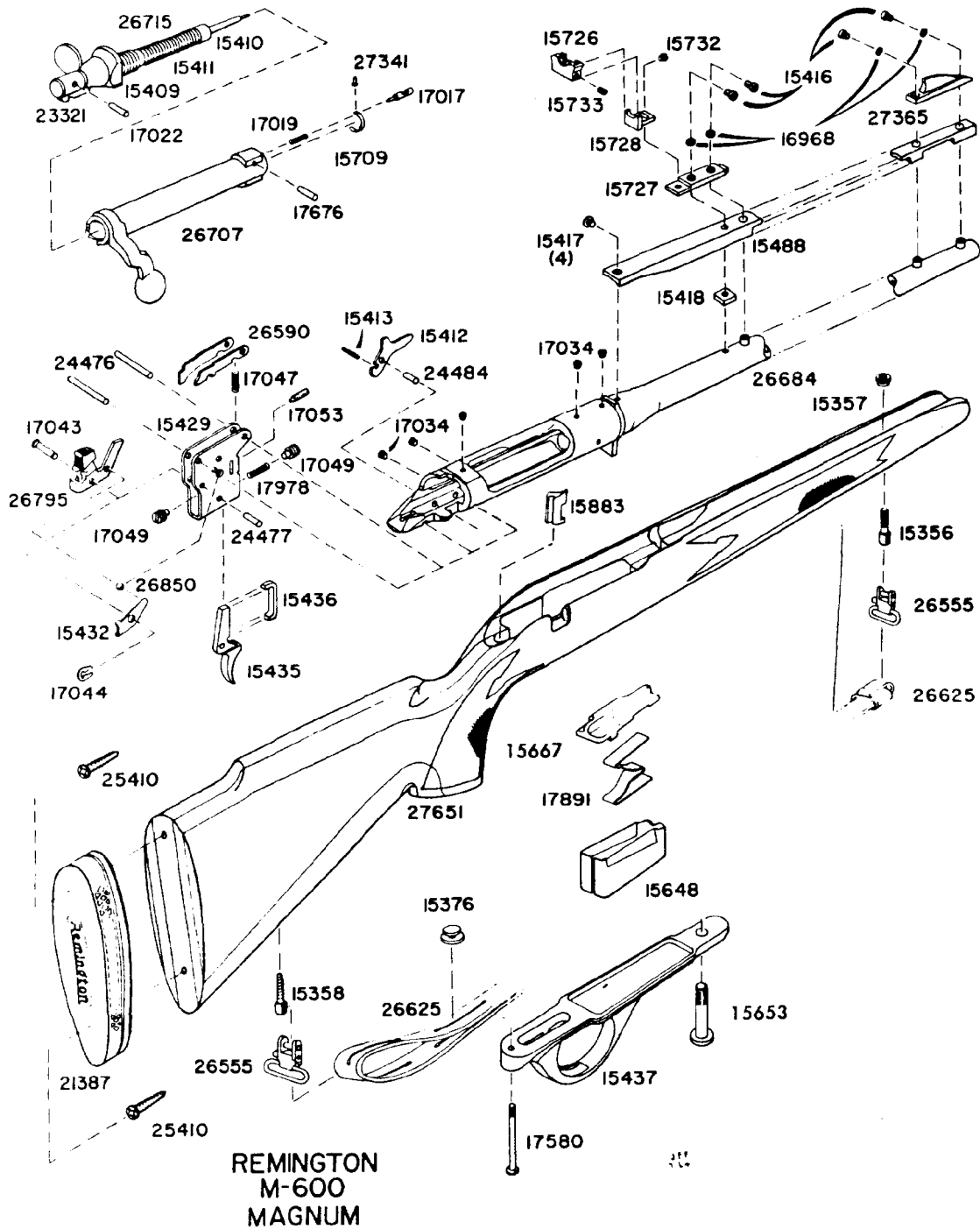
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MAGAZINE (marked **MAGNUM**) - is designed for **MAGNUM** model use only.
Do not use for Standard Model 600.

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.

To Reassemble - 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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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.

EXHIBIT "E" 

1965

MODEL 600

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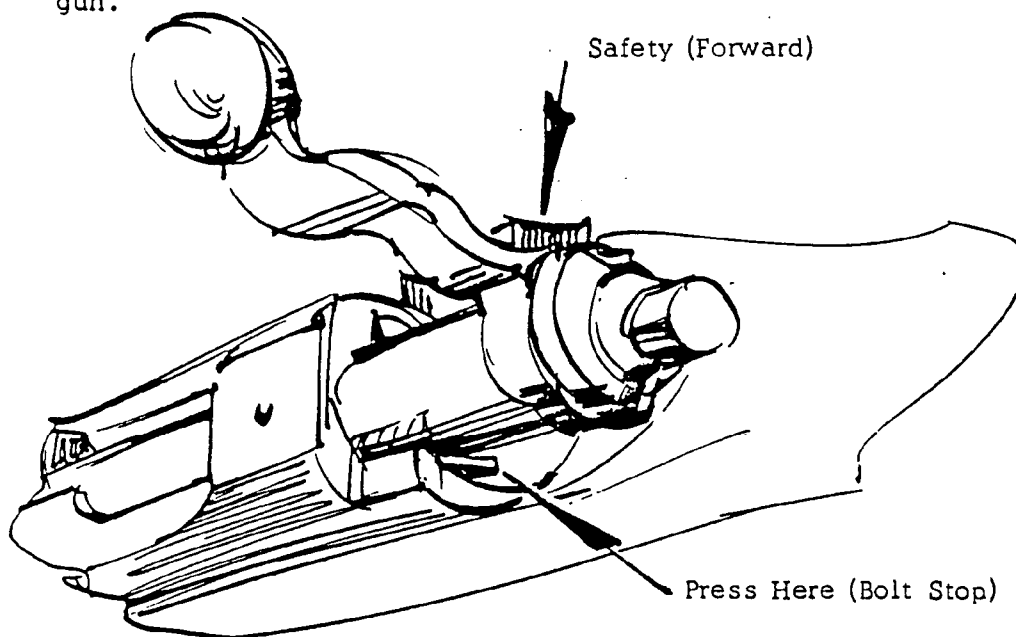
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BOLT FINAL ASSEMBLY - is designed (1) to close and lock action against chambered round in barrel for firing, and (2) contain the firing, extraction, ejection, and cocking parts.

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 sketch below. 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; 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.

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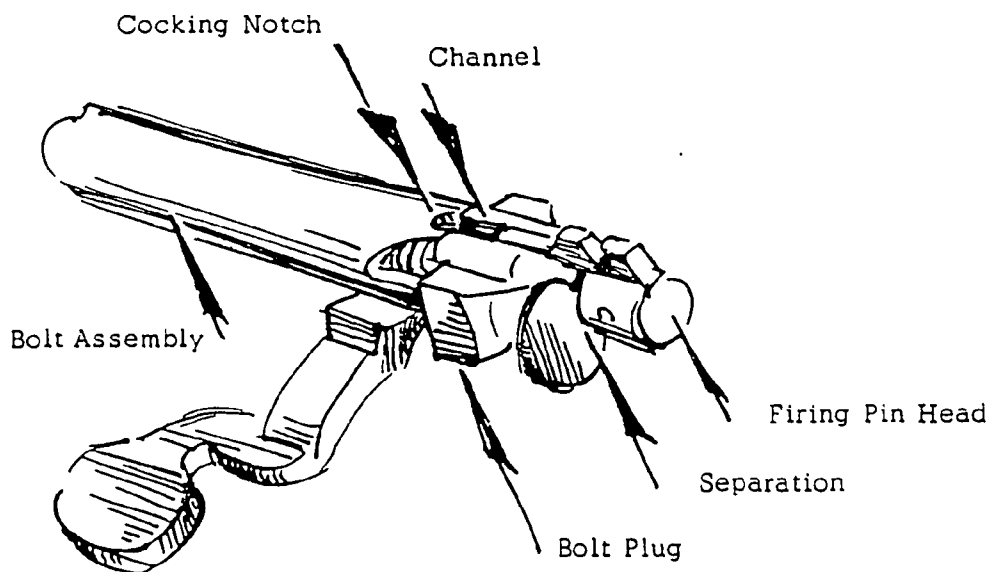
BOLT FINAL ASSEMBLY - COMPONENTS - Include Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly - which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

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 sketch below). 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.

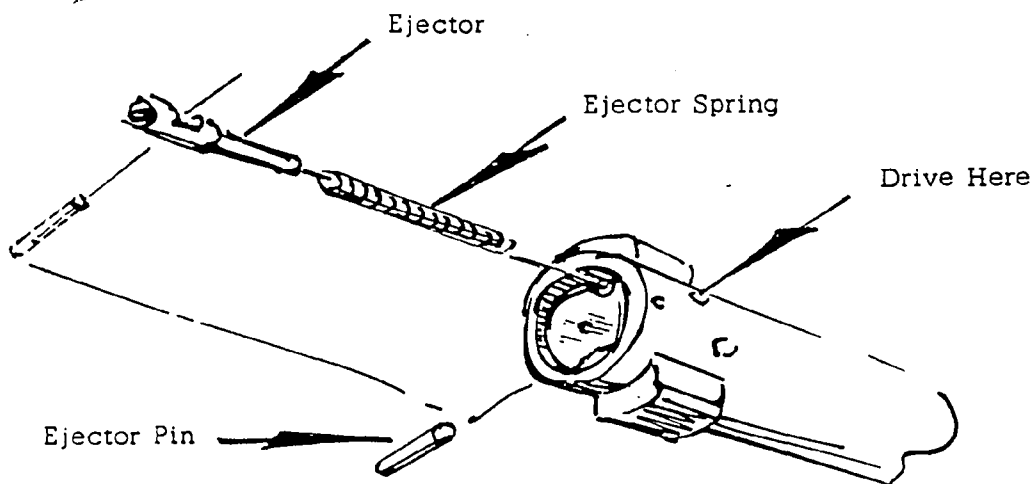


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BOLT FINAL ASSEMBLY - COMPONENTS Continued

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.

To Disassemble - 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.

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.

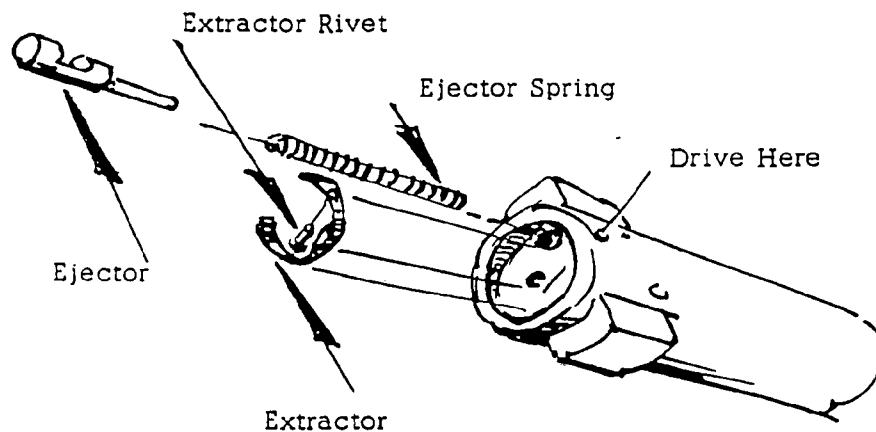
Note: Ejector, when reassembled, must have free plunging motion for proper ejection operation.

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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.

To Disassemble - 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.



To Service - 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.

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.

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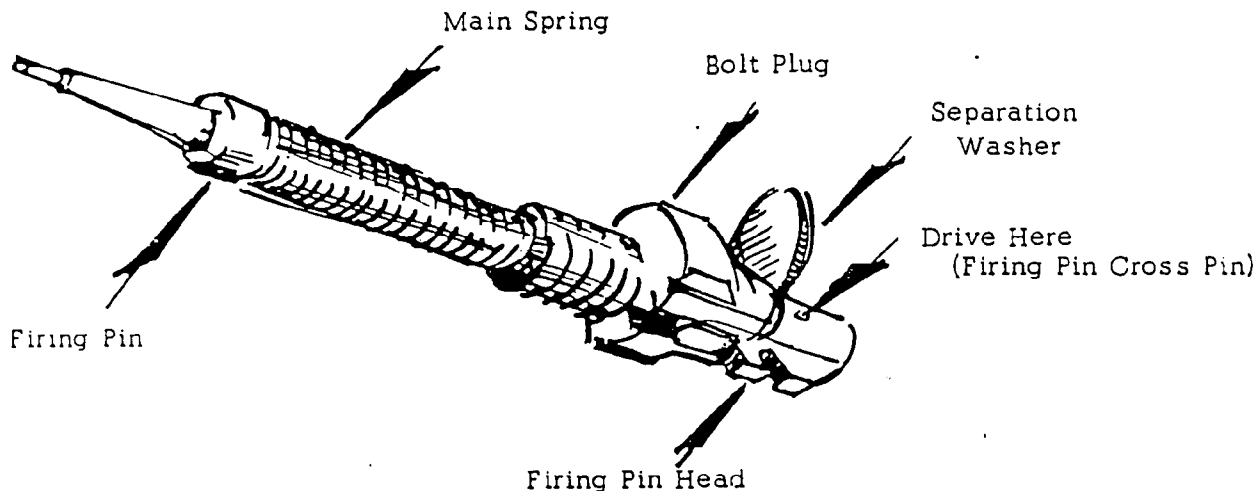
BOLT FINAL ASSEMBLY - COMPONENTS Continued

FIRING PIN ASSEMBLY - COMPONENTS include:

Firing Pin, Main Spring, Bolt Plug, Firing Pin Head,
Firing Pin Cross Pin (In Firing Pin Assembly)

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. See sketch below. All parts of firing pin assembly should separate for disassembly.

Precaution: Main spring is under tension.



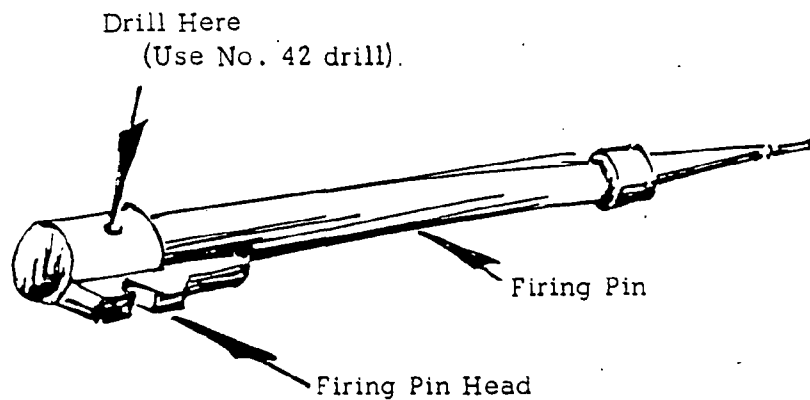
To Service - All parts in firing pin assembly are interchangeable. No factory fitting required. However, if replacing firing pin, a hole drilling operation in shank of firing pin is necessary. To do this, use a No. 42 size drill (.093").

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

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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.



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.

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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 front 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 and 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.

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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.

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

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

To Service - 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.

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 Service - Rib is interchangeable with no adjustment required.

To Reassemble - 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.

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 Service - Interchangeable as replacement. No adjustment required.

To Reassemble - 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.

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.

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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 Service - Interchangeable as replacement. No adjustment required. Magazine assembly is factory listed to include magazine and magazine support.

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

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 Service - Interchangeable as replacement. No adjustment required.

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 screw.

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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 Service - Interchangeable as replacement. No adjustment required.

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 Sectional View.

To Service - 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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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. See Sectional View.

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. See Sectional View.

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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 - 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".

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

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.

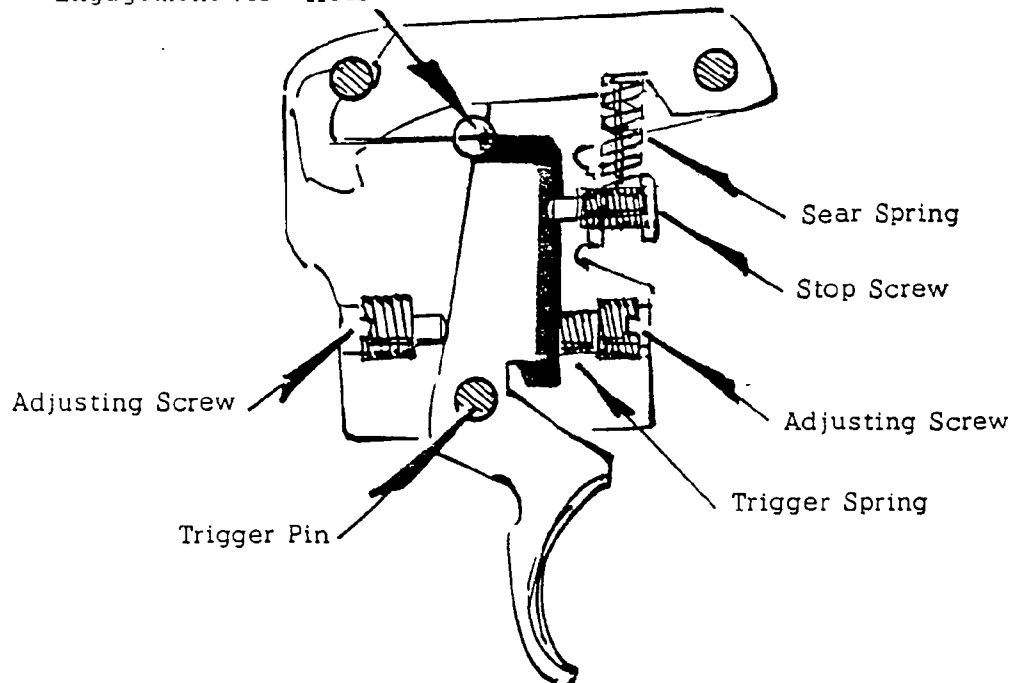
To Service - Trigger housing interchangeable as replacement. No factory assembly required.

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

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

Engagement View Hole



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.

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 of pull.

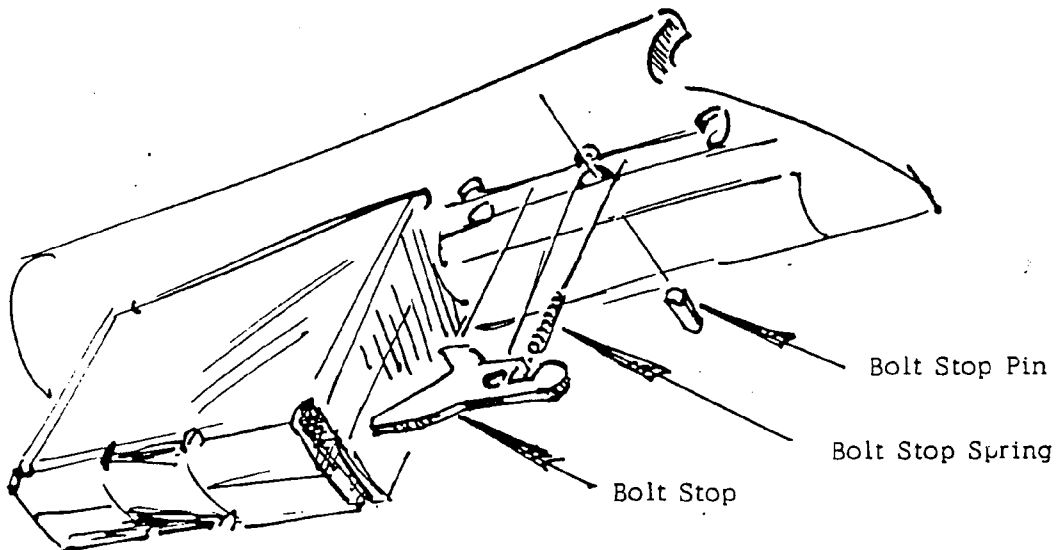
Travel of Trigger - is adjusted by turning trigger stop screw in front of housing. To reduce trigger travel, place bolt in receiver to "cock" action. Then (1) turn trigger stop screw inward or clockwise until firing pin will not fall or gun "fire" as trigger is pulled; (2) Cock gun again and back off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

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

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 sketch below. Tap out bolt stop pin. Disassemble bolt stop and bolt stop spring.



To Service - Bolt stop and bolt stop spring interchangeable as replacement. No adjustment required.

To Reassemble - 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

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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.

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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MODEL 600
Assembly
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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

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

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) 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.

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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.

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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

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.

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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.

- - - - -

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>Cause</u>	<u>Correction</u>
Firing	<ol style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. 	<ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition.
Unlocking	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault.
Extraction	<ol style="list-style-type: none"> 1. Fouled, rough, or enlarged chamber. 2. Extractor broken or damaged. 3. Not enough hook space on extractor. 4. Height of claw not correct. 	<ol style="list-style-type: none"> 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.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Bolt Binds	<ol style="list-style-type: none"> 1. Guard screws protrude into bolt track. 2. Receiver plug screws protrude into bolt track. 3. Bolt handle interferes in stock. 4. Damage at rear of bolt lugs. 	<ol style="list-style-type: none"> 1. File ends of screws. 2. File ends of screws. 3. Clear stock or fit new stock. 4. Stone to blend. Check head space.
Ejection	<ol style="list-style-type: none"> 1. Burr at ejector hole in bolt. 2. Ejector binds or fails to retract far enough. 3. Extractor binds. 	<ol style="list-style-type: none"> 1. Deburr. 2. Free up or replace. 3. Adjust or fit new extractor (and rivet).
Bolt Pulls Out	<ol style="list-style-type: none"> 1. Bolt stop or bolt release binds. 2. Bolt stop or bolt release broken. 3. Bolt stop spring damaged. 	<ol style="list-style-type: none"> 1. Free up. 2. Replace. 3. Replace.
Feeding	<ol style="list-style-type: none"> 1. Magazine follower binds. 2. Weak or defective follower spring. 3. Magazine spring caught under guard. 4. Damaged chamfer on bolt head. 5. Tabs on follower bent. 	<ol style="list-style-type: none"> 1. Adjust side angle on magazine. 2. Replace spring. 3. Correct. 4. Replace bolt, or stone smooth. 5. Straighten or replace follower.
Loading	<ol style="list-style-type: none"> 1. Damaged receiver rails. 2. Sharp edge - rear end of chamber. 3. Rough loading ramp in receiver. 	<ol style="list-style-type: none"> 1. Polish or reshape. 2. Remove sharpness. 3. Polish ramp.

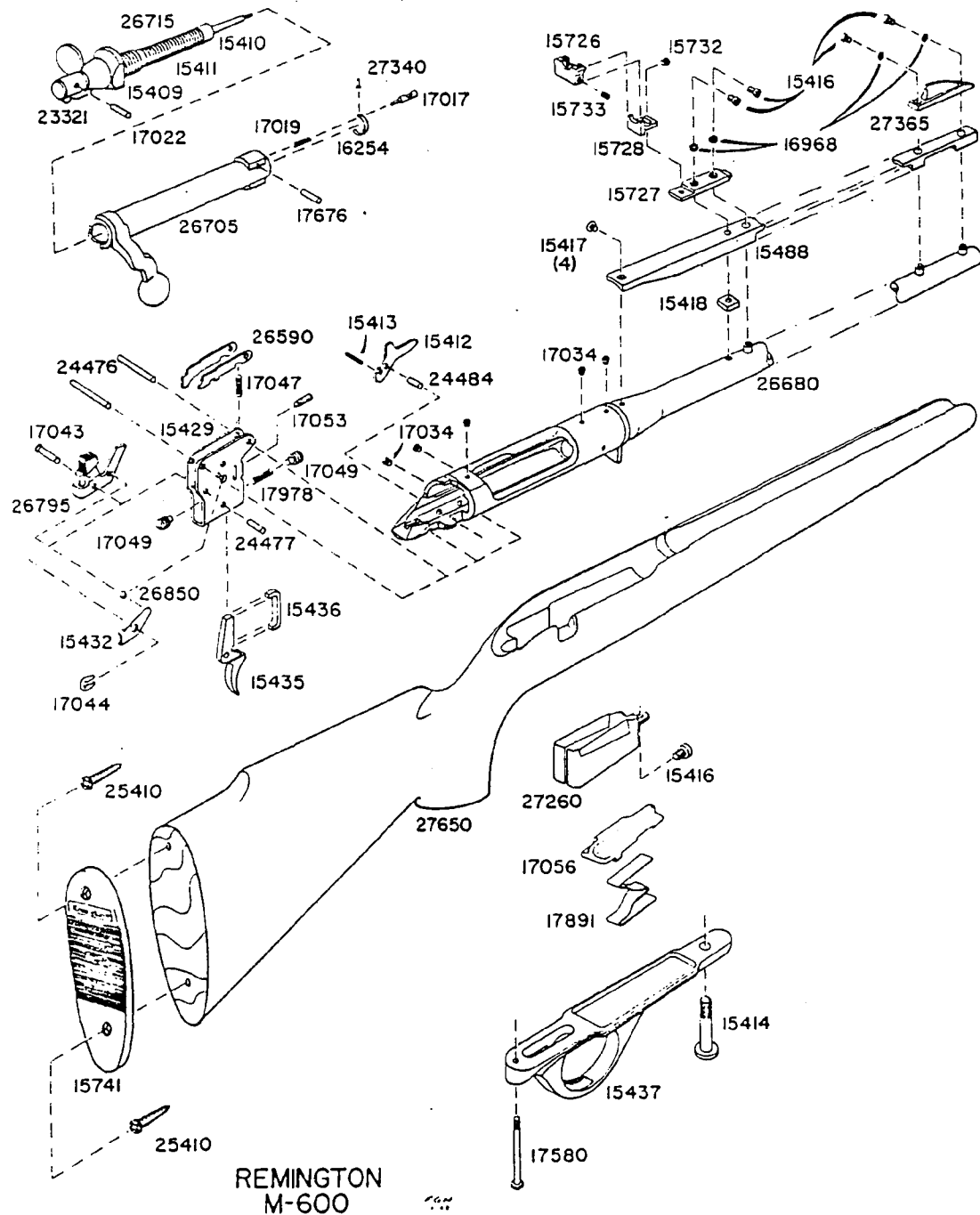
MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION
(Continued)

<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Locking	<ol style="list-style-type: none"> 1. Shallow throat. 2. Min. head space. 3. Damaged chamber. 4. Extractor interferes with shell rim. 5. Ejector binds or fails to retract far enough. 6. Burr at ejector hole in bolt. 7. Sharp corners in bolt lugs. 	<ol style="list-style-type: none"> 1. Ream. 2. Re-head. 3. Re-head. 4. Fit new extractor (grind relief in new extractor behind claw). 5. Free up or replace. 6. Deburr. 7. Stone radius.
Cocking (see Trigger Adjustment)	<ol style="list-style-type: none"> 1. Trigger adjusting screw at 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. 	<ol style="list-style-type: none"> 1. Adjust. 2. Fit new trigger assembly. 3. Fit new trigger assembly. 4. Fit new sear and safety cam or connector.
Bulges or Blows Cases	<ol style="list-style-type: none"> 1. Oversize chamber. 2. Max. head space. 	<ol style="list-style-type: none"> 1. Replace barrel assembly. 2. Fit new bolt.
Safety	<ol style="list-style-type: none"> 1. Safe binds (safe works hard). 2. Safety snap washer stretched out (safe works too freely). 3. Safety damaged. 	<ol style="list-style-type: none"> 1. Free up. 2. Replace washer or reseal in safety pivot pin slot. 3. Replace safety.

MALFUNCTIONS, POSSIBLE CAUSE AND CORRECTION (Continued)

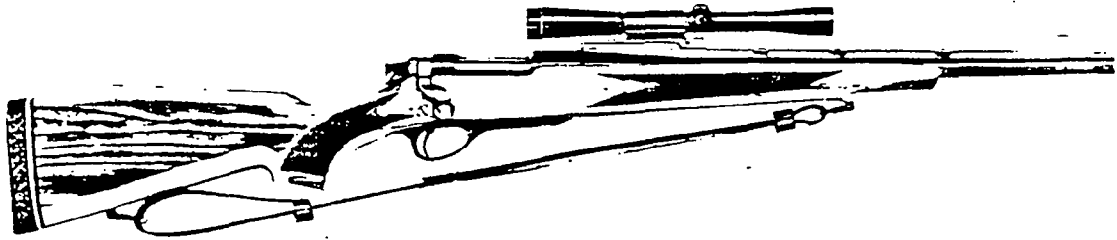
<u>Malfunction</u>	<u>Cause</u>	<u>Correction</u>
Accuracy		
- Group Size	1. Crown of barrel damaged.	1. Recrown.
	2. Barrel bore fouled.	2. Lead or replace barrel.
	3. Enlarged bore.	3. Replace barrel.
	4. Improper bedding of barrel in stock.	4. Refloat barrel.
	5. Loose sights.	5. Tighten or replace.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

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.

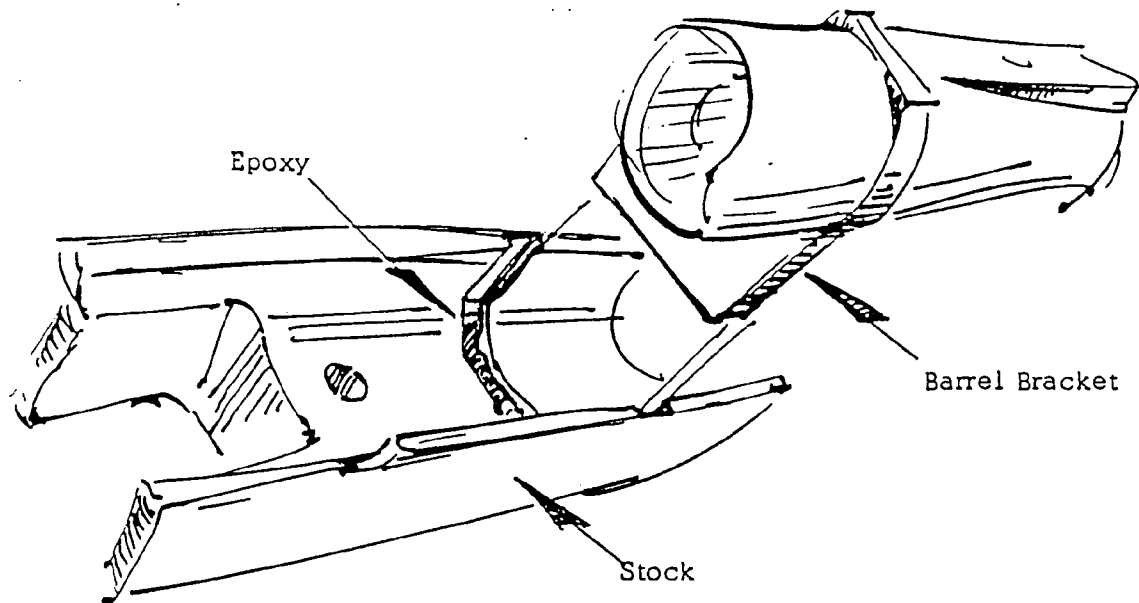
This SERVICE SUPPLEMENT for the Model 600 MAGNUM Carbine will list only those parts that require different assembly instructions from Standard Model 600. See Standard Model 600 for parts not listed.

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

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.

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. See Sketch.



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.

REMINGTON
FIELD SERVICE MANUAL

STOCK ASSEMBLY - Continued

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. 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.

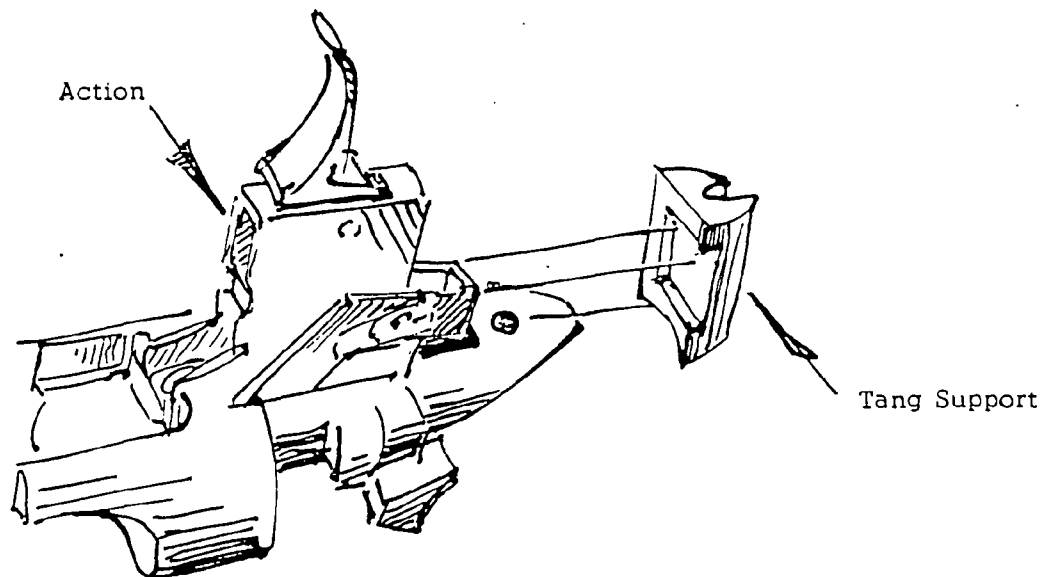
To Disassemble - Remove stock assembly. Remove loosened tang support from rear of action.

To Service - Replacement tang supports are interchangeable with no adjustment required.

REMINGTON
FIELD SERVICE MANUAL

TANG SUPPORT - Continued

To Reassemble - 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.

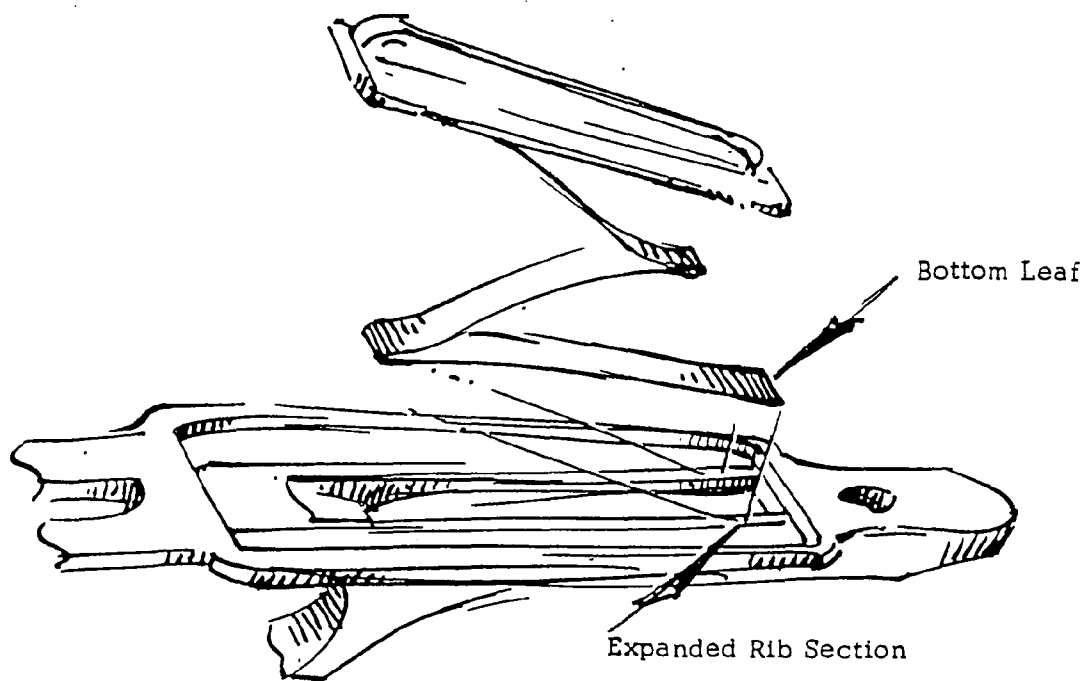
To Disassemble - Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

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 without expanded rib section on Standard Model 600.

REMINGTON
FIELD SERVICE MANUAL

TRIGGER GUARD - Continued

To Reassemble - 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.

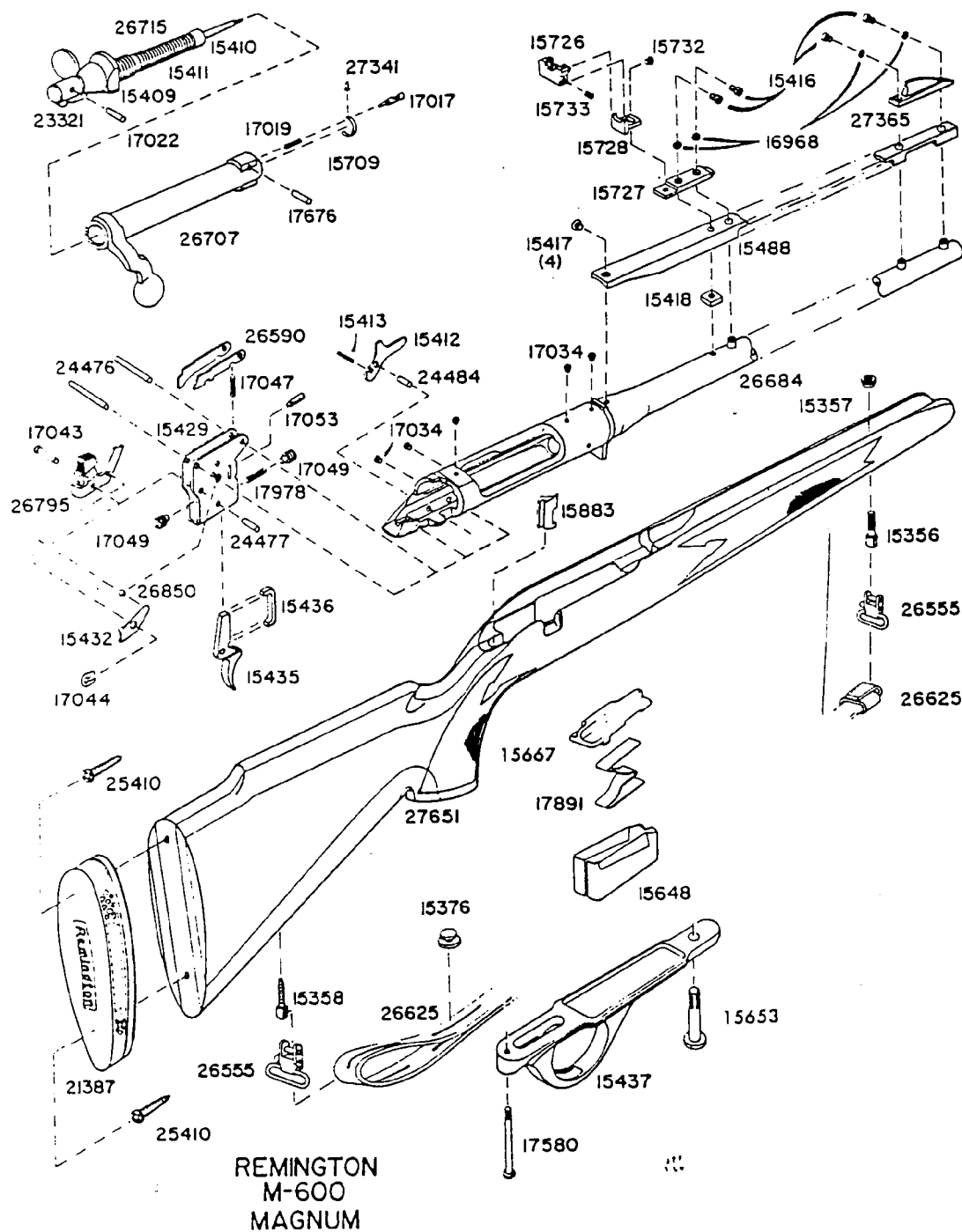
REMINGTON
FIELD SERVICE MANUAL

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.

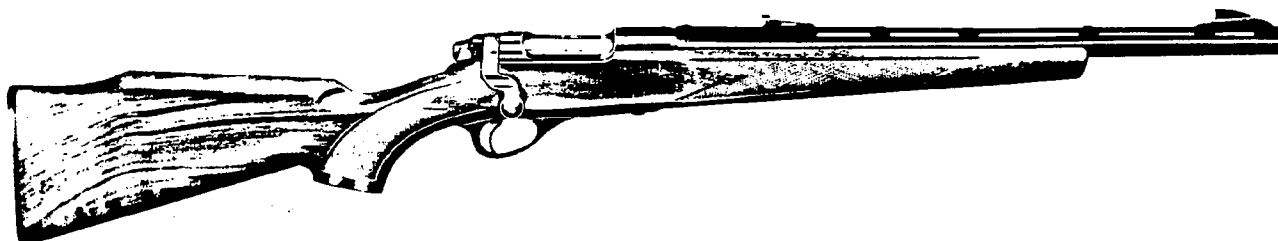
To Reassemble - Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

REMINGTON
FIELD SERVICE MANUAL



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

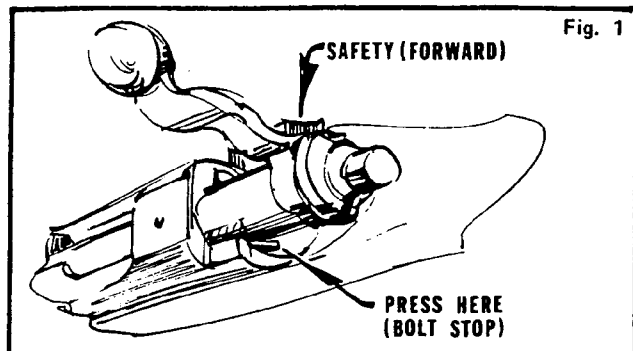
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

1969

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; 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.

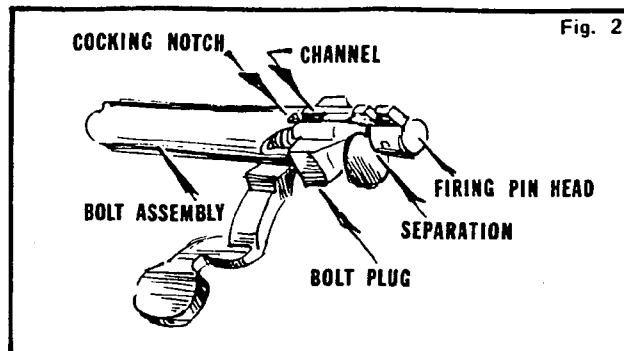
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

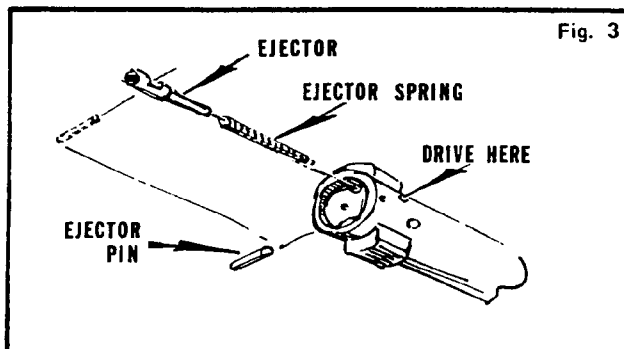
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

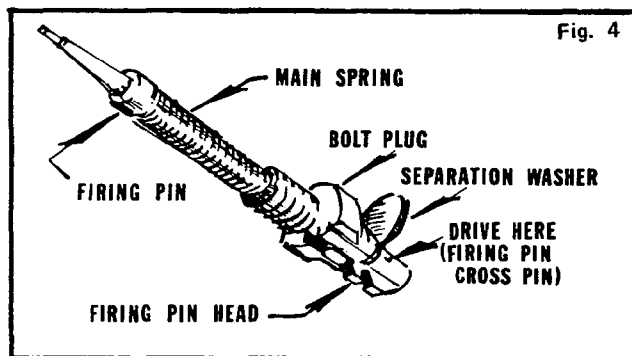
To Disassemble — Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

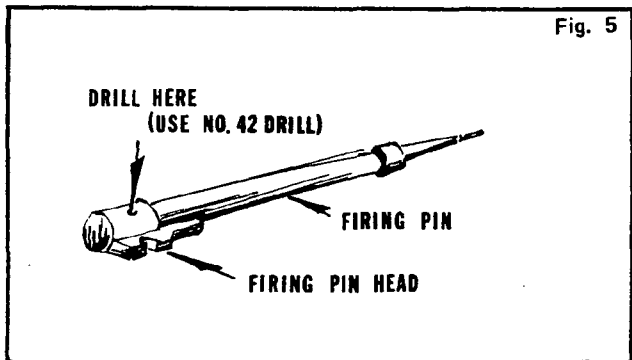
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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 re-assembled. 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

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**.

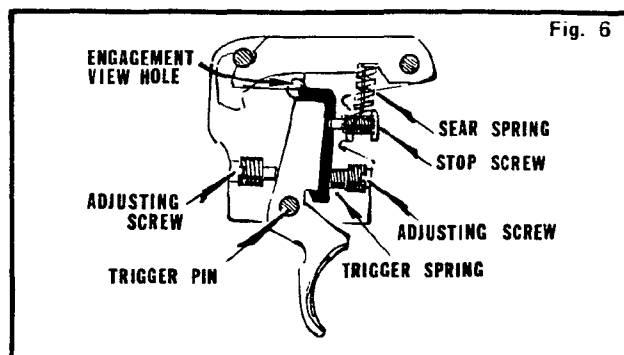
To Reassemble — Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble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

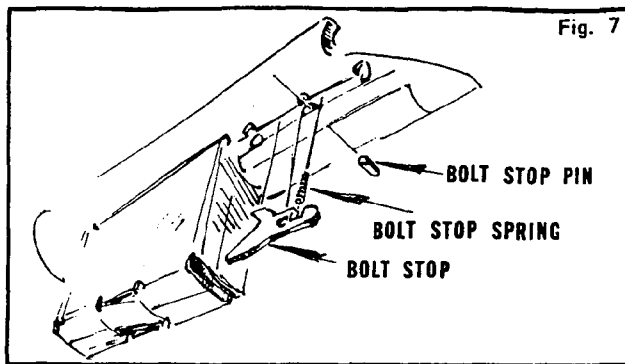
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

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 over-travel.

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° 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.

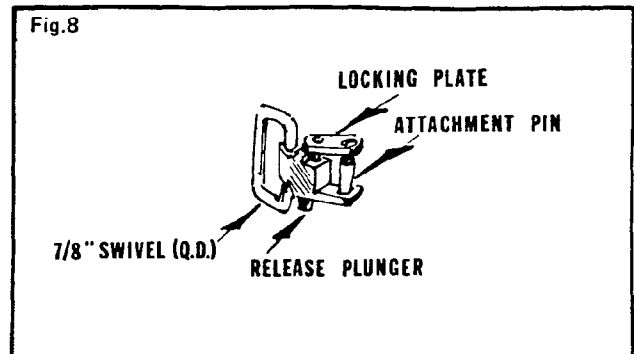
Front Swivel Screw — Use No. 13 drill.

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 tight-end 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 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 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 tell-tale 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 style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition. |

UNLOCKING

- | | |
|--------------------|--|
| Cause: | <ol style="list-style-type: none"> 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: | <ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault. |

MODEL 600

EXTRACTION

- Cause:**
1. Fouled, rough, or enlarged chamber.
 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.

BOLT BINDS

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle enters in stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File ends of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Replace.
 3. Replace.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge— rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.
- Correction:**
1. Ream.
 2. Re-head.
 3. Re-head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING (See trigger Adjustment)

- Cause:**
1. Trigger adjusting screw at 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.
- Correction:**
1. Adjust.
 2. Fit new trigger assembly.
 3. Fit new trigger assembly;
 4. Fit new sear and safety cam or connector.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY

- Cause:**
1. Safe binds (safe works hard).
 2. Safety snap washer stretches out (safe works too freely).
 3. Safety damaged.
- Correction:**
1. Free up.
 2. Replace washer or reseal in safety pivot pin 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

- 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

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Barrel, 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, Barrel Bracket, Barrel Stud (6), Receiver)	34	25410	Recoil Pad Screw (Magnum only)
2	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Body Assembly and Bolt Handle)	35	26850	Safety Detent Ball
	26705	Bolt Assembly, 308 Win. (includes Bolt Body Assembly and Bolt Handle)	36	15432	Safety Detent Spring
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	37	17043	Safety Pivot Pin
	26700	Bolt Final Assembly, 308 Win. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	38	17044	Safety Snap Washer
3	15409	Bolt Plug	39	15666	Sear Safety Cam
4	15412	Bolt Stop	40	24476	Sear Pin
5	24484	Bolt Stop Pin	41	17047	Sear Spring
6	15413	Bolt Stop Spring	42	15416	Sight Screw
	15741	Butt Plate (Model 600 only)	43	16968	Sight Washer
	25410	Butt Plate Screw (Model 600 only)		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
7	17017	Ejector	44	15376	Fastener
8	17676	Ejector Pin	45	15357	Front Swivel Nut
9	17019	Ejector Spring	46	15356	Front Swivel Screw
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	47	15358	Rear Swivel Screw
	16254	Extractor	48	26625	Sling Strap Assembly, 7/8"
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	49	26555	Swivel Assembly, Q.D. (each)
	27340	Extractor Rivet (except 222 Rem.)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Recoil Pad, Recoil Pad Screw (2), Stock, Swivel Screw, Rear; Swivel Screw, Front; Front Swivel Nut, Reinforcing Screw)
12	15410	Firing Pin		27650	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), and Stock)
13	26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	51	15883	Tang Support (Magnum only)
14	17022	Firing Pin Cross Pin	52	15435	Trigger
15	23321	Firing Pin Head	53	17049	Trigger Adjusting Screw
16	15653	Front Guard Screw		26730	Trigger Assembly (includes Trigger Housing, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
17	27365	Front Sight Assembly (includes Front Sight and Front Sight Bead)	54	15436	Trigger Connector
18	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	56	15429	Trigger Housing
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.	57	24477	Trigger Pin
	17056	Magazine Follower	58	17978	Trigger Spring
20	17891	Magazine Spring	59	17053	Trigger Stop Screw
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly (includes Rear Sight Elevation Screw, Rear Sight Base, Rear Sight Eye-piece, Rear Sight Leaf, Rear Sight Windage Screw)			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eyepiece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			

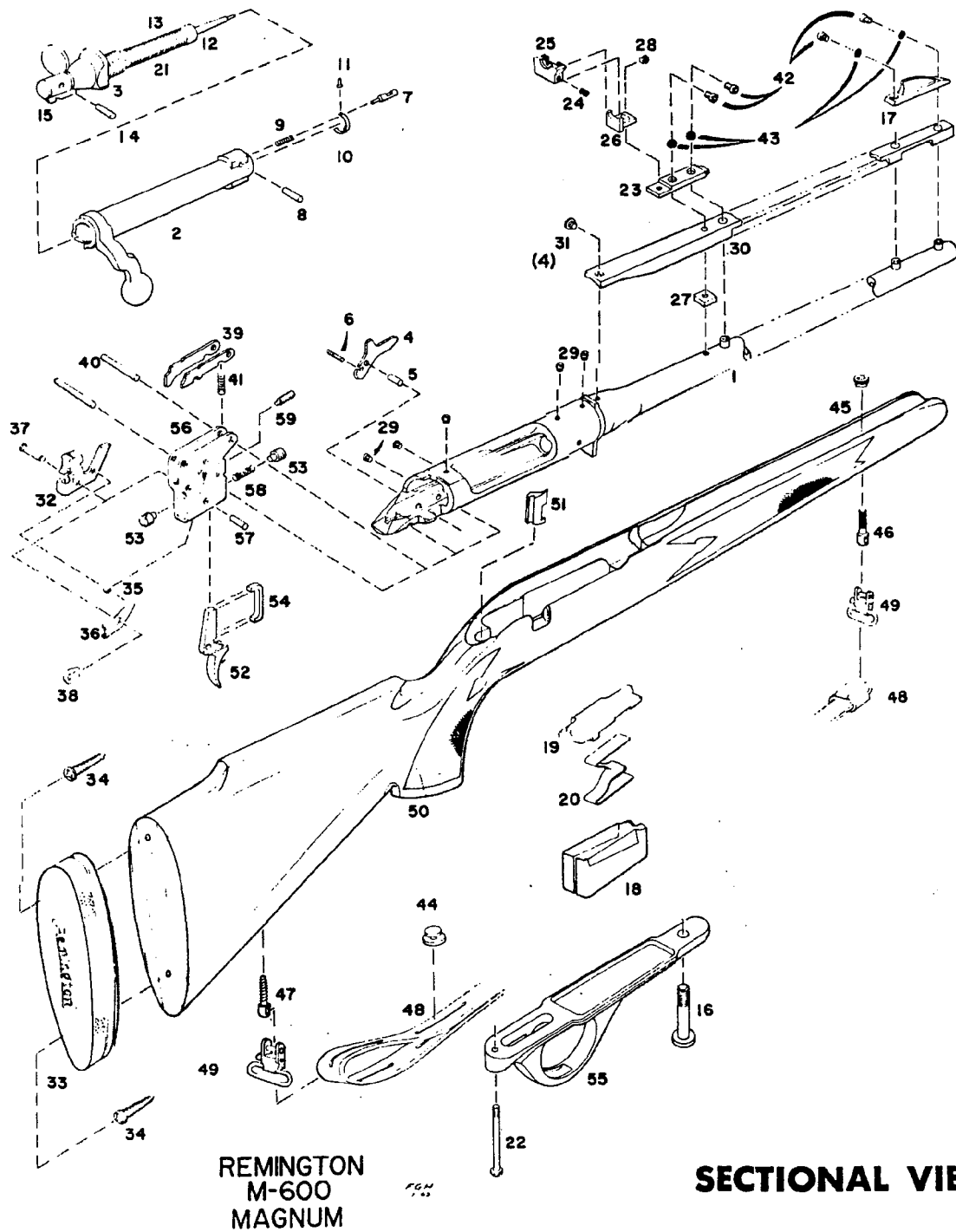
ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

26682	Barrel Assembly, 35 Rem. (Superseded)
26681	Barrel Assembly, 222 Rem.
26683	Barrel Assembly, 6 MM Rem.
26685	Barrel Assembly, 243 Win.
26706	Bolt Assembly, 35 Rem. (Superseded)
26775	Bolt Assembly, 222 Rem.
26701	Bolt Final Assembly, 35 Rem. (Superseded)
26770	Bolt Final Assembly, 222 Rem.
15852	Ejector, 222 Rem.
15850	Extractor, 222 Rem.
27342	Extractor Rivet, 222 Rem.
27366	Front Sight Assembly, 6 MM Rem., 243 Win.
27261	Magazine, 222 Rem.
27262	Magazine, 35 Rem. (Superseded)
16793	Magazine Follower, 222 Rem.
15742	Magazine Spacer, 222 Rem.
17983	Magazine Spring, 222 Rem.
15600	Rear Sight Base, 35 Rem. (Superseded)

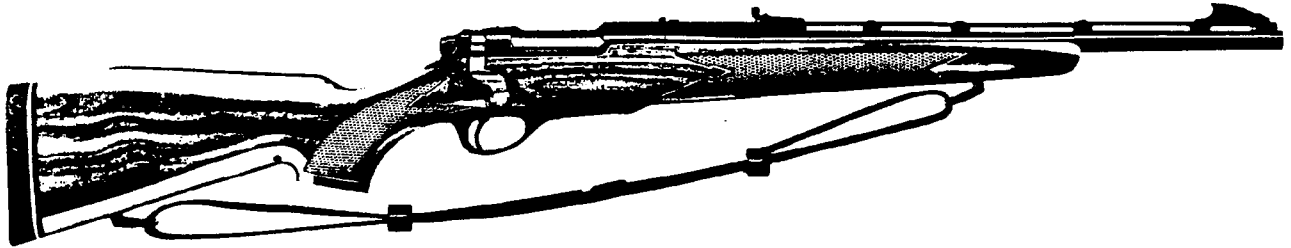
NOTE: See basic Parts List for parts not listed above.

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.

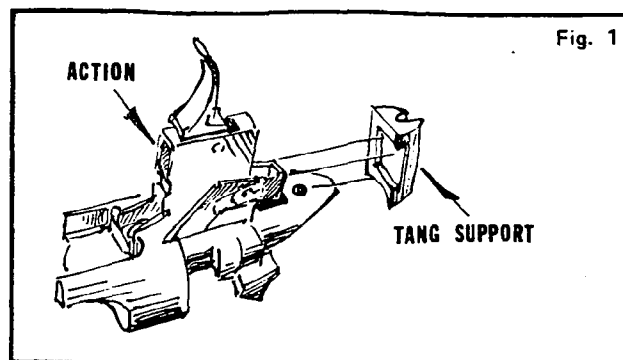
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See **TANG SUPPORT**

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).



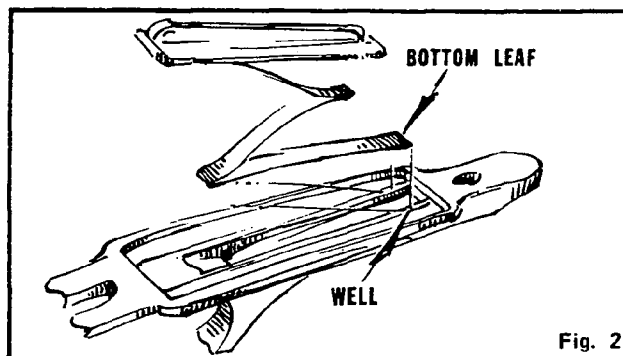
Reassemble stock assembly to action. Tighten firmly with guard screws.

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.

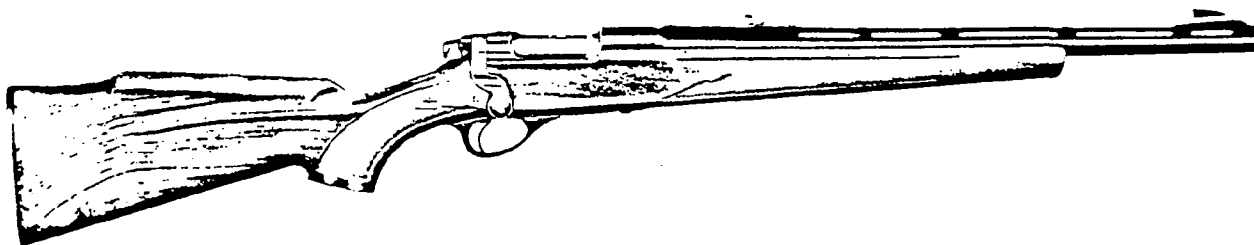
MAGAZINE (marked MAGNUM) — is designed for MAGNUM model use only. Do not use for Standard Model 600.

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 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

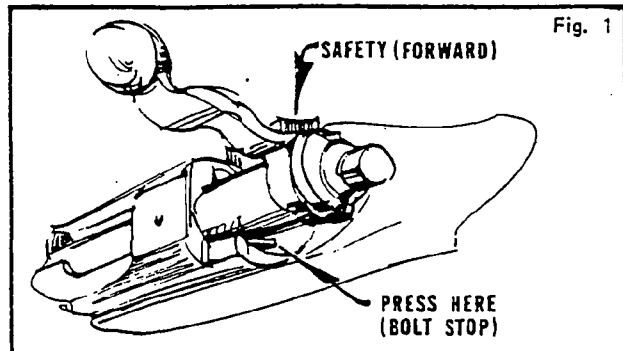
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

1969

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; 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.

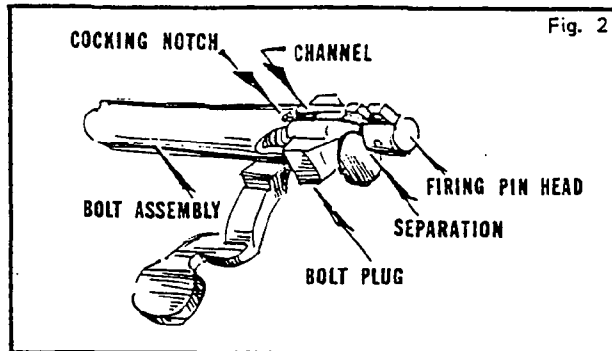
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

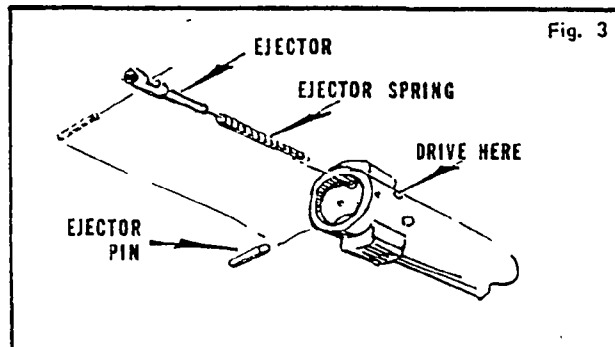
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

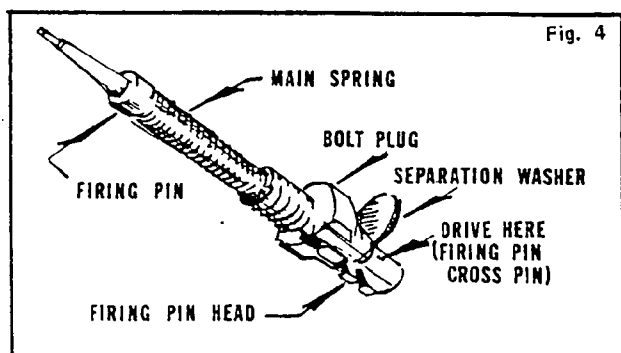
To Disassemble — Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

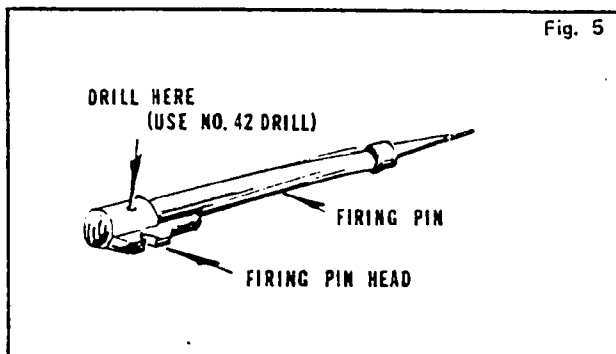
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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.

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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.

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**.

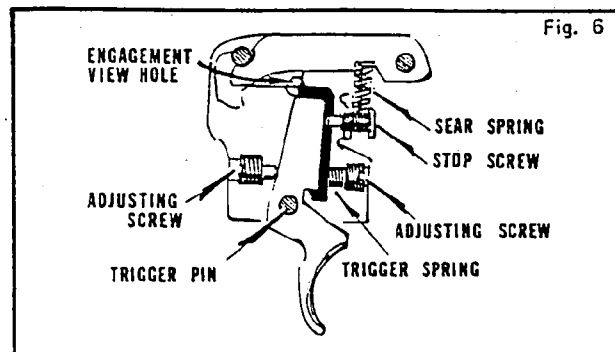
To Reassemble — Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble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

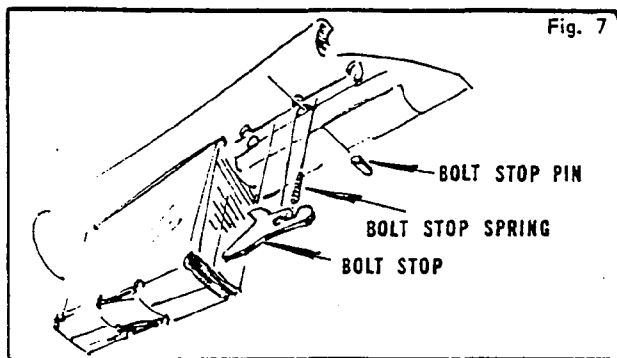
Pull of Trigger — is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

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 over-travel.

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.

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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° 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.

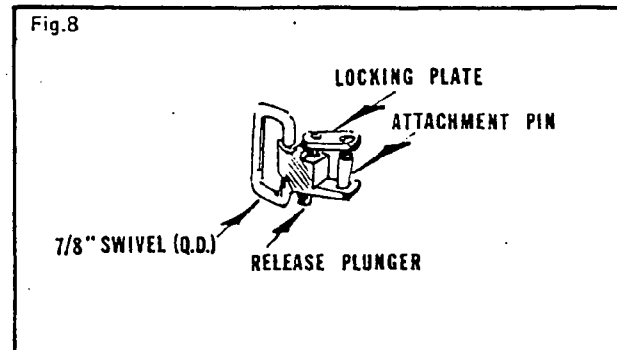
Front Swivel Screw — Use No. 13 drill.

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 tight-end 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 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 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 tell-tale 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 style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition. |

UNLOCKING

- | | |
|--------------------|--|
| Cause: | <ol style="list-style-type: none"> 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: | <ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault. |

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EXTRACTION

- Cause:**
1. Fouled, rough, or enlarged chamber.
 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.

BOLT BINDS

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle enters in stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File ends of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Replace.
 3. Replace.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge— rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.
- Correction:**
1. Ream.
 2. Re—head.
 3. Re—head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING (See trigger Adjustment)

- Cause:**
1. Trigger adjusting screw at 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.
- Correction:**
1. Adjust.
 2. Fit new trigger assembly.
 3. Fit new trigger assembly;
 4. Fit new sear and safety cam or connector.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY

- Cause:**
1. Safe binds (safe works hard).
 2. Safety snap washer stretches out (safe works too freely).
 3. Safety damaged.
- Correction:**
1. Free up.
 2. Replace washer or reseal in safety pivot pin 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

- 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

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Barrel, 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, Barrel Bracket, Barrel Stud (6), Receiver)	34	25410	Recoil Pad Screw (Magnum only)
2	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Body Assembly and Bolt Handle)	35	26850	Safety Detent Ball
	26705	Bolt Assembly, 308 Win. (includes Bolt Body Assembly and Bolt Handle)	36	15432	Safety Detent Spring
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	37	17043	Safety Pivot Pin
	26700	Bolt Final Assembly, 308 Win. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	38	17044	Safety Snap Washer
3	15409	Bolt Plug	39	15666	Sear Safety Cam
4	15412	Bolt Stop	40	24476	Sear Pin
5	24484	Bolt Stop Pin	41	17047	Sear Spring
6	15413	Bolt Stop Spring	42	15416	Sight Screw
	15741	Bolt Plate (Model 600 only)	43	16968	Sight Washer
	25410	Bolt Plate Screw (Model 600 only)		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
7	17017	Ejector	44	15376	Fastener
8	17676	Ejector Pin	45	15357	Front Swivel Nut
9	17019	Ejector Spring	46	15356	Front Swivel Screw
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag. ..	47	15358	Rear Swivel Screw
	16254	Extractor	48	26625	Sling Strap Assembly, 7/8"
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	49	26555	Swivel Assembly, Q.D. (each)
	27340	Extractor Rivet (except 222 Rem.)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Recoil Pad, Recoil Pad Screw (2), Stock, Swivel Screw, Rear Swivel Screw, Front Swivel Nut, Reinforcing Screw)
12	15410	Firing Pin		27650	Stock Assembly (includes Bolt Plate, Bolt Plate Screw (2), and Stock)
13	26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	51	15883	Tang Support (Magnum only)
14	17022	Firing Pin Cross Pin	52	15435	Trigger
15	23321	Firing Pin Head	53	17049	Trigger Adjusting Screw
16	15653	Front Guard Screw		26730	Trigger Assembly (includes Trigger Housing, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
17	27365	Front Sight Assembly (includes Front Sight and Front Sight Bead)	54	15436	Trigger Connector
18	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	56	15429	Trigger Housing
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.	57	24477	Trigger Pin
	17056	Magazine Follower	58	17978	Trigger Spring
20	17891	Magazine Spring	59	17053	Trigger Stop Screw
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly (includes Rear Sight Elevation Screw, Rear Sight Base, Rear Sight Eye-piece, Rear Sight Leaf, Rear Sight Windage Screw)			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eye-piece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
30	18186	Reinforcing Screw			
	15488	Rib			
31	15417	Rib Screw			

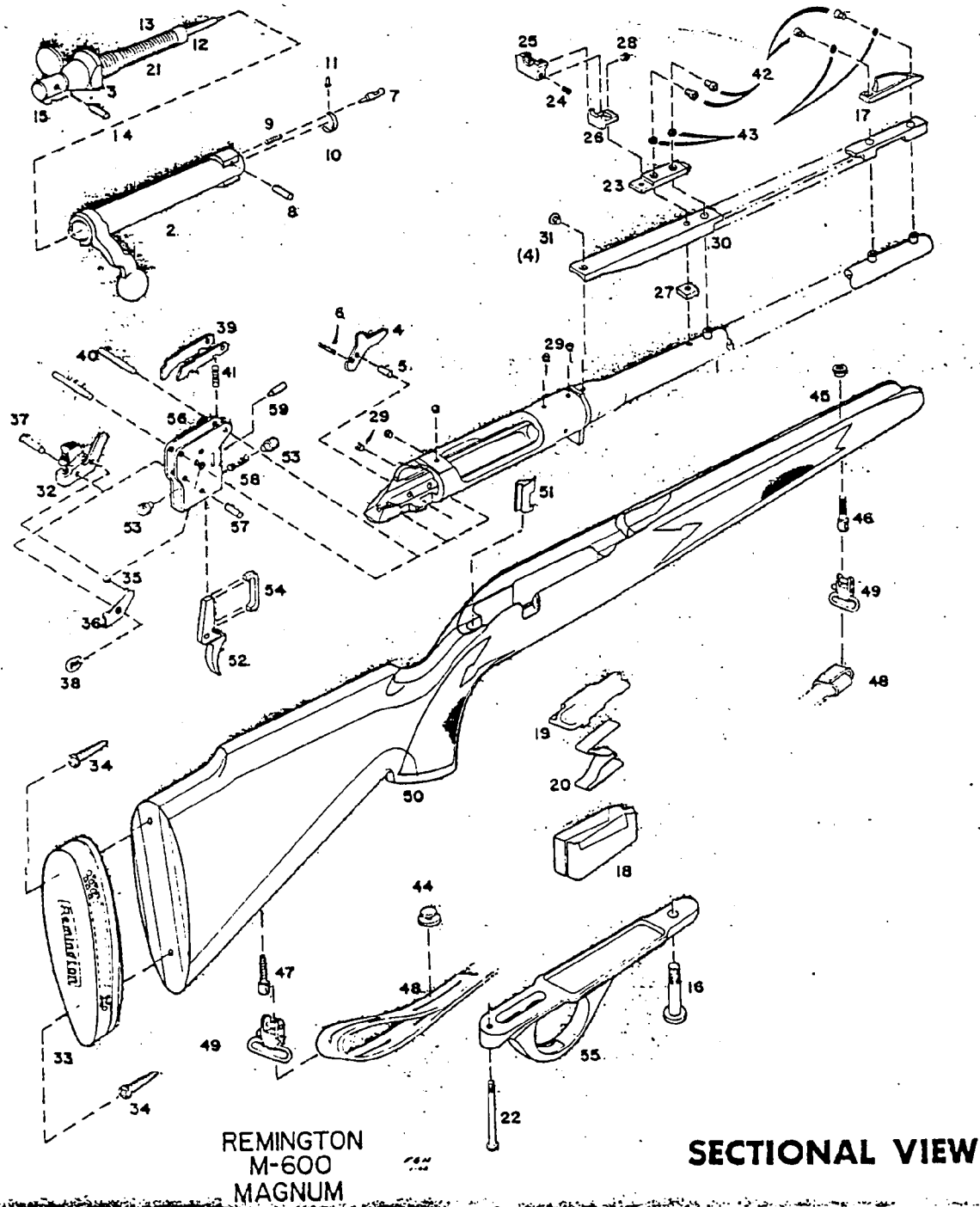
ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

26682	Barrel Assembly, 35 Rem. (Superseded)
26681	Barrel Assembly, 222 Rem.
26683	Barrel Assembly, 6 MM Rem.
26685	Barrel Assembly, 243 Win.
26706	Bolt Assembly, 35 Rem. (Superseded)
26775	Bolt Assembly, 222 Rem.
26701	Bolt Final Assembly, 35 Rem. (Superseded)
26770	Bolt Final Assembly, 222 Rem.
15852	Ejector, 222 Rem.
15850	Extractor, 222 Rem.
27342	Extractor Rivet, 222 Rem.
27366	Front Sight Assembly, 6 MM Rem., 243 Win.
27261	Magazine, 222 Rem.
27262	Magazine, 35 Rem. (Superseded)
16793	Magazine Follower, 222 Rem.
15742	Magazine Spacer, 222 Rem.
17983	Magazine Spring, 222 Rem.
15600	Rear Sight Base, 35 Rem. (Superseded)

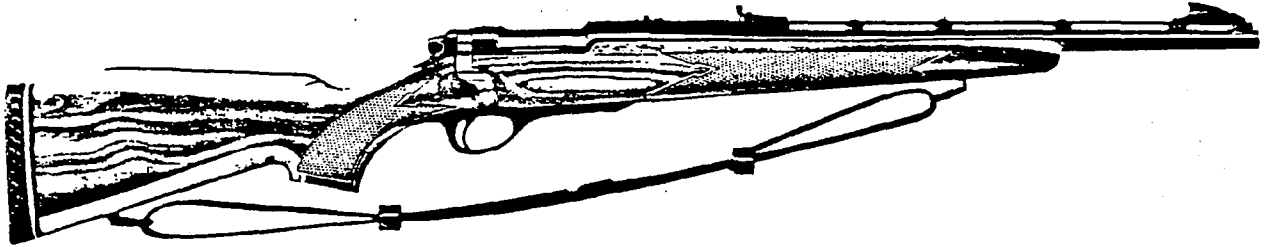
NOTE: See basic Parts List for parts not listed above.

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.

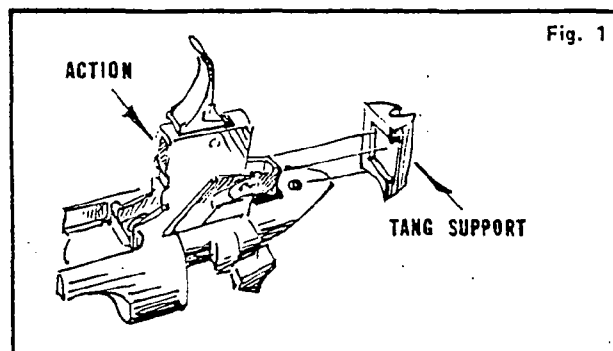
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See **TANG SUPPORT**

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).



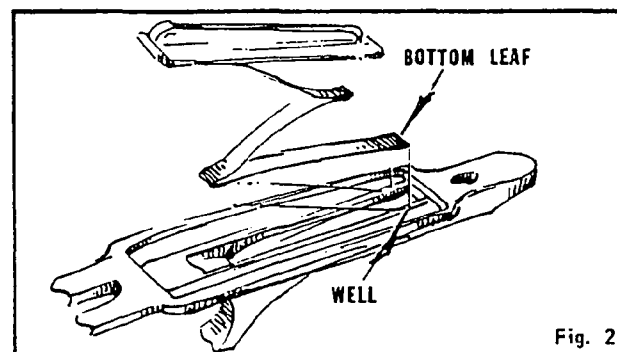
Reassemble stock assembly to action. Tighten firmly with guard screws.

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 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

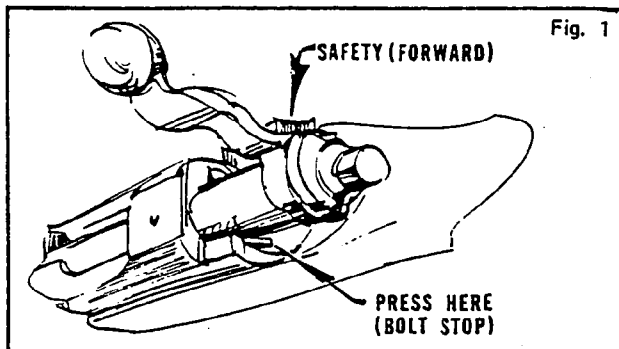
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

1973

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; 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.

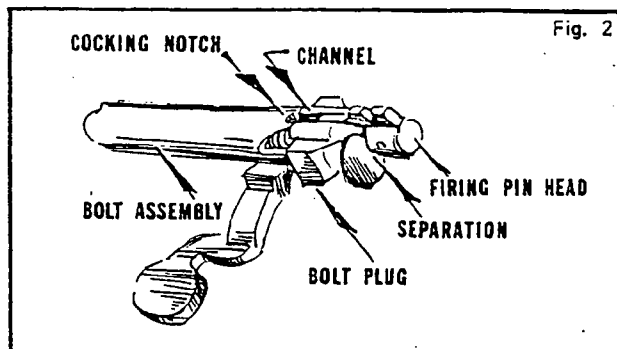
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

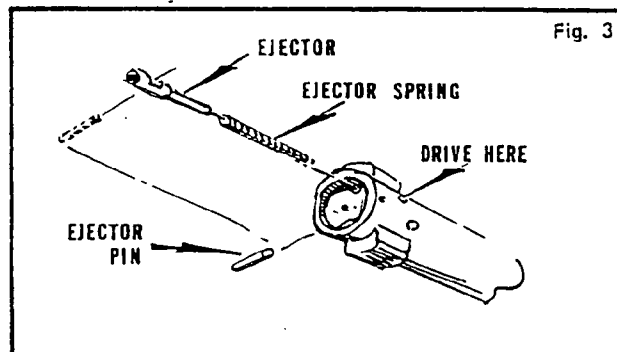
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

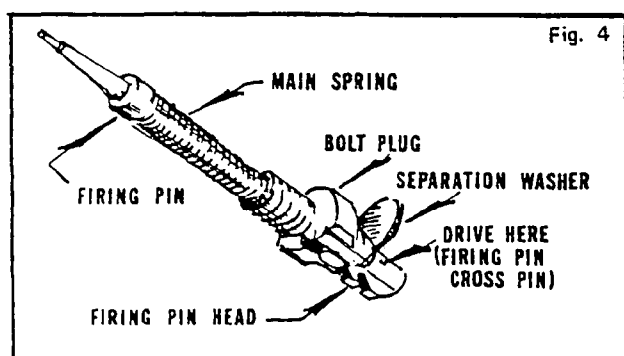
To Disassemble — Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

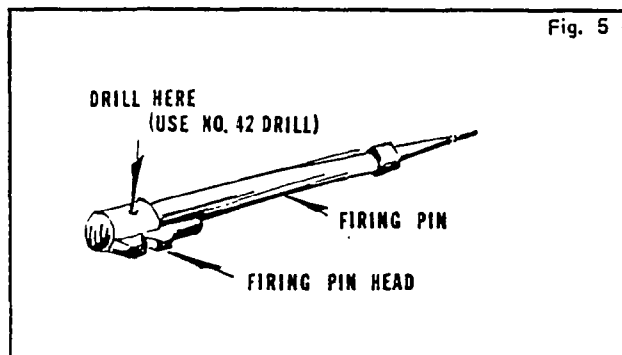
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly. (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 ASSEMBLY. Hold bolt plug retracted against tension of re-assembled 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 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 re-assembled. 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 components 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**.

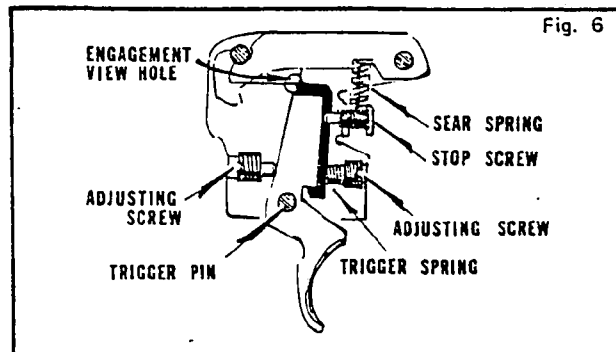
To Reassemble — Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble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

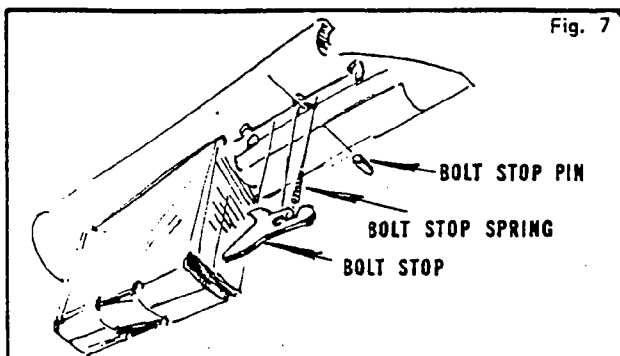
Pull of Trigger — is adjusted to desired weight by turning trigger adjusting screw at front. Turn screw inward or clockwise for heavier weight of pull. Turn screw outward or counter clockwise for lighter weight pull.

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 over-travel.

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.

MODEL 600



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° 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.

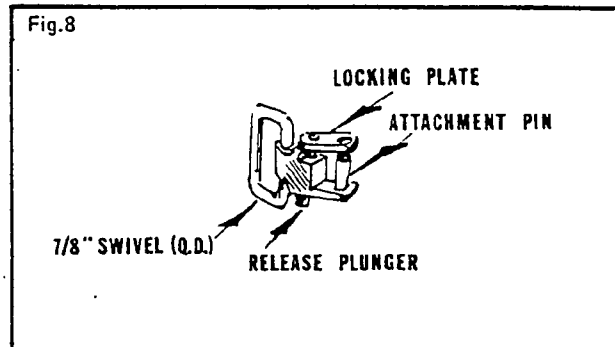
Front Swivel Screw — Use No. 13 drill.

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 tight-end 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 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 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 tell-tale 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 style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition. |

UNLOCKING

- | | |
|--------------------|--|
| Cause: | <ol style="list-style-type: none"> 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: | <ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault. |

MODEL 600

EXTRACTION

- Cause:**
1. Fouled, rough, or enlarged chamber.
 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.

BOLT BINDS

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle enters in stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File ends of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Replace.
 3. Replace.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge— rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.
- Correction:**
1. Ream.
 2. Re-head.
 3. Re-head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING (See trigger Adjustment)

- Cause:**
1. Trigger adjusting screw at 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.
- Correction:**
1. Adjust.
 2. Fit new trigger assembly.
 3. Fit new trigger assembly.
 4. Fit new sear and safety cam or connector.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY

- Cause:**
1. Safe binds (safe works hard).
 2. Safety snap washer stretches out (safe works too freely).
 3. Safety damaged.
- Correction:**
1. Free up.
 2. Replace washer or reseal in safety pivot pin 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

- 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

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Barrel, 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, Barrel Bracket, Barrel Stud (6), Receiver)	34	25410	Recoil Pad Screw (Magnum only)
2	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Body Assembly and Bolt Handle)	35	26850	Safety Detent Ball
	26705	Bolt Assembly, 308 Win. (includes Bolt Body Assembly and Bolt Handle)	36	15432	Safety Detent Spring
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	37	17043	Safety Pivot Pin
	26700	Bolt Final Assembly, 308 Win. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	38	17044	Safety Snap Washer
3	15409	Bolt Plug	39	15666	Sear Safety Cam
4	15412	Bolt Stop	40	24476	Sear Pin
5	24484	Bolt Stop Pin	41	17047	Sear Spring
6	15413	Bolt Stop Spring	42	15416	Sight Screw
	15741	Butt Plate (Model 600 only)	43	16968	Sight Washer
	25410	Butt Plate Screw (Model 600 only)		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
7	17017	Ejector	44	15376	Fastener
8	17676	Ejector Pin	45	15357	Front Swivel Nut
9	17019	Ejector Spring	46	15356	Front Swivel Screw
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	47	15358	Rear Swivel Screw
	16254	Extractor	48	26625	Sling Strap Assembly, 7/8"
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	49	26555	Swivel Assembly, Q.D. (each)
	27340	Extractor Rivet (except 222 Rem.)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Recoil Pad, Recoil Pad Screw (2), Stock, Swivel Screw, Rear; Swivel Screw, Front; Front Swivel Nut, Reinforcing Screw)
12	15410	Firing Pin		27650	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), and Stock)
13	26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	51	15883	Tong Support (Magnum only)
14	17022	Firing Pin Cross Pin	52	15435	Trigger
15	23321	Firing Pin Head	53	17049	Trigger Adjusting Screw
16	15653	Front Guard Screw		26730	Trigger Assembly (includes Trigger Housing, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
17	27365	Front Sight Assembly (includes Front Sight and Front Sight Bead)	54	15436	Trigger Connector
18	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	56	15429	Trigger Housing
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.	57	24477	Trigger Pin
	17056	Magazine Follower	58	17978	Trigger Spring
20	17891	Magazine Spring	59	17053	Trigger Stop Screw
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly (includes Rear Sight Elevation Screw, Rear Sight Base, Rear Sight Eye-piece, Rear Sight Leaf, Rear Sight Windage Screw)			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eye-piece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			

ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

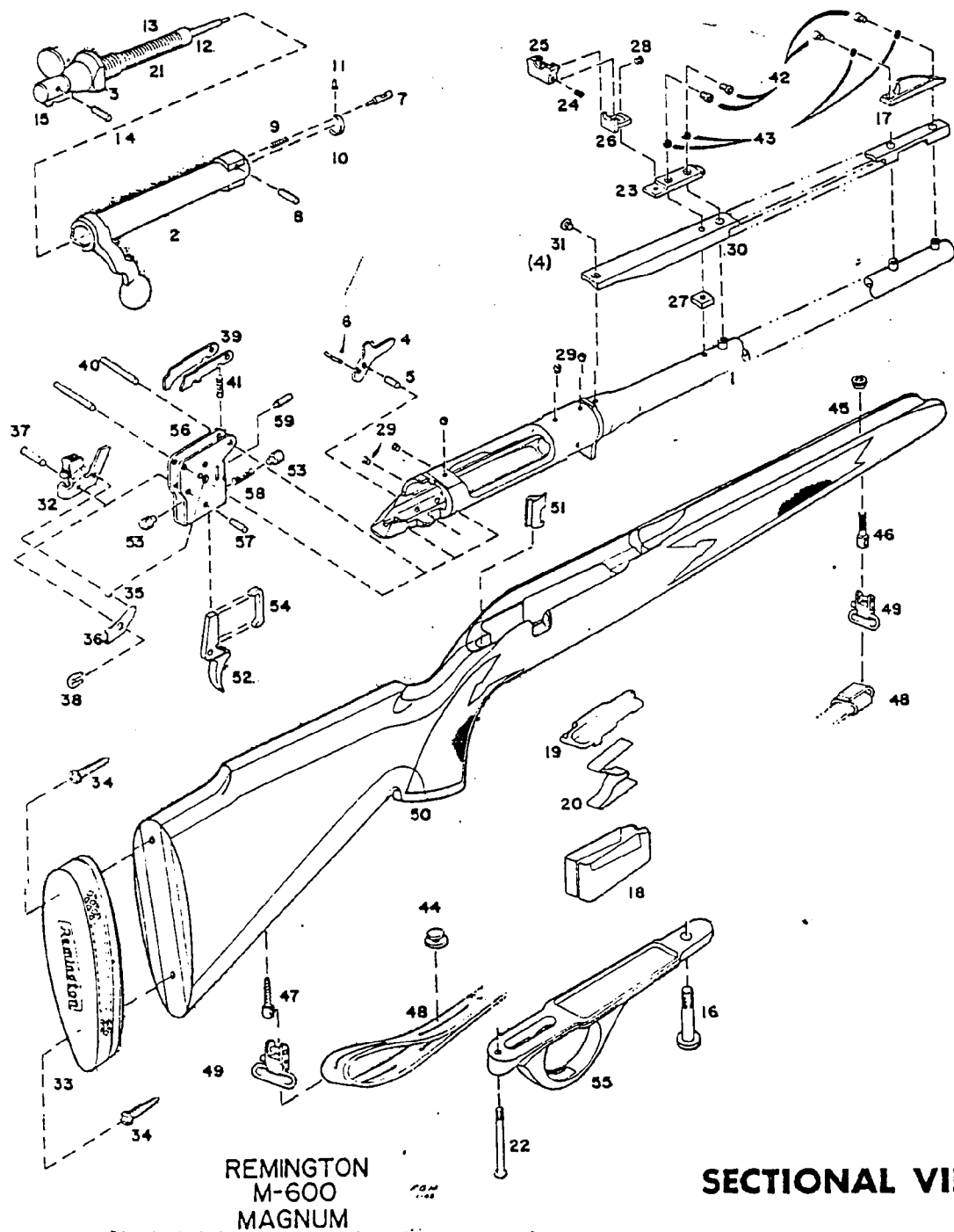
26682	Barrel Assembly, 35 Rem. (Superseded)
26681	Barrel Assembly, 222 Rem.
26683	Barrel Assembly, 6 MM Rem.
26685	Barrel Assembly, 243 Win.
26706	Bolt Assembly, 35 Rem. (Superseded)
26775	Bolt Assembly, 222 Rem.
26701	Bolt Final Assembly, 35 Rem. (Superseded)
26770	Bolt Final Assembly, 222 Rem.
15852	Ejector, 222 Rem.
15850	Extractor, 222 Rem.
27342	Extractor Rivet, 222 Rem.
27366	Front Sight Assembly, 6 MM Rem., 243 Win.
27261	Magazine, 222 Rem.
27262	Magazine, 35 Rem. (Superseded)
16793	Magazine Follower, 222 Rem.
15742	Magazine Spacer, 222 Rem.
17983	Magazine Spring, 222 Rem.
15600	Rear Sight Base, 35 Rem. (Superseded)

NOTE: See basic Parts List for parts not listed above.

EXPLODED
VIEW

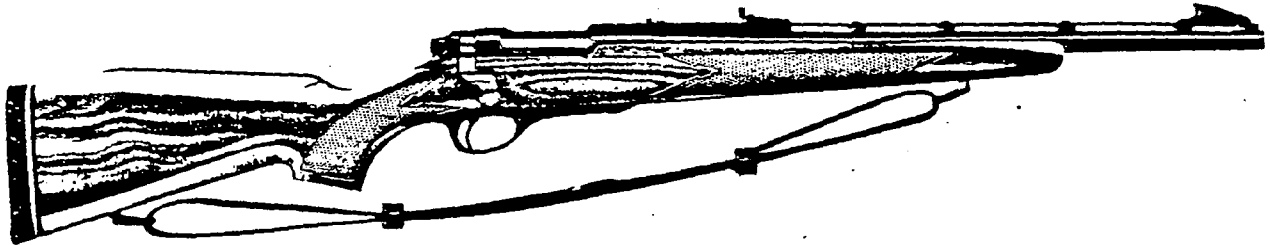
MODEL 600

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).

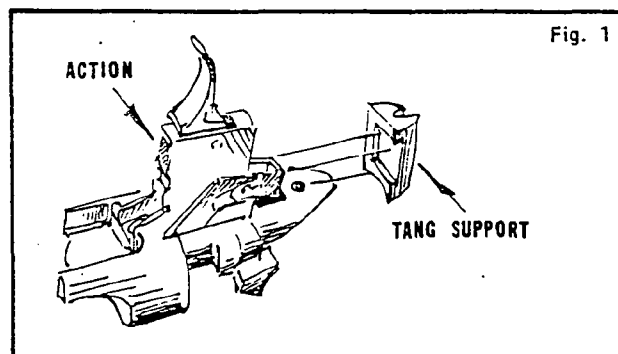


Fig. 1

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).

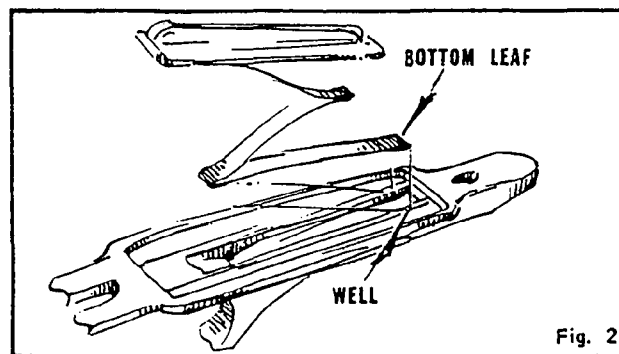


Fig. 2

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.

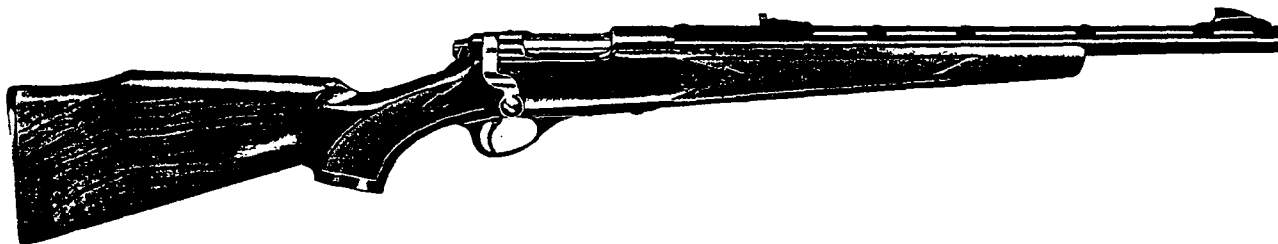
MODEL 600 - FIELD SERVICE MANUAL

From 1973 MANUAL

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

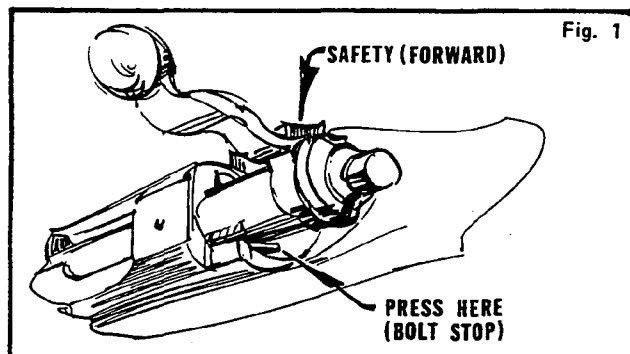
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

MODEL 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; 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.

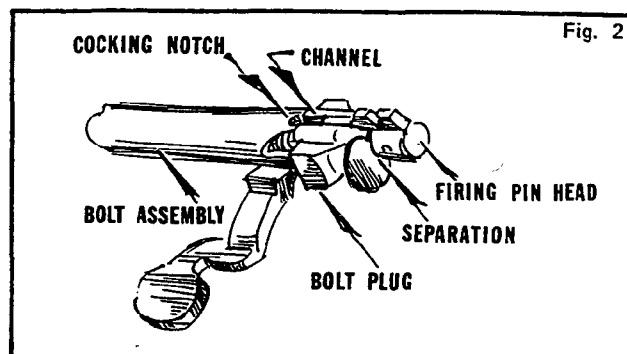
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

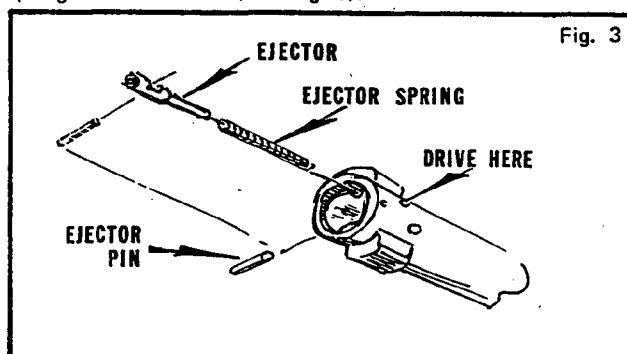
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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 in 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)

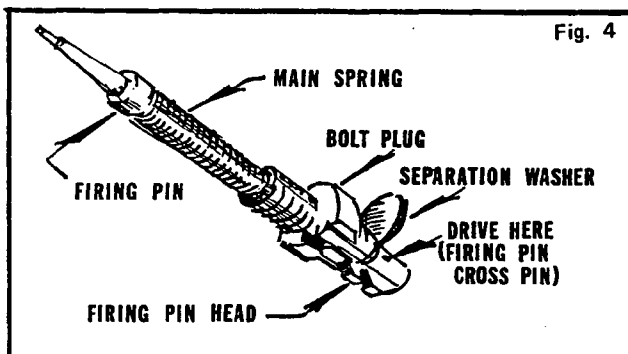
To Disassemble — Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

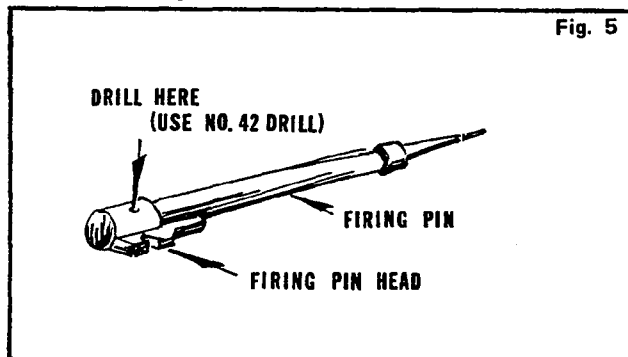
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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 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.

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**.

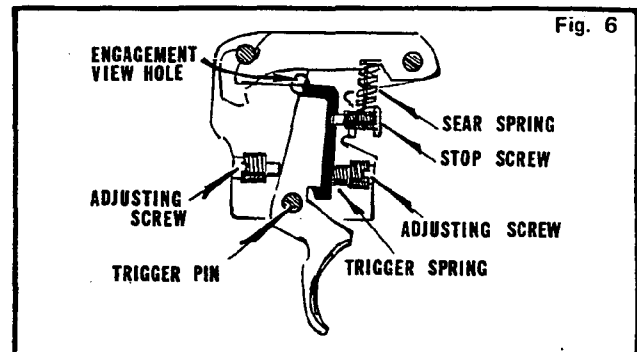
To Reassemble — Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble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

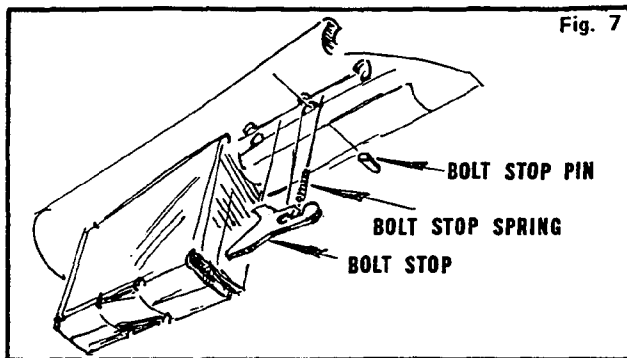
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

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 over-travel.

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° 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.

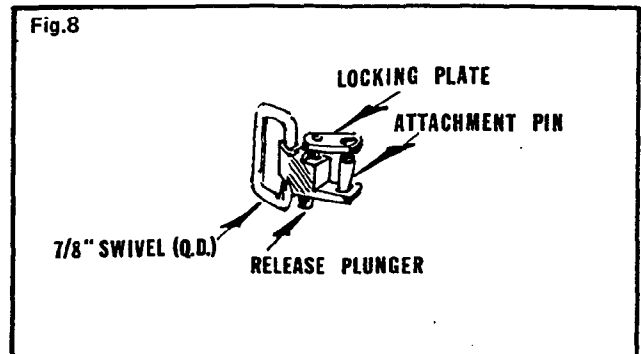
Front Swivel Screw — Use No. 13 drill.

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 tight-end 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 receiver 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 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 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 tell-tale 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 style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition. |

UNLOCKING

- | | |
|--------------------|--|
| Cause: | <ol style="list-style-type: none"> 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: | <ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault. |

MODEL 600

EXTRACTION

- Cause:**
1. Fouled, rough, or enlarged chamber.
 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.

BOLT BINDS

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle enters in stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File ends of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Replace.
 3. Replace.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge— rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.
- Correction:**
1. Ream.
 2. Re-head.
 3. Re-head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING (See trigger Adjustment)

- Cause:**
1. Trigger adjusting screw at 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.
- Correction:**
1. Adjust.
 2. Fit new trigger assembly.
 3. Fit new trigger assembly;
 4. Fit new sear and safety cam or connector.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY

- Cause:**
1. Safe binds (safe works hard).
 2. Safety snap washer stretches out (safe works too freely).
 3. Safety damaged.
- Correction:**
1. Free up.
 2. Replace washer or reseal in safety pivot pin 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

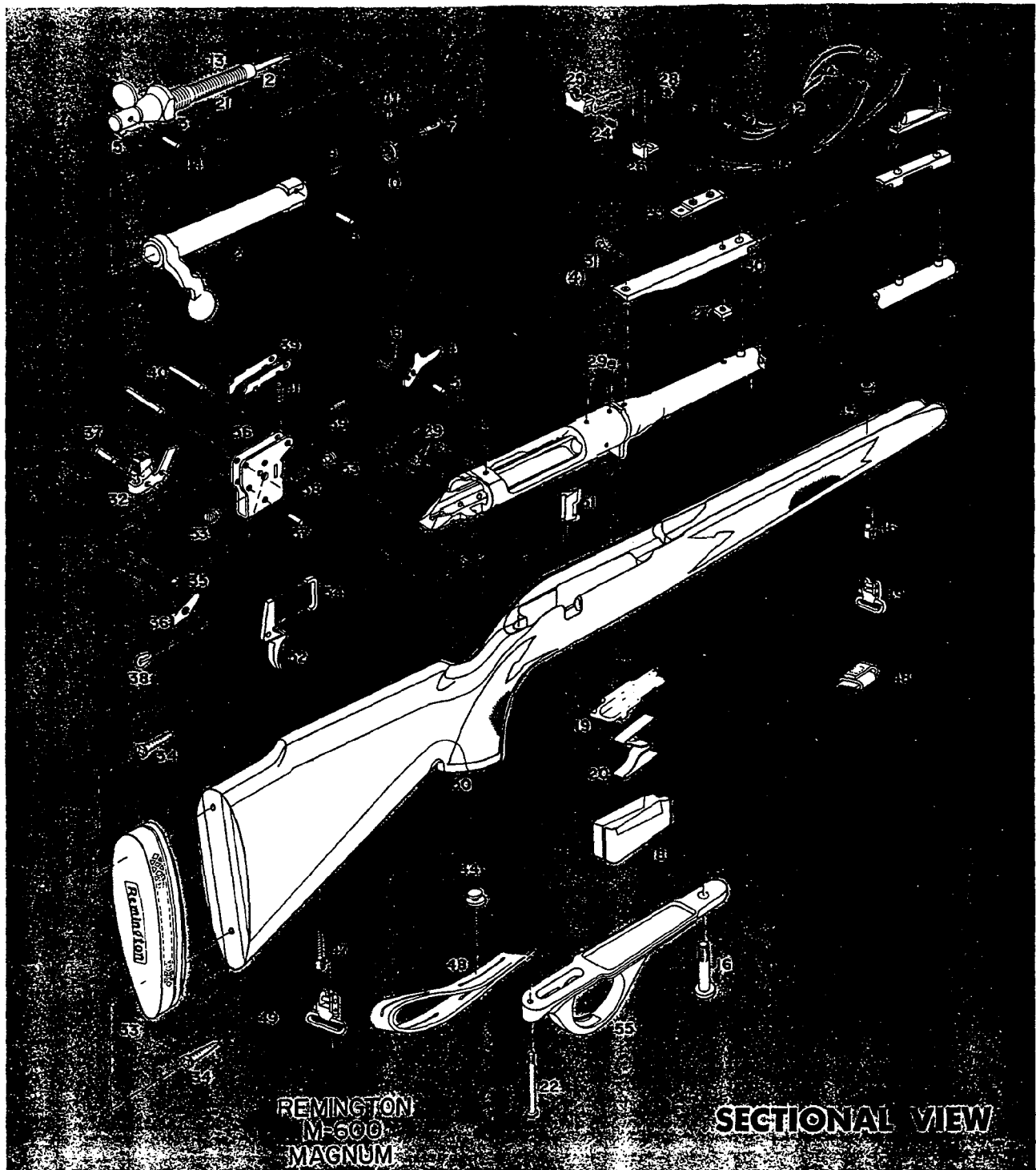
- Cause:**
1. Barrel not straight.
 2. Improper or loose sights.
- Correction;**
1. Straighten or replace barrel.
 2. Tighten or change sights.

REMINGTON FIELD SERVICE MANUAL

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Barrel, 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, Barrel Bracket, Barrel Stud (6), Receiver)	34	25410	Recoil Pad Screw (Magnum only)
2	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Body Assembly and Bolt Handle)	35	26850	Safety Detent Ball
	26705	Bolt Assembly, 308 Win. (includes Bolt Body Assembly and Bolt Handle)	36	15432	Safety Detent Spring
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	37	17043	Safety Pivot Pin
	26700	Bolt Final Assembly, 308 Win. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	38	17044	Safety Snap Washer
3	15409	Bolt Plug	39	15666	Sear Safety Cam
4	15412	Bolt Stop	40	24476	Sear Pin
5	24484	Bolt Stop Pin	41	17047	Sear Spring
6	15413	Bolt Stop Spring	42	15416	Sight Screw
	15741	Butt Plate (Model 600 only)	43	16968	Sight Washer
	25410	Butt Plate Screw (Model 600 only)		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
7	17017	Ejector	44	15376	Fastener
8	17676	Ejector Pin	45	15357	Front Swivel Nut
9	17019	Ejector Spring	46	15356	Front Swivel Screw
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	47	15358	Rear Swivel Screw
	16254	Extractor	48	26625	Sling Strap Assembly, 7/8"
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	49	26555	Swivel Assembly, Q.D. (each)
	27340	Extractor Rivet (except 222 Rem.)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Recoil Pad, Recoil Pad Screw (2), Stock, Swivel Screw, Rear; Swivel Screw, Front; Front Swivel Nut, Reinforcing Screw)
12	15410	Firing Pin		27650	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), and Stock)
13	26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	51	15883	Tang Support (Magnum, only)
14	17022	Firing Pin Cross Pin	52	15435	Trigger
15	23321	Firing Pin Head	53	17049	Trigger Adjusting Screw
16	15653	Front Guard Screw		26730	Trigger Assembly (includes Trigger Housing, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
17	27365	Front Sight Assembly (includes Front Sight and Front Sight Bead)	54	15436	Trigger Connector
18	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	56	15429	Trigger Housing
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.	57	24477	Trigger Pin
	17056	Magazine Follower	58	17978	Trigger Spring
20	17891	Magazine Spring	59	17053	Trigger Stop Screw
21	15411	Main Spring			
22	17580	Rear Guard Screw			ADDITIONAL CALIBER PARTS
	26841	Rear Sight Assembly (includes Rear Sight Elevation Screw, Rear Sight Base, Rear Sight Eye-piece, Rear Sight Leaf, Rear Sight Windage Screw)			(Not Shown in Sectional View)
23	15600	Rear Sight Base, 350 Rem. Mag.	26682		Barrel Assembly, 35 Rem (Superseded)
	15727	Rear Sight Base	26681		Barrel Assembly, 222 Rem.
24	15733	Rear Sight Elevation Screw	26683		Barrel Assembly, 6 MM Rem.
25	15726	Rear Sight Eyepiece	26685		Barrel Assembly, 243 Win.
26	15728	Rear Sight Leaf	26706		Bolt Assembly, 35 Rem. (Superseded)
27	15418	Rear Sight Nut	26775		Bolt Assembly, 222 Rem.
28	15732	Rear Sight Windage Screw	26701		Bolt Final Assembly, 35 Rem. (Superseded)
	15778	Rear Sight Wrench	26770		Bolt Final Assembly, 222 Rem.
29	17034	Receiver Plug Screw	15852		Ejector, 222 Rem.
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.	15850		Extractor, 222 Rem.
	18186	Reinforcing Screw	27342		Extractor Rivet, 222 Rem.
30	15488	Rib	27366		Front Sight Assembly, 6 MM Rem., 243 Win.
31	15417	Rib Screw	27261		Magazine, 222 Rem.
			27262		Magazine, 35 Rem. (Superseded)
			16793		Magazine Follower, 222 Rem.
			15742		Magazine Spacer, 222 Rem.
			17983		Magazine Spring, 222 Rem.
			15600		Rear Sight Base, 35 Rem. (Superseded)

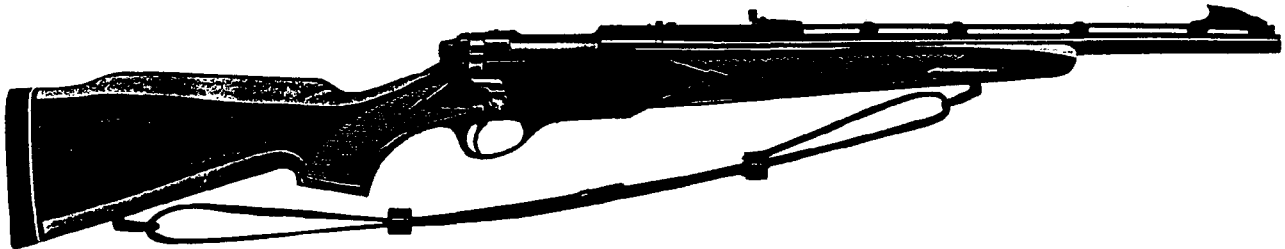
NOTE: See basic Parts List for parts not listed above.

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.

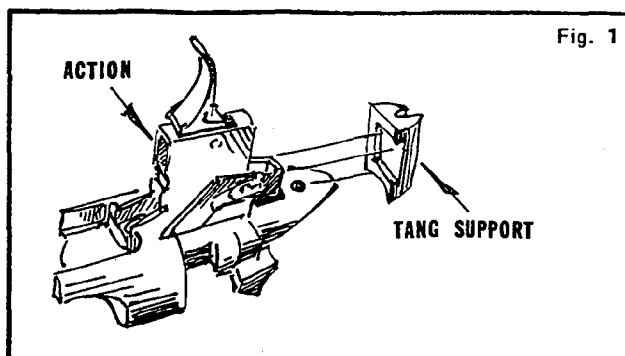
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See **TANG SUPPORT**

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).



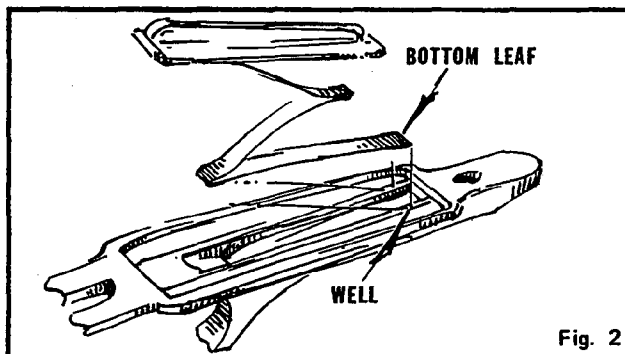
Reassemble stock assembly to action. Tighten firmly with guard screws.

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

MARCH - 1976

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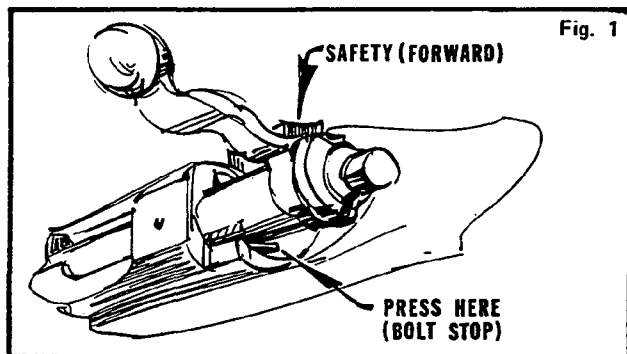
Send all guns for factory service and inquiries on
service and parts to

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

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.

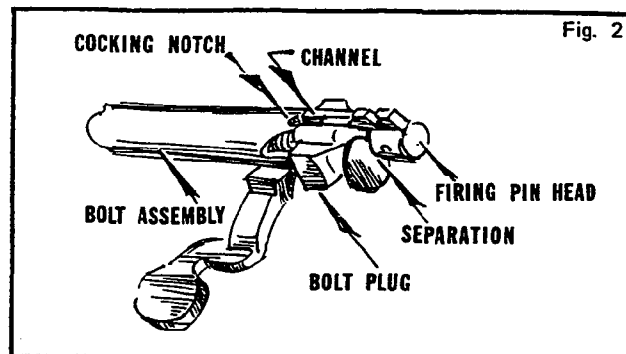
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

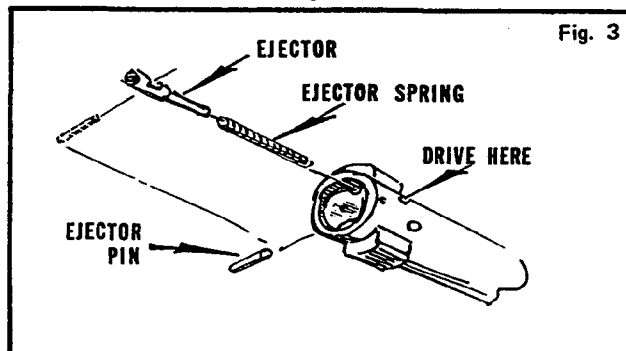
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

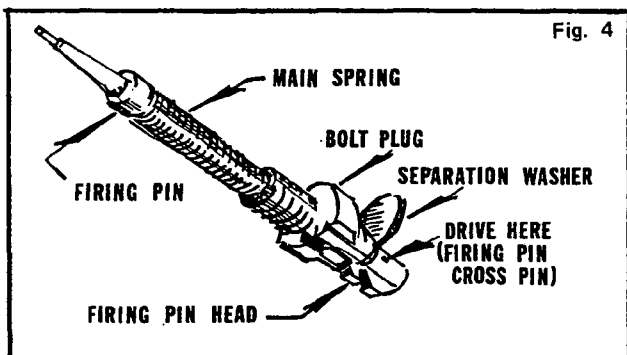
To Disassemble — Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

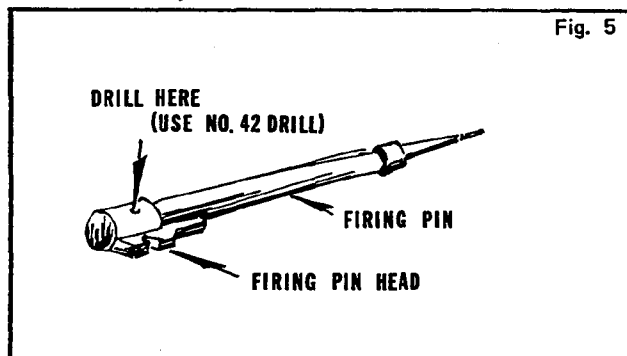
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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 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.

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**.

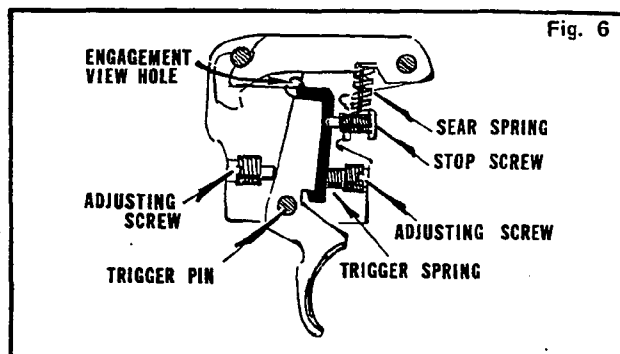
To Reassemble — Locate trigger connector on trigger. Position assembled trigger and trigger connector into housing. Align trigger to trigger pin hole in housing. Make certain trigger spring remains assembled to forward trigger adjusting screw as trigger and trigger connector are reassembled. Reassemble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

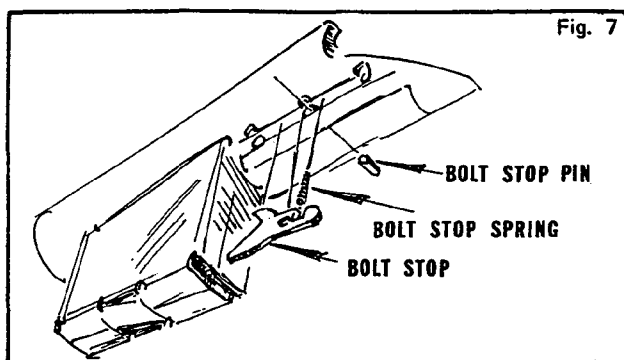
Note: All adjusting (2) and stop (1) screws are factory sealed with adhesive cement.

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 over-travel.

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° 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.

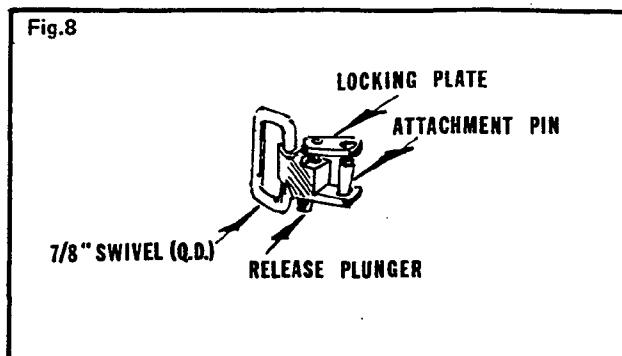
Front Swivel Nut — Use 3/8 inch drill.

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 tight-end 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 (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 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 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 tell-tale 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 style="list-style-type: none"> 1. Firing pin damaged. 2. Firing pin binds. 3. Firing pin protrusion faulty. 4. Trigger assembly out of adjustment. 5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none"> 1. Replace. 2. Free up or replace. 3. Replace firing pin. 4. Adjust. 5. Replace ammunition. |

UNLOCKING

- | | |
|-------------|--|
| Cause: | <ol style="list-style-type: none"> 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: | <ol style="list-style-type: none"> 1. See Extraction. 2. Smooth up bolt handle cam. 3. Deburr. 4. Ammunition may be at fault. |

MODEL 600

EXTRACTION

- Cause:**
1. Fouled, rough, or enlarged chamber.
 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.

BOLT BINDS

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle interferes in stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File ends of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Replace.
 3. Replace.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge— rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.
- Correction:**
1. Ream.
 2. Re-head.
 3. Re-head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING (See trigger Adjustment)

- Cause:**
1. Trigger adjusting screw at 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.
- Correction:**
1. Adjust.
 2. Fit new trigger assembly.
 3. Fit new trigger assembly;
 4. Fit new sear and safety cam or connector.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY

- Cause:**
1. Safe binds (safe works hard).
 2. Safety snap washer stretches out (safe works too freely).
 3. Safety damaged.
- Correction:**
1. Free up.
 2. Replace washer or reseal in safety pivot pin 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

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

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
1	26684	Barrel Assembly, 350 Rem. Mag. (includes Barrel, 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, Barrel Bracket, Barrel Stud (6), Receiver)	34	25410	Recoil Pad Screw (Magnum only)
2	26707	Bolt Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Body Assembly and Bolt Handle)	35	26850	Safety Detent Ball
	26705	Bolt Assembly, 308 Win. (includes Bolt Body Assembly and Bolt Handle)	36	15432	Safety Detent Spring
	26702	Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	37	17043	Safety Pivot Pin
	26700	Bolt Final Assembly, 308 Win. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	38	17044	Safety Snap Washer
3	15409	Bolt Plug	39	15666	Sear Safety Cam
4	15412	Bolt Stop	40	24476	Sear Pin
5	24484	Bolt Stop Pin	41	17047	Sear Spring
6	15413	Bolt Stop Spring	42	15416	Sight Screw
	15741	Butt Plate (Model 600 only)	43	16968	Sight Washer
	25410	Butt Plate Screw (Model 600 only)		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
7	17017	Ejector	44	15376	Fastener
8	17676	Ejector Pin	45	15357	Front Swivel Nut
9	17019	Ejector Spring	46	15356	Front Swivel Screw
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	47	15358	Rear Swivel Screw
	16254	Extractor	48	26625	Sling Strap Assembly, 7/8"
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	49	26555	Swivel Assembly, Q.D. (each)
	27340	Extractor Rivet (except 222 Rem.)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag. (includes Recoil Pad, Recoil Pad Screw (2), Stock, Swivel Screw, Rear; Swivel Screw, Front; Front Swivel Nut, Reinforcing Screw)
12	15410	Firing Pin		27650	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), and Stock)
13	26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	51	15883	Tang Support (Magnum only)
14	17022	Firing Pin Cross Pin	52	15435	Trigger
15	23321	Firing Pin Head	53	17049	Trigger Adjusting Screw
16	15653	Front Guard Screw		26730	Trigger Assembly (includes Trigger Housing, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
17	27365	Front Sight Assembly (includes Front Sight and Front Sight Bead)	54	15436	Trigger Connector
18	15648	Magazine, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.	56	15429	Trigger Housing
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.	57	24477	Trigger Pin
	17056	Magazine Follower	58	17978	Trigger Spring
20	17891	Magazine Spring	59	17053	Trigger Stop Screw
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly (includes Rear Sight Elevation Screw, Rear Sight Base, Rear Sight Eye-piece, Rear Sight Leaf, Rear Sight Windage Screw)			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eyepiece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			

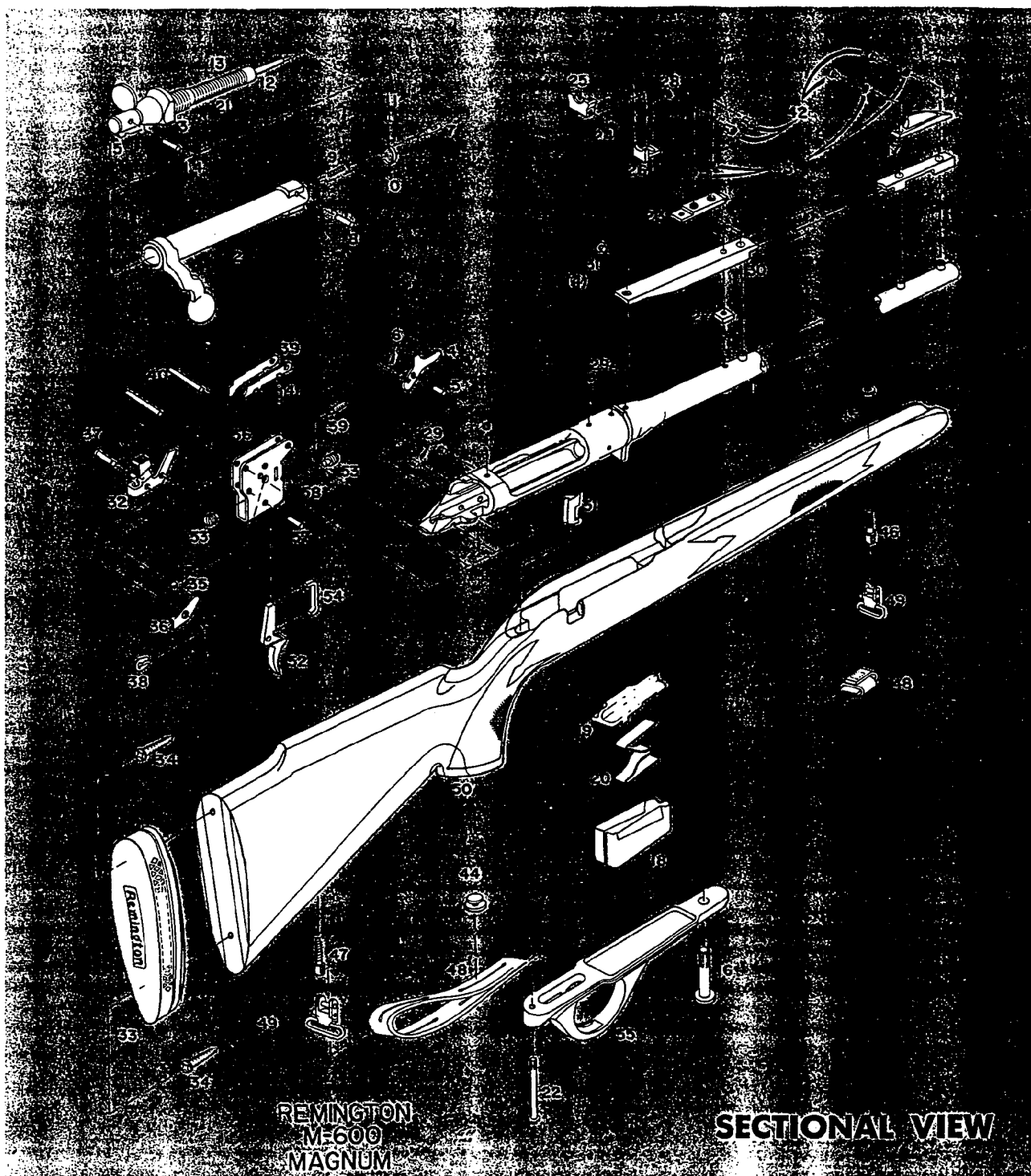
ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

26682	Barrel Assembly, 35 Rem (Superseded)
26681	Barrel Assembly, 222 Rem.
26683	Barrel Assembly, 6 MM Rem.
26685	Barrel Assembly, 243 Win.
26706	Bolt Assembly, 35 Rem. (Superseded)
26775	Bolt Assembly, 222 Rem.
26701	Bolt Final Assembly, 35 Rem. (Superseded)
26770	Bolt Final Assembly, 222 Rem.
15852	Ejector, 222 Rem.
15850	Extractor, 222 Rem.
27342	Extractor Rivet, 222 Rem.
27366	Front Sight Assembly, 6 MM Rem., 243 Win.
27261	Magazine, 222 Rem.
27262	Magazine, 35 Rem. (Superseded)
16793	Magazine Follower, 222 Rem.
15742	Magazine Spacer, 222 Rem.
17983	Magazine Spring, 222 Rem.
15600	Rear Sight Base, 35 Rem. (Superseded)

NOTE: See basic Parts List for parts not listed above.

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.

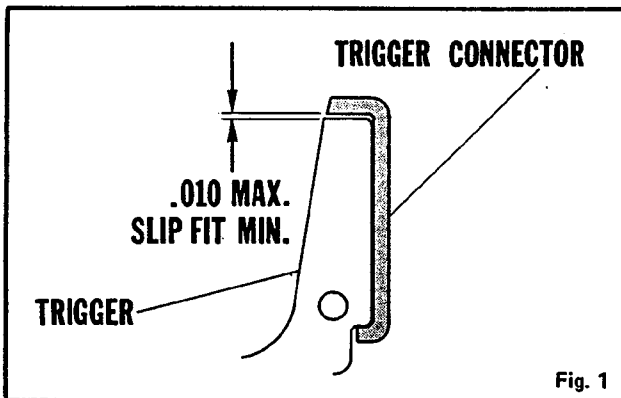


Fig. 1

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).

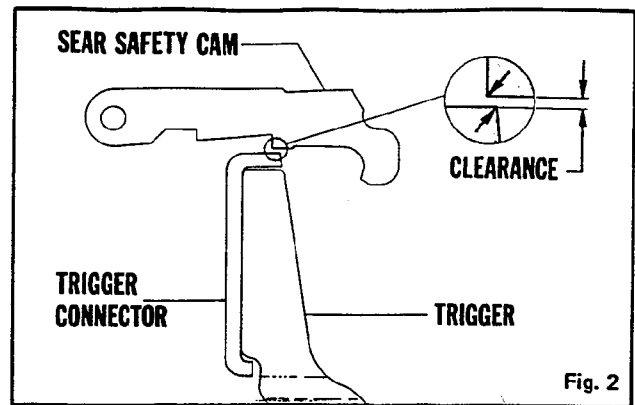


Fig. 2

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).

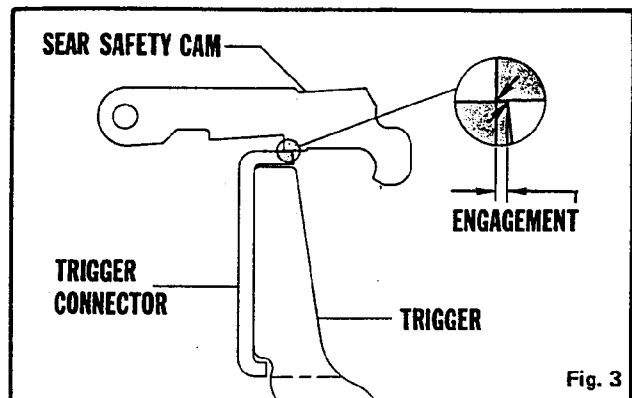


Fig. 3

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

1. **"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.

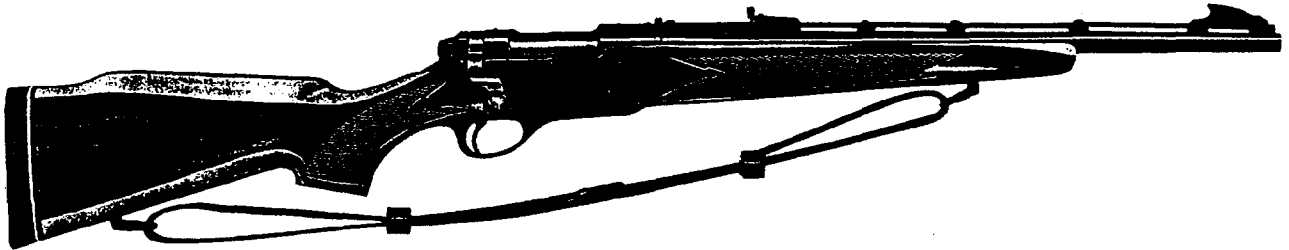
This malfunction may also be caused by improper sear safety cam — trigger connector engagement. Adjust engagement as previously described. (see note B).
3. **"Firing Pin Fails to Fall."** If firing pin fails to fall when trigger is pulled or trigger has to be pulled more than once. See firing pin falls 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.

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).

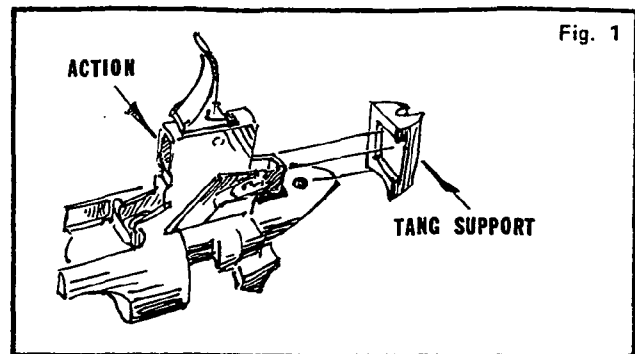


Fig. 1

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).

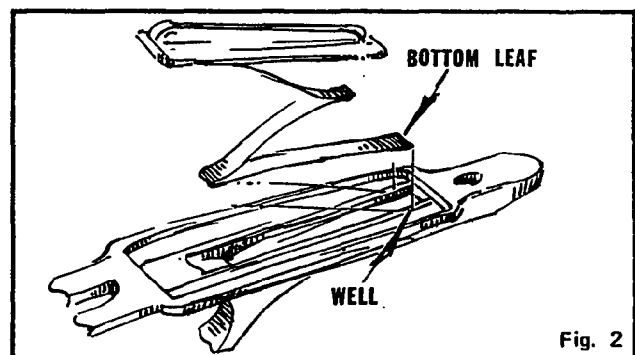


Fig. 2

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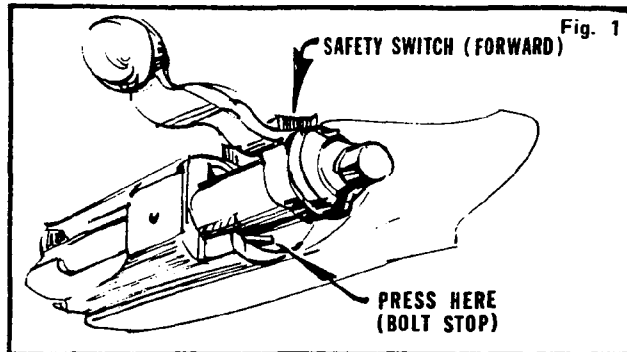
Send all guns for factory service and inquiries on
service and parts to

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

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.

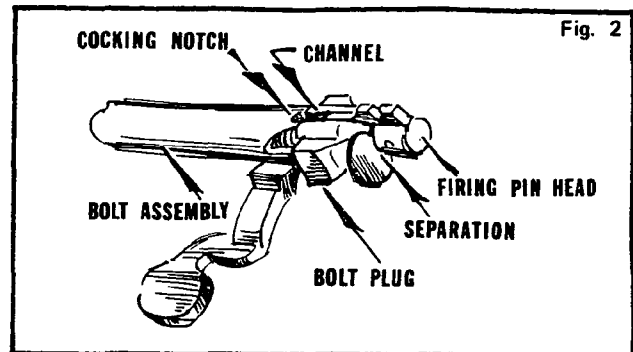
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

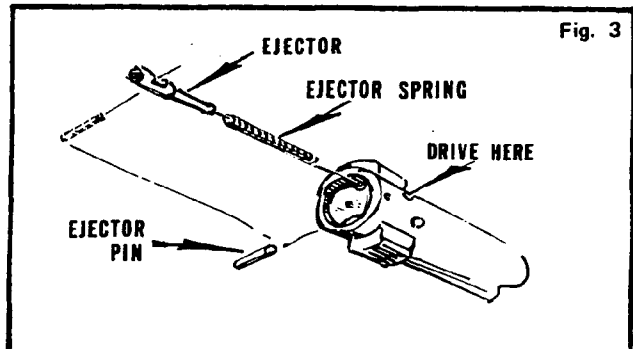
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

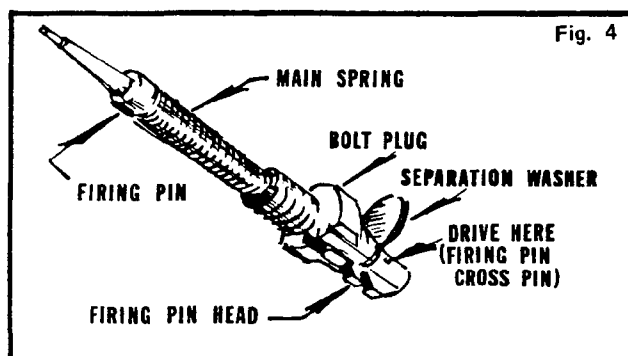
To Disassemble — Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

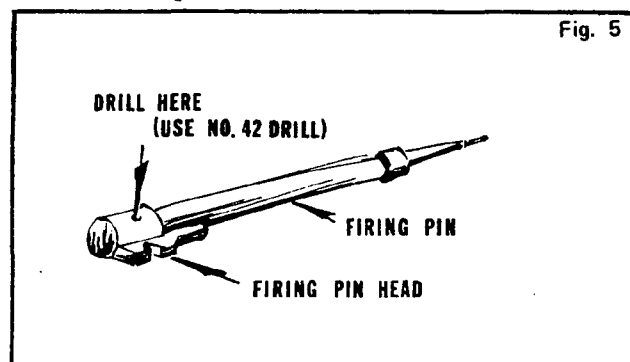
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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 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 re-assembled. 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° 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.

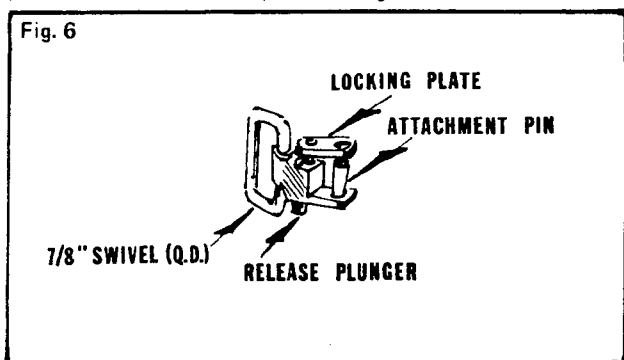
Front Swivel Screw — Use No. 13 drill.

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 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 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 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 tell-tale 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 style="list-style-type: none">1. Firing pin damaged.2. Firing pin binds.3. Firing pin protrusion faulty.4. Trigger assembly out of adjustment.5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none">1. Replace.2. Free up or replace.3. Replace firing pin.4. Return the firearm to the factory.5. Replace ammunition. |

UNLOCKING

- | | |
|--------------------|---|
| Cause: | <ol style="list-style-type: none">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: | <ol style="list-style-type: none">1. See Extraction.2. Smooth up bolt handle cam.3. Deburr.4. Ammunition may be at fault. |

EXTRACTION

- | | |
|--------------------|--|
| Cause: | <ol style="list-style-type: none">1. Fouled, rough, or enlarged chamber.2. Extractor broken or damaged.3. Not enough hook space on extractor.4. Height of claw not correct. |
| Correction: | <ol style="list-style-type: none">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

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle interferes with stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File end of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Return the firearm to the factory.
 3. Return the firearm to the factory.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge — rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.

- Correction:**
1. Ream.
 2. Re-head.
 3. Re-head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING

- 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.
- 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.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY SWITCH

- Cause:**
1. Safety switch binds (safety switch works hard).
 2. Safety switch snap washer stretches out (safety switch works too freely).
 3. Safety switch damaged.
- Correction:**
1. Return the firearm to the factory.
 2. Return the firearm to the factory.
 3. Return the firearm to the factory.

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.

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 Rem. Mag.		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
		Bolt Assembly, 308 Win.	44	15376	Fastener
		Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. 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)
6	15413	Bolt Stop Spring (Restricted)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.
	15741	Butt Plate (Model 600 only)		27650	Stock Assembly
	25410	Butt Plate Screw (Model 600 only)	51	15883	Tang Support (Magnum only)
7	17017	Ejector	52	15435	Trigger (Restricted)
8	17676	Ejector Pin	53	17049	Trigger Screw, Front (Restricted)
9	17019	Ejector Spring		26730	Trigger Assembly (Restricted)
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	54	15436	Trigger Connector (Restricted)
	16254	Extractor	55	15437	Trigger Guard
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. 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			
17	27365	Front Sight Assembly			
18	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Mag.			
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.			
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	17056	Magazine Follower			
20	17891	Magazine Spring			
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eyepiece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			
32	26795	Safety Switch Assembly (Restricted)			
33	21386	Recoil Pad (Magnum only)			
34	25410	Recoil Pad Screw (Magnum only)			
35	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)			
40	24476	Sear Pin (Restricted)			

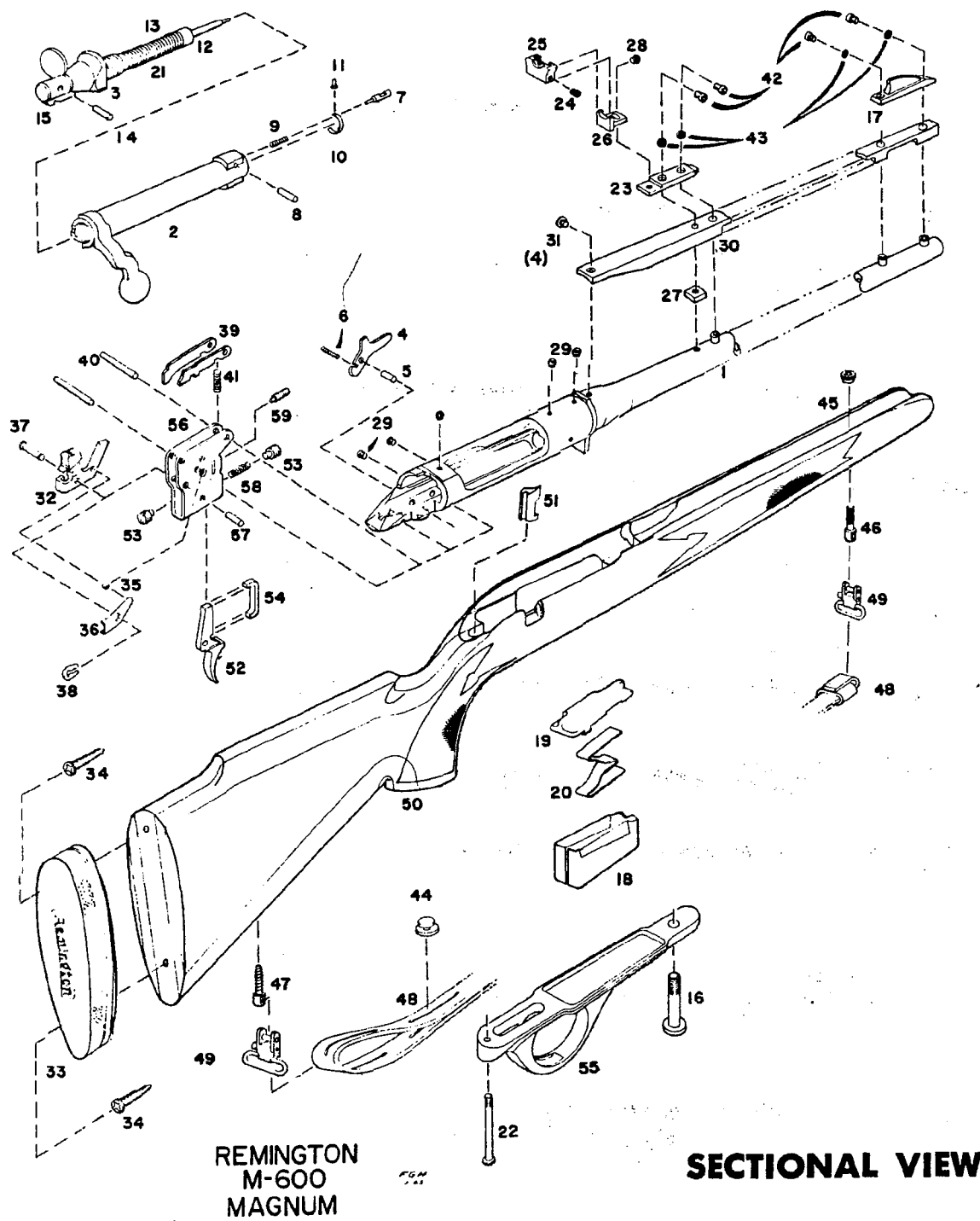
ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

Barrel Assembly, 35 Rem. (Superseded)
 Barrel Assembly, 222 Rem.
 Barrel Assembly, 6MM Rem.
 Barrel Assembly, 243 Win.
 Bolt Assembly, 35 Rem. (Superseded)
 Bolt Assembly, 222 Rem.
 Bolt Final Assembly, 35 Rem. (Superseded)
 Bolt Final Assembly, 222 Rem.
 Ejector, 222 Rem.
 Extractor, 222 Rem.
 Extractor Rivet, 222 Rem.
 Front Sight Assembly, 6 MM Rem., 243 Win.
 Magazine, 222 Rem.
 Magazine, 35 Rem. (Superseded)
 Magazine Follower, 222 Rem.
 Magazine Spacer, 222 Rem.
 Magazine Spring, 222 Rem.
 Rear Sight Base, 35 Rem. (Superseded)

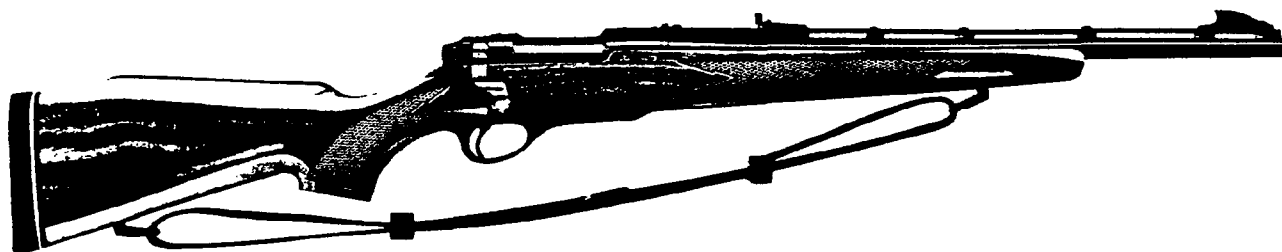
NOTE: See Basic Parts List for parts not listed above.

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.

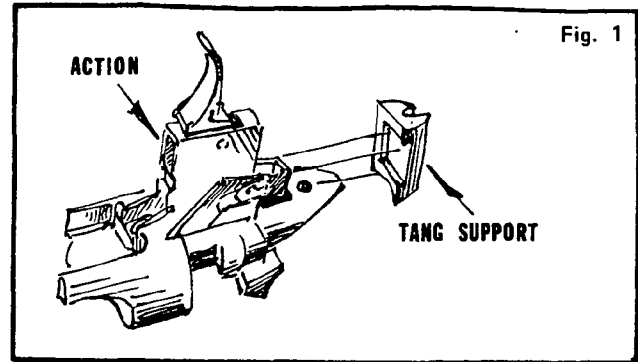
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See **TANG SUPPORT**

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).



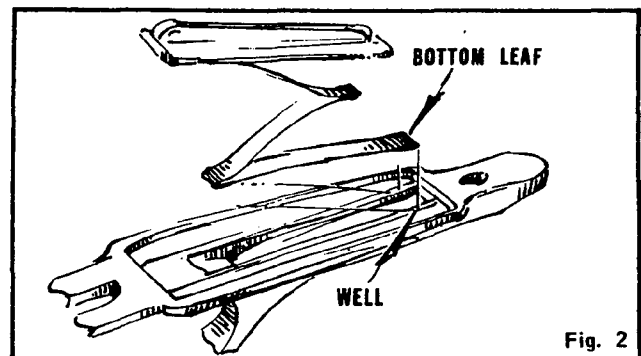
Reassemble stock assembly to action. Tighten firmly with guard screws.

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.

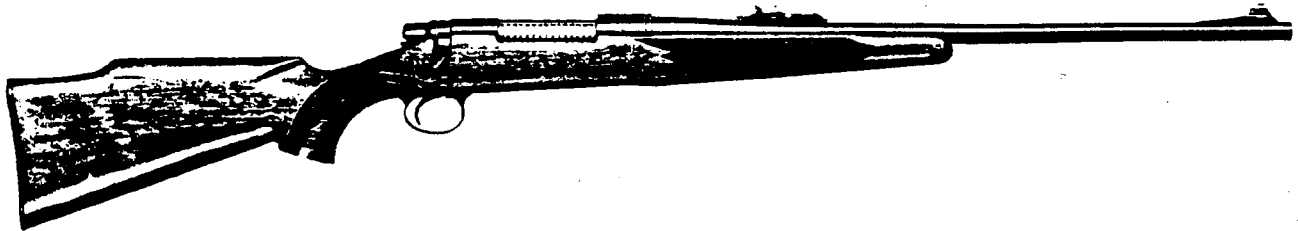
MAGAZINE (marked MAGNUM) — is designed for MAGNUM model use only. Do not use for Standard Model 600.

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
Ilion, New York 13357

All other inquiries are to be addressed to

REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

1982

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)

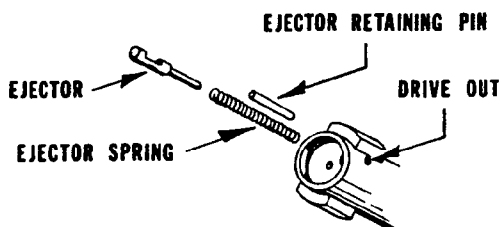


FIG. 1

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.

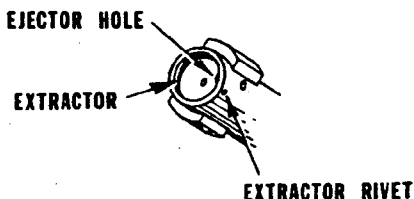


FIG. 2

Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.

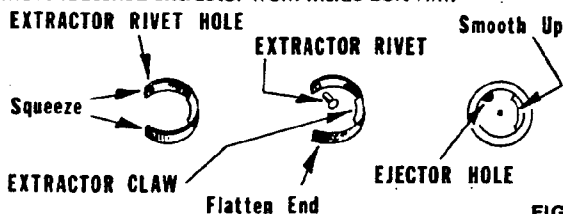


FIG. 3

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.

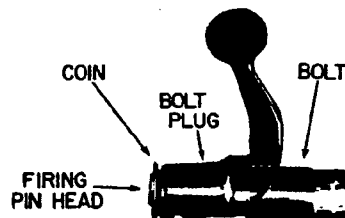
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

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.

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.

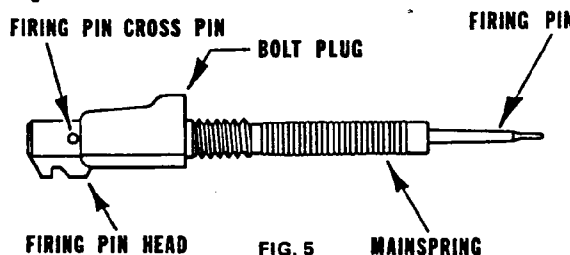


FIG. 5

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.

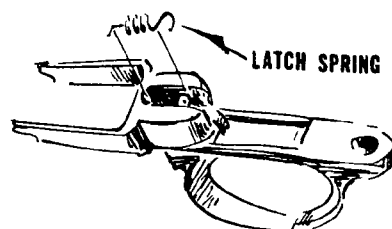


FIG. 6

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)

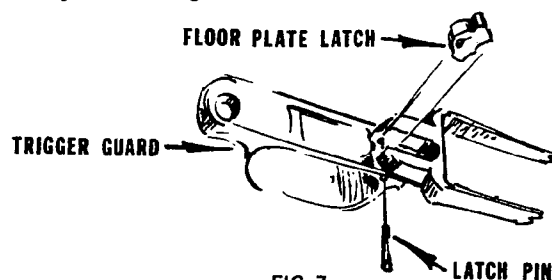


FIG. 7

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.
 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

- 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.

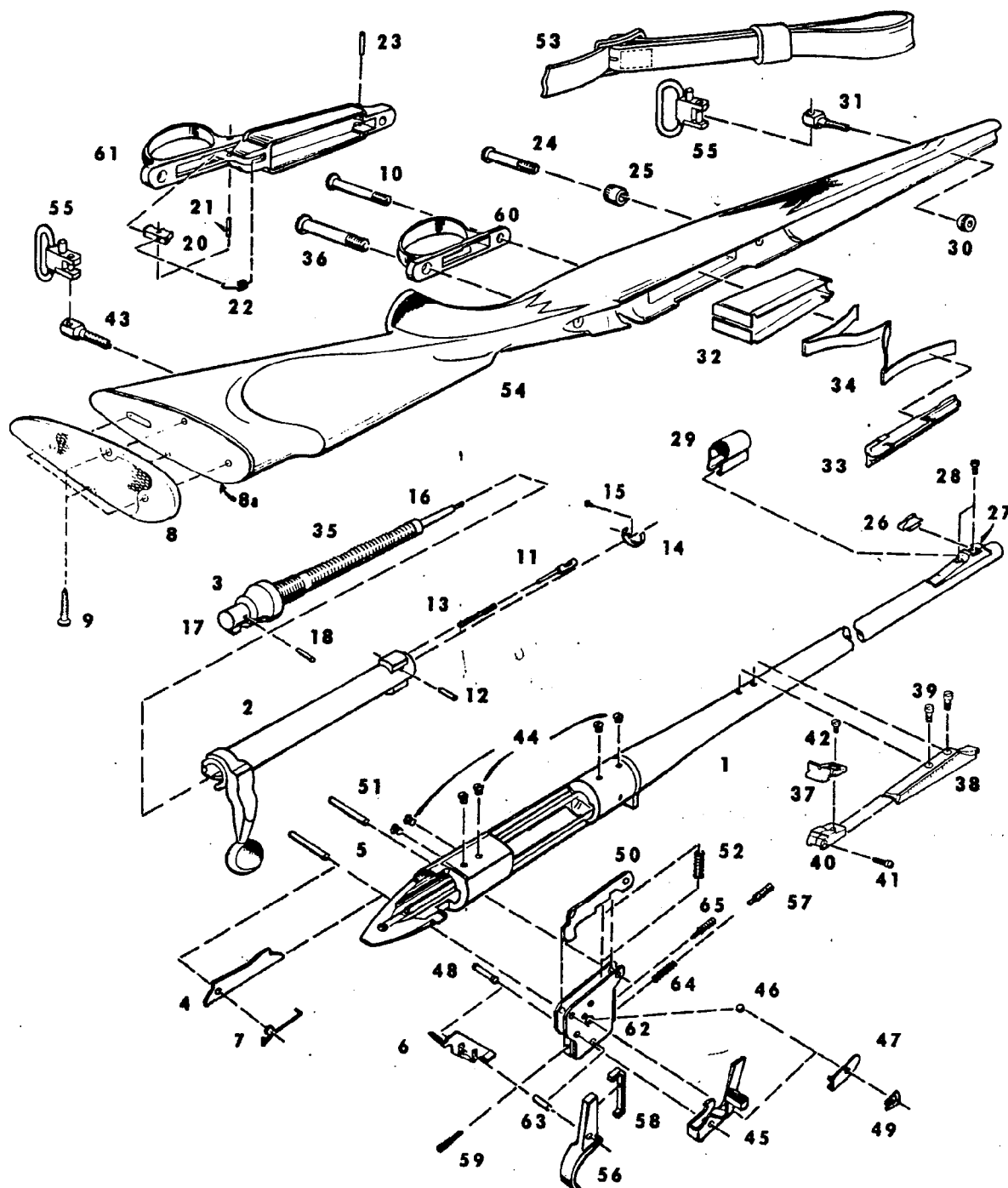
- Correction:**
1. Change Barrel or Barrel and Receiver Assembly.
 2. Fit new Bolt (ammunition may be at fault).

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.

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.			35	17029	Main Spring
1		Barrel Assembly	36	26355	Rear Guard Screw
2		Bolt Assembly	37	32510	Rear Sight Aperture
		Bolt Final Assembly	38	91595	Rear Sight Base
3	17012	Bolt Plug	39	28505	Rear Sight Base Screw (2)
4	17013	Bolt Stop (Restricted)	40	90905	Rear Sight Slide
5	24475	Bolt Stop Pin (Restricted)	41	90906	Elevation Screw
6	15478	Bolt Stop Release (Restricted)	42	90904	Windage Screw
7	15224	Bolt Stop Spring (Restricted)	43	15358	Rear Swivel Screw, BDL Grade
8	90953	Butt Plate	44	17034	Recalver Plug Screw
8a	90954	Butt Plate Spacer, BDL	45	26585	Safety Switch Assembly (Restricted)
9	25380	Butt Plate Screw	46	23222	Safety Switch Detent Ball (Restricted)
10	15287	Center Guard Screw, ADL Grade	47	15368	Safety Switch Detent Spring (Restricted)
11	17017	Ejector	48	17043	Safety Switch Pivot Pin (Restricted)
12	17676	Ejector Pin	49	17044	Safety Switch Snap Washer (Restricted)
13	17019	Ejector Spring	50	15666	Sear Safety Cam (Restricted)
14	91816	Extractor	51	24476	Sear Pin (Restricted)
	15376	Fastener, Sling Strap	52	17047	Sear Spring (Restricted)
16	22020	Firing Pin	53	30855	Sling Strap Assembly, BDL Grade
17	22040	Firing Pin Assembly		26990	Sling Strap Assembly and Mountings Complete
18	17022	Firing Pin Cross Pin	54	33366	Stock Assembly, ADL Grade
20	15291	Floor Plate Latch, BDL Grade		33371	Stock Assembly, BDL Grade
21	16451	Floor Plate Latch Pin, BDL Grade		18186	Stock Reinforcing Screw (not shown)
22	16452	Floor Plate Latch Spring, BDL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
23	16453	Floor Plate Pivot Pin, BDL Grade	55	26555	Swivel Assembly, BDL Grade (Q.D.)
24	22035	Front Guard Screw	56	15280	Trigger (Restricted)
25	15161	Front Guard Screw Bushing, ADL Grade	57	17053	Trigger Adjusting Screw (Restricted)
26	15373	Front Sight		26345	Trigger Assembly (Restricted)
	15719	Front Sight (Low)	58	19461	Trigger Connector (Restricted)
27	28510	Front Sight Ramp	59	91128	Trigger Engagement Screw (Restricted)
	15635	Front Sight Ramp, BDL Grade	60	15281	Trigger Guard
28	28505	Front Sight Ramp Screw	61	26376	Trigger Guard, BDL Grade
29	15363	Front Sight Hood, BDL Grade		26371	Trigger Guard Assembly, BDL Grade
30	15357	Front Swivel Nut, BDL Grade	62	26655	Trigger Housing Assembly (Restricted)
31	15358	Front Swivel Screw, BDL Grade	63	24477	Trigger Pin (Restricted)
	90957	Grip Cap, BDL Grade (not shown)	64	15400	Trigger Spring (Restricted)
	25380	Grip Cap Screw	65	15481	Trigger Stop Screw (Restricted)
	90958	Grip Cap Spacer, BDL Grade (not shown)			
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			
	15677	Magazine Spring, BDL Grade			



ADDITIONAL CALIBERS
 Not Shown in Sectional View)
CLUDES VARMINT MODEL

REMINGTON
FIELD SERVICE MANUAL

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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
91837	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem. 22-250 Rem., BDL Grade, 17 Rem.
91906	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.
22021	Firing Pin, 222 Rem., 234-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308 Win., 6mm Rem., 22-250 Rem. 223 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 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. (includes same as standard Magnum except Stock Bolt (2) Nut (2), Cover (4) used)
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	DISCONTINUED or SERVICE PARTS	
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	26270	Barrel Assembly, 280 Rem.
14756	Magazine, BDL Grade	20467	Extractor, 222 Cal.
10951	Magazine Follower, 222 Rem., 223 & 17 Rem.	17639	Ejector, 222 Cal.
10982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag. 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
15742	Magazine Spacer, 222 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
15286	Magazine Spacer, 222 Rem., BDL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
11133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2)
15698	Magazine Spring, 22-250 Rem.	15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag.
15699	Magazine Spring, 22-250 Rem., 6mm Rem. 243 Win., BDL Grade	15850	Extractor, 222-223 Rem., 17 Rem.
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win., 17 Rem.	27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.
18843	Rear Scope Base, Varmint	27342	Extractor Rivet, 222-223 Rem., 17 Rem.
10949	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag.		
15410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		
18842	Scope Base Screw, Rear Varmint		
16204	Scope Base Screw, Front Varmint		
13380	Stock Assembly, 7mm Rem. Mag., ADL Grade		
13365	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade		
13385	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)

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.

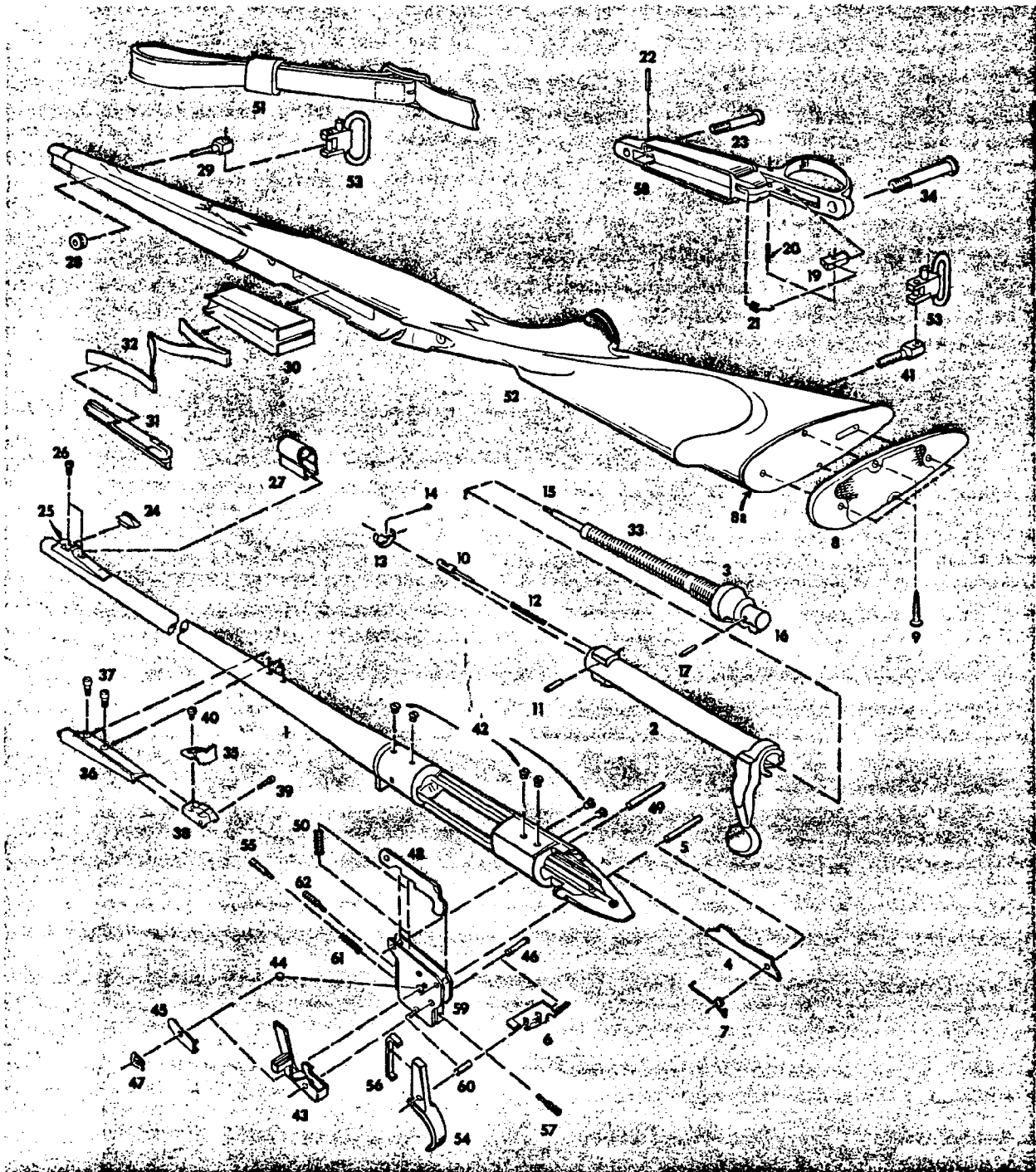
REMINGTON FIELD SERVICE MANUAL

Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 caliber listed below. For other caliber parts and numbers, see additional calibers list.		46	17043	Safety Switch Pivot Pin (Restricted)
		47	17044	Safety Switch Snap Washer (Restricted)
	Barrel Assembly	48	15666	Sear Safety Cam (Restricted)
	Bolt Assembly	49	24476	Sear Pin (Restricted)
	Bolt Final Assembly	50	17047	Sear Spring (Restricted)
17012	Bolt Plug	51	30855	Sling Strap Assembly
17013	Bolt Stop (Restricted)		26990	Sling Strap Assembly and Mountings Complete
24475	Bolt Stop Pin (Restricted)	52	33391	Stock Assembly
90555	Bolt Stop Release (Restricted)		18186	Stock Reinforcing Screw
90554	Bolt Stop Spring (Restricted)		16970	Stock Reinforcing Screw Dowel
90953	Butt Plate	53	26555	Swivel Assembly (Q.D.)
90954	Butt Plate Spacer	54	15280	Trigger (Restricted)
25380	Butt Plate Screw	55	17053	Trigger Adjusting Screw (Restricted)
17017	Ejector		32895	Trigger Assembly (Restricted)
17676	Ejector Pin	56	19461	Trigger Connector (Restricted)
17019	Ejector Spring	57	91128	Trigger Engagement Screw (Restricted)
91816	Extractor	58	26376	Trigger Guard
27340	Extractor Rivet		26371	Trigger Guard Assembly
15376	Fastener, Sling Strap	59	32905	Trigger Housing Assembly (Restricted)
22020	Firing Pin	60	24477	Trigger Pin (Restricted)
22040	Firing Pin Assembly	61	15400	Trigger Spring (Restricted)
17022	Firing Pin Cross Pin	62	15481	Trigger Stop Screw (Restricted)
15291	Floor Plate Latch	ADDITIONAL CALIBERS NOTE: Parts not listed, same as 30-06 Caliber. Barrel Assembly, 7mm Rem. Mag. Barrel Assembly, 270 Win. Bolt Assembly, 7mm Rem. Mag. Extractor, 7mm Rem. Mag. Extractor Rivet, 7mm Rem. Mag. Front Sight, 7mm Rem. Mag. Recoil Pad, 7mm Rem. Mag. Recoil Pad Screw, 7mm Rem. Mag. Stock Assembly, 7mm Rem. Mag.		
16451	Floor Plate Latch Pin			
16452	Floor Plate Latch Spring			
16453	Floor Plate Pivot Pin			
22035	Front Guard Screw			
15373	Front Sight			
15719	Front Sight (Low)			
15635	Front Sight Ramp			
28505	Front Sight Ramp Screw			
15363	Front Sight Hood			
15357	Front Swivel Nut			
15358	Front Swivel Screw			
90957	Grip Cap			
90958	Grip Cap Spacer			
25380	Grip Cap Spacer Screw			
16430	Magazine	91837	Extractor, 7mm Rem. Mag.	
91017	Magazine Follower	27341	Extractor Rivet, 7mm Rem. Mag.	
15677	Magazine Spring	14659	Front Sight, 7mm Rem. Mag.	
17029	Main Spring	90949	Recoil Pad, 7mm Rem. Mag.	
26355	Rear Guard Screw	25410	Recoil Pad Screw, 7mm Rem. Mag.	
32510	Rear Sight Aperture	33395	Stock Assembly, 7mm Rem. Mag.	
91595	Rear Sight Base			
28505	Rear Sight Screw			
90905	Rear Sight Slide			
90906	Elevation Screw			
90904	Windage Screw			
15358	Rear Swivel Screw			
17034	Receiver Plug Screw			
32900	Safety Switch Assembly (Restricted)			
23222	Safety Switch Detent Ball (Restricted)			
90557	Safety Switch Detent Spring (Restricted)			

EXPLODED
VIEW

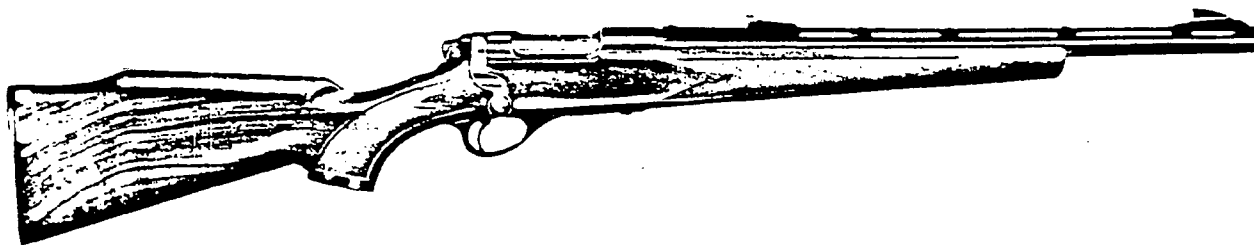
REMINGTON FIELD SERVICE MANUAL

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.

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Rear Sight Assembly	2	Sling Strap Assembly and Mountings Complete.	4
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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

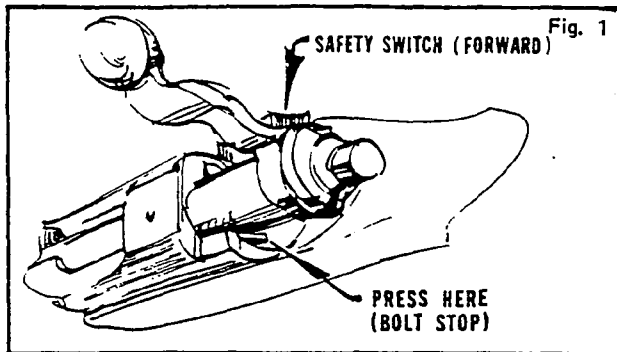
All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

1982

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.

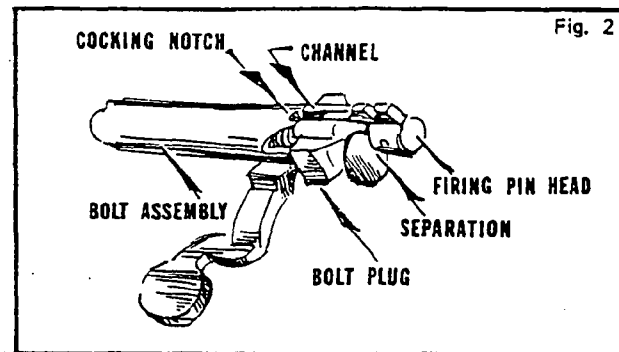
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble — Remove bolt final assembly from gun. Hold firing pin head in secure 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.

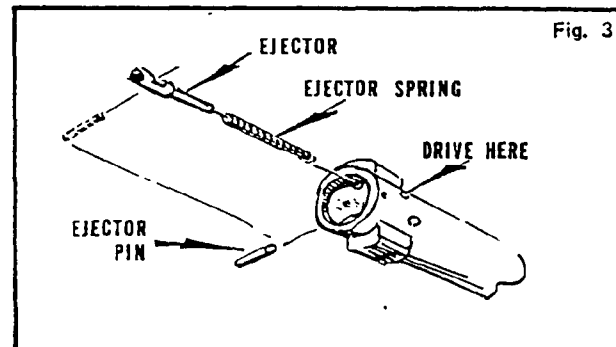
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

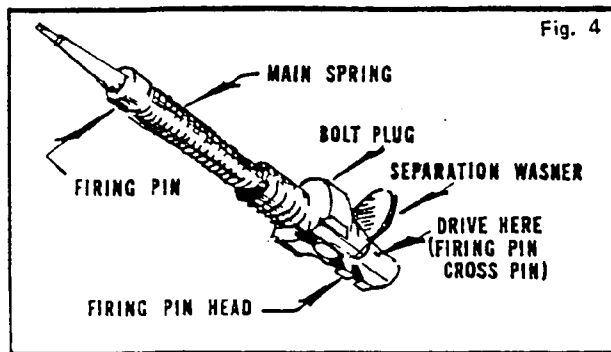
To Disassemble — Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

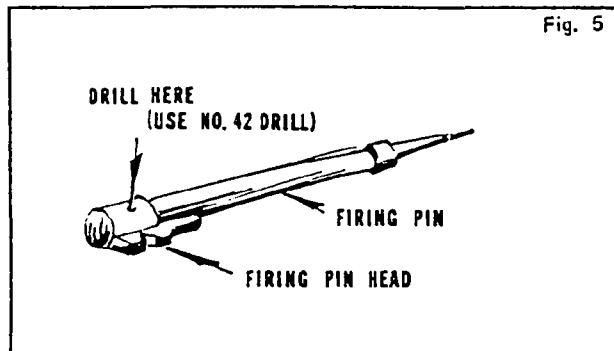
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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 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° 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.

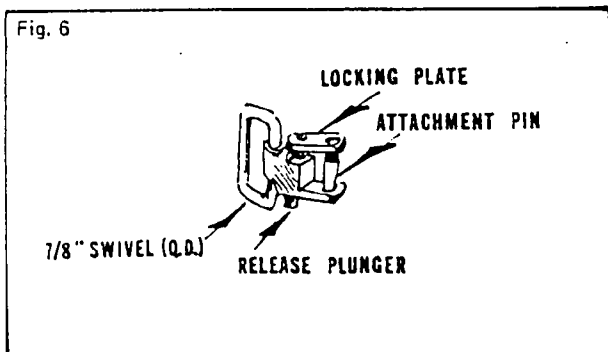
Front Swivel Screw — Use No. 13 drill.

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 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 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 tell-tale 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.
 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.

BOLT BINDS

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle interferes with stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File end of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Return the firearm to the factory.
 3. Return the firearm to the factory.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge — rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.

- Correction:**
1. Ream.
 2. Re-head.
 3. Re-head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING

- 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.
- 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.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY SWITCH

- Cause:**
1. Safety switch binds (safety switch works hard).
 2. Safety switch snap washer stretches out (safety switch works too freely).
 3. Safety switch damaged.
- Correction:**
1. Return the firearm to the factory.
 2. Return the firearm to the factory.
 3. Return the firearm to the factory.

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.

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 Rem. Mag.		26990	Sling Strap Assembly and Mountings, Complete
		Bolt Assembly, 308 Win.			Includes: 44 thru 49
		Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.	44	15376	Fastener
		Bolt Final Assembly, 308 Win.	45	15357	Front Swivel Nut
3	15409	Bolt Plug	46	15356	Front Swivel Screw
4	15412	Bolt Stop (Restricted)	47	15358	Rear Swivel Screw
5	24484	Bolt Stop Pin (Restricted)	48	26625	Sling Strap Assembly, 7/8"
6	15413	Bolt Stop Spring (Restricted)	49	26555	Swivel Assembly, Q.D. (each)
	15741	Butt Plate (Model 600 only)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.
	25410	Butt Plate Screw (Model 600 only)		27650	Stock Assembly
7	17017	Ejector	51	15883	Tang Support (Magnum only)
8	17676	Ejector Pin	52	15435	Trigger (Restricted)
9	17019	Ejector Spring	53	17049	Trigger Screw, Front (Restricted)
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.		26730	Trigger Assembly (Restricted)
	16254	Extractor	54	15436	Trigger Connector (Restricted)
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27340	Extractor Rivet (except 222 Rem.)	56	15429	Trigger Housing (Restricted)
12	15410	Firing Pin	57	24477	Trigger Pin (Restricted)
13	26715	Firing Pin Assembly	58	17978	Trigger Spring (Restricted)
14	17022	Firing Pin Cross Pin	59	17053	Trigger Stop Screw (Restricted)
15	23321	Firing Pin Head			
16	15653	Front Guard Screw			
17	27365	Front Sight Assembly			
18	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Mag.			
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.			
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	17056	Magazine Follower			
20	17891	Magazine Spring			
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eyepiece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			
32	26795	Safety Switch Assembly (Restricted)			
33	21386	Recoil Pad (Magnum only)			
34	25410	Recoil Pad Screw (Magnum only)			
35	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)			
40	24476	Sear Pin (Restricted)			

ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

Barrel Assembly, 35 Rem. (Superseded)

Barrel Assembly, 222 Rem.

Barrel Assembly, 6MM Rem.

Barrel Assembly, 243 Win.

Bolt Assembly, 35 Rem. (Superseded)

Bolt Assembly, 222 Rem.

Bolt Final Assembly, 35 Rem. (Superseded)

Bolt Final Assembly, 222 Rem.

15852 Ejector, 222 Rem.

15850 Extractor, 222 Rem.

27342 Extractor Rivet, 222 Rem.

27366 Front Sight Assembly, 6 MM Rem., 243 Win.

27261 Magazine, 222 Rem.

27262 Magazine, 35 Rem. (Superseded)

16793 Magazine Follower, 222 Rem.

15742 Magazine Spacer, 222 Rem.

17983 Magazine Spring, 222 Rem.

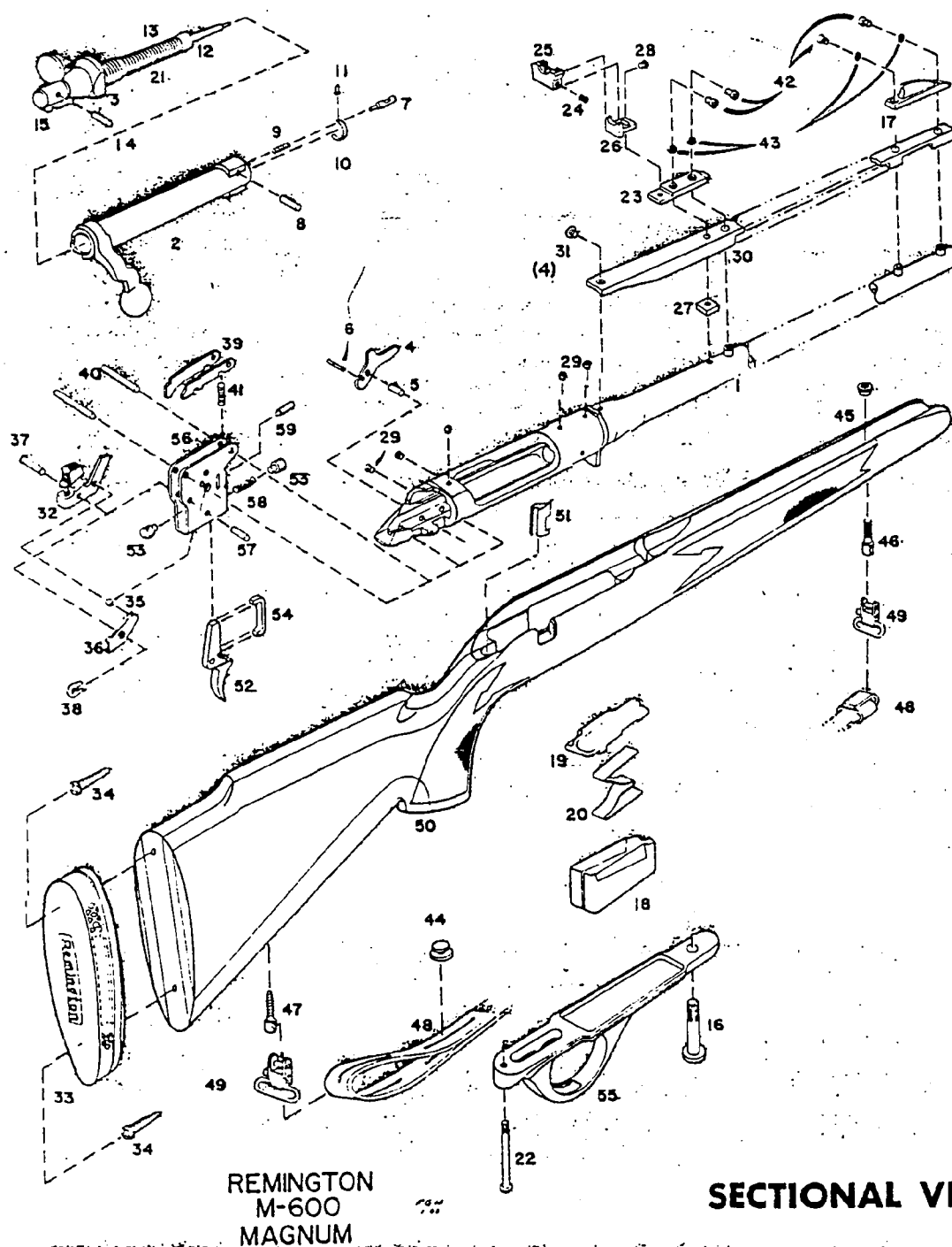
15600 Rear Sight Base, 35 Rem. (Superseded)

NOTE: See Basic Parts List for parts not listed above.

EXPLODED
VIEW

MODEL 600

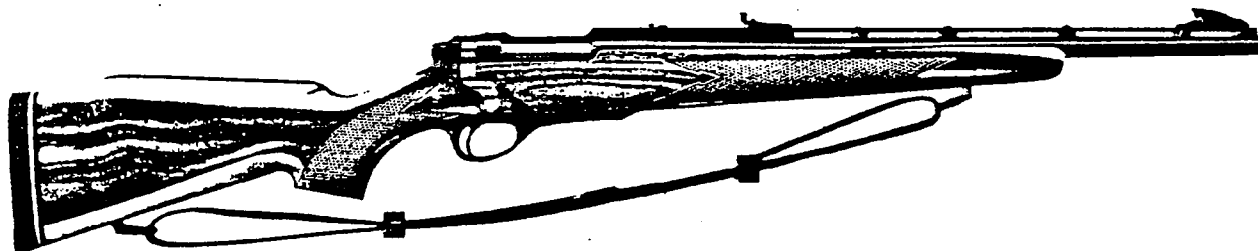
REMINGTON FIELD SERVICE MANUAL



SECTIONAL VIEW

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.

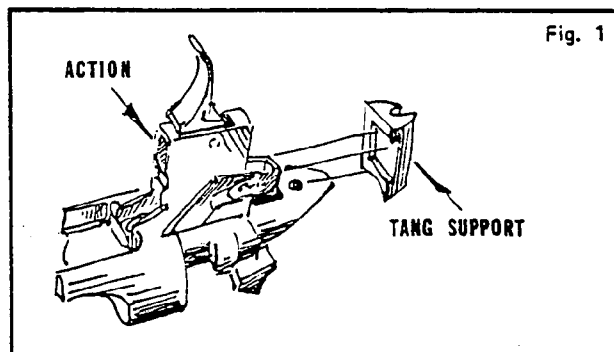
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See **TANG SUPPORT**

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).



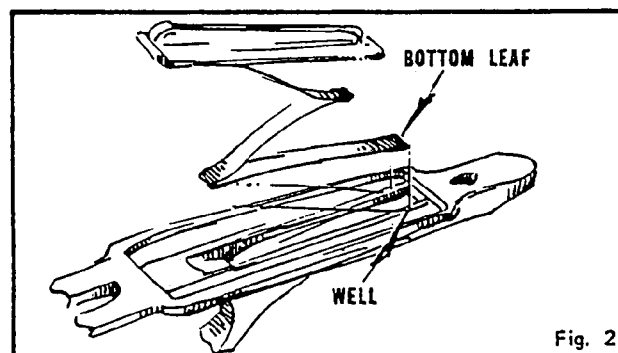
Reassemble stock assembly to action. Tighten firmly with guard screws.

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.

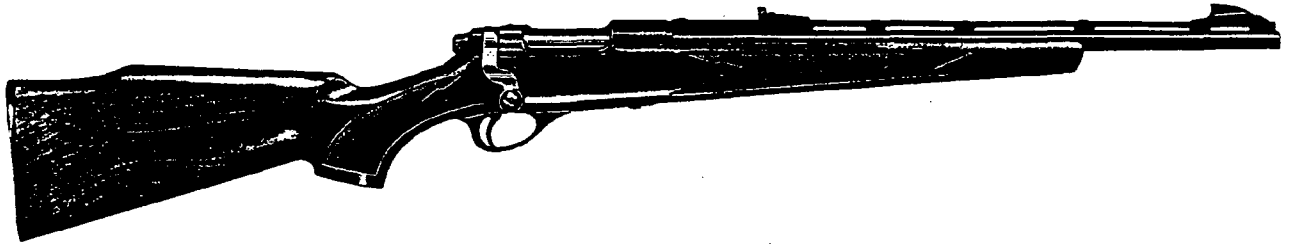
MODEL 600 - FIELD SERVICE MANUAL

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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

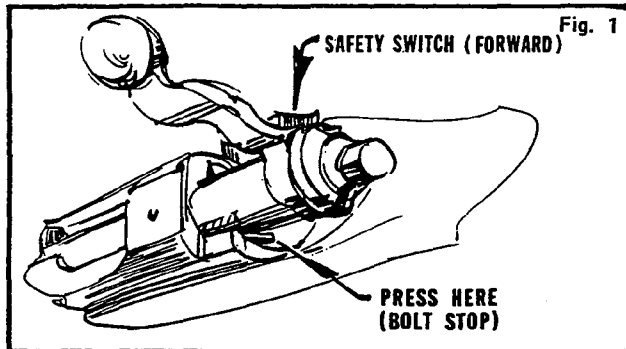
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

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.

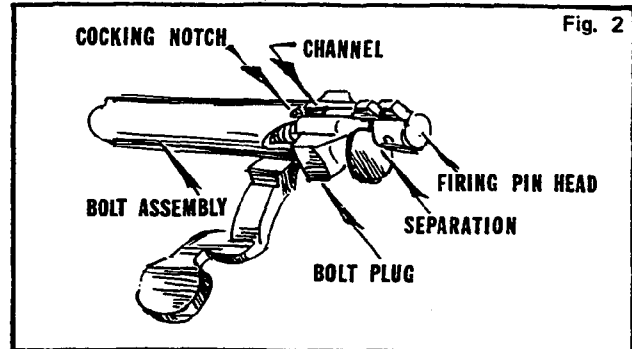
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

FIRING PIN ASSEMBLY from BOLT ASSEMBLY

To Disassemble — Remove bolt final assembly from gun. Hold firing pin head in secure 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.

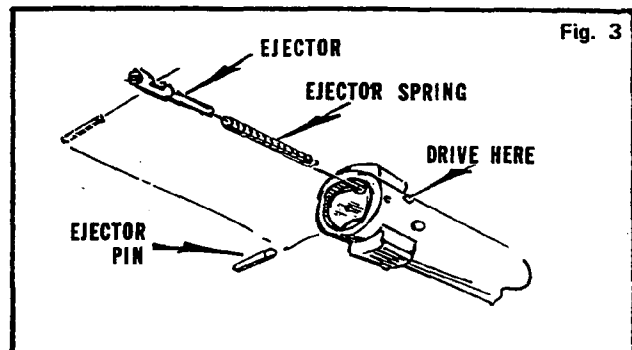
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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)

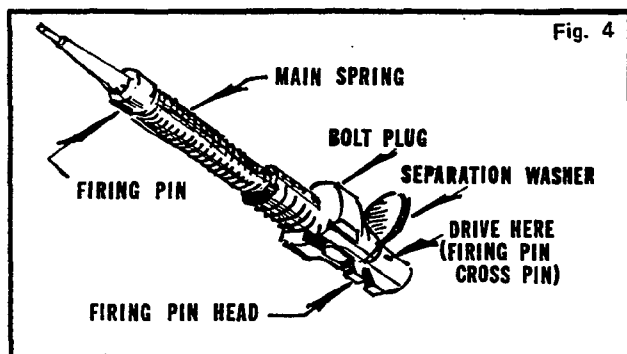
To Disassemble — Remove bolt final assembly from gun. Remove ejector, Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

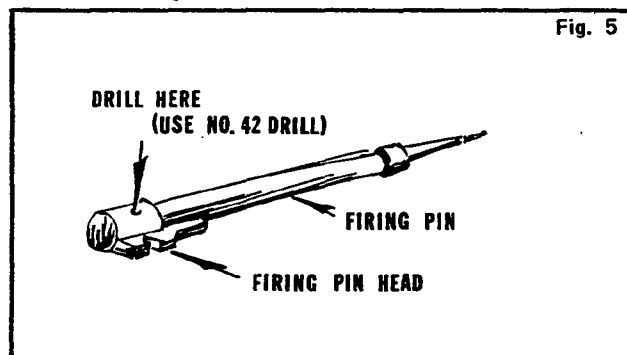
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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 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° 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.

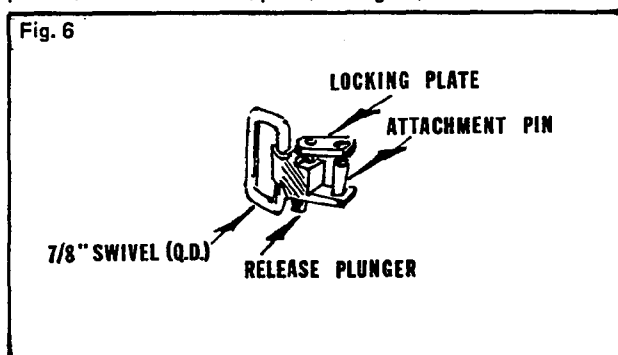
Front Swivel Screw — Use No. 13 drill.

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 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 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 tell-tale 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 style="list-style-type: none">1. Firing pin damaged.2. Firing pin binds.3. Firing pin protrusion faulty.4. Trigger assembly out of adjustment.5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none">1. Replace.2. Free up or replace.3. Replace firing pin.4. Return the firearm to the factory.5. Replace ammunition. |

UNLOCKING

- | | |
|-------------|---|
| Cause: | <ol style="list-style-type: none">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: | <ol style="list-style-type: none">1. See Extraction.2. Smooth up bolt handle cam.3. Deburr.4. Ammunition may be at fault. |

EXTRACTION

- | | |
|-------------|--|
| Cause: | <ol style="list-style-type: none">1. Fouled, rough, or enlarged chamber.2. Extractor broken or damaged.3. Not enough hook space on extractor.4. Height of claw not correct. |
| Correction: | <ol style="list-style-type: none">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

- Cause:**
1. Guard screws protrude into bolt track.
 2. Receiver plug screws protrude into bolt track.
 3. Bolt handle interferes with stock.
 4. Damage at rear of bolt lugs.
- Correction:**
1. File end of screws.
 2. File end of screws.
 3. Clear stock or fit new stock.
 4. Stone to blend. Check head space.

EJECTION

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Extractor binds.
- Correction:**
1. Deburr.
 2. Free up or replace.
 3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

- Cause:**
1. Bolt stop or bolt release binds.
 2. Bolt stop or bolt release broken.
 3. Bolt stop spring damaged.
- Correction:**
1. Free up.
 2. Return the firearm to the factory.
 3. Return the firearm to the factory.

FEEDING

- Cause:**
1. Magazine follower binds.
 2. Weak or defective follower spring.
 3. Magazine spring caught under guard.
 4. Damaged chamfer on bolt head.
 5. Tabs on follower bent.
- Correction:**
1. Adjust side angle on magazine.
 2. Replace spring.
 3. Correct.
 4. Replace bolt, or stone smooth.
 5. Straighten or replace follower.

LOADING

- Cause:**
1. Damaged receiver rails.
 2. Sharp edge — rear end of chamber.
 3. Rough loading ramp in receiver.
- Correction:**
1. Polish or reshape.
 2. Remove sharpness.
 3. Polish ramp.

LOCKING

- Cause:**
1. Shallow throat.
 2. Min. head space.
 3. Damaged chamber.
 4. Extractor interferes with shell rim.
 5. Ejector binds or fails to retract far enough.
 6. Burr at ejector hole in bolt.
 7. Sharp corners in bolt lugs.

- Correction:**
1. Ream.
 2. Re—head.
 3. Re—head.
 4. Fit new extractor (grind relief in new extractor behind claw).
 5. Free up or replace.
 6. Deburr.
 7. Stone radius.

COCKING

- 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.
- 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.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.
- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

SAFETY SWITCH

- Cause:**
1. Safety switch binds (safety switch works hard).
 2. Safety switch snap washer stretches out (safety switch works too freely).
 3. Safety switch damaged.
- Correction:**
1. Return the firearm to the factory.
 2. Return the firearm to the factory.
 3. Return the firearm to the factory.

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.

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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 Rem. Mag.		26990	Sling Strap Assembly and Mountings, Complete Includes: 44 thru 49
		Bolt Assembly, 308 Win.	44	15376	Fastener
		Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. 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)
6	15413	Bolt Stop Spring (Restricted)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.
	15741	Butt Plate (Model 600 only)		27650	Stock Assembly
	25410	Butt Plate Screw (Model 600 only)	51	15883	Tang Support (Magnum only)
7	17017	Ejector	52	15435	Trigger (Restricted)
8	17676	Ejector Pin	53	17049	Trigger Screw, Front (Restricted)
9	17019	Ejector Spring		26730	Trigger Assembly (Restricted)
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.	54	15436	Trigger Connector (Restricted)
	16254	Extractor	55	15437	Trigger Guard
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. 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			
17	27365	Front Sight Assembly			
18	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Mag.			
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.			
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	17056	Magazine Follower			
20	17891	Magazine Spring			
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eyeiece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			
32	26795	Safety Switch Assembly (Restricted)			
33	21386	Recoil Pad (Magnum only)			
34	25410	Recoil Pad Screw (Magnum only)			
35	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)			
40	24476	Sear Pin (Restricted)			

ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

Barrel Assembly, 35 Rem. (Superseded)
 Barrel Assembly, 222 Rem.
 Barrel Assembly, 6MM Rem.
 Barrel Assembly, 243 Win.
 Bolt Assembly, 35 Rem. (Superseded)
 Bolt Assembly, 222 Rem.
 Bolt Final Assembly, 35 Rem. (Superseded)
 Bolt Final Assembly, 222 Rem.
 Ejector, 222 Rem.
 Extractor, 222 Rem.
 Extractor Rivet, 222 Rem.
 Front Sight Assembly, 6 MM Rem., 243 Win.
 Magazine, 222 Rem.
 Magazine, 35 Rem. (Superseded)
 Magazine Follower, 222 Rem.
 Magazine Spacer, 222 Rem.
 Magazine Spring, 222 Rem.
 Rear Sight Base, 35 Rem. (Superseded)

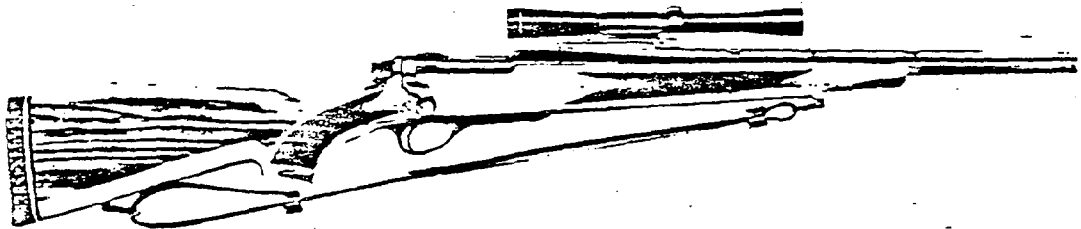
NOTE: See Basic Parts List for parts not listed above.

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 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.

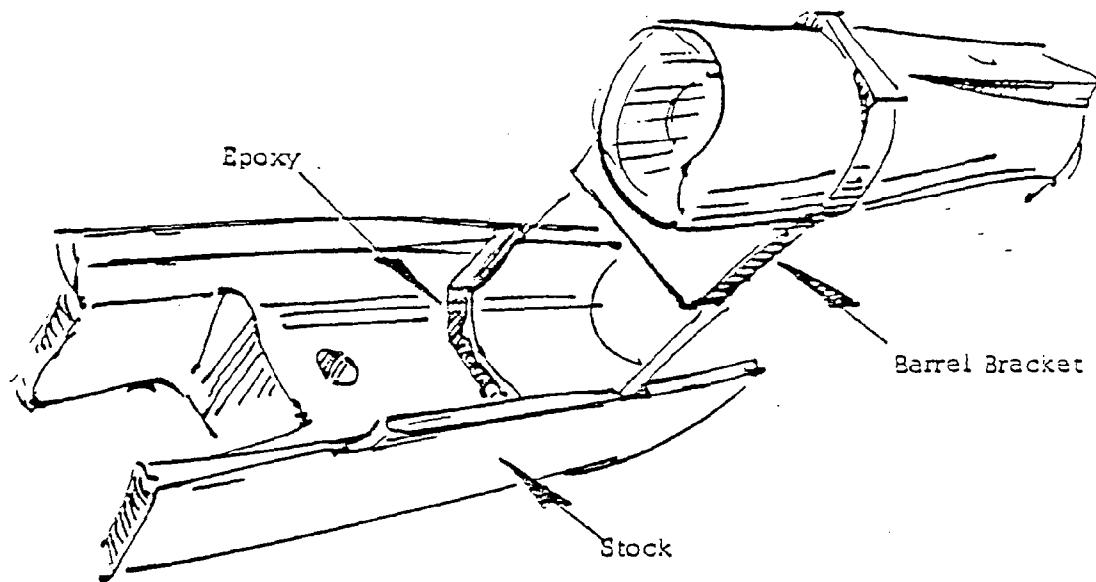
MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

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REMINGTON
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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.

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. See Sketch.



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.

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STOCK ASSEMBLY - Continued

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. 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.

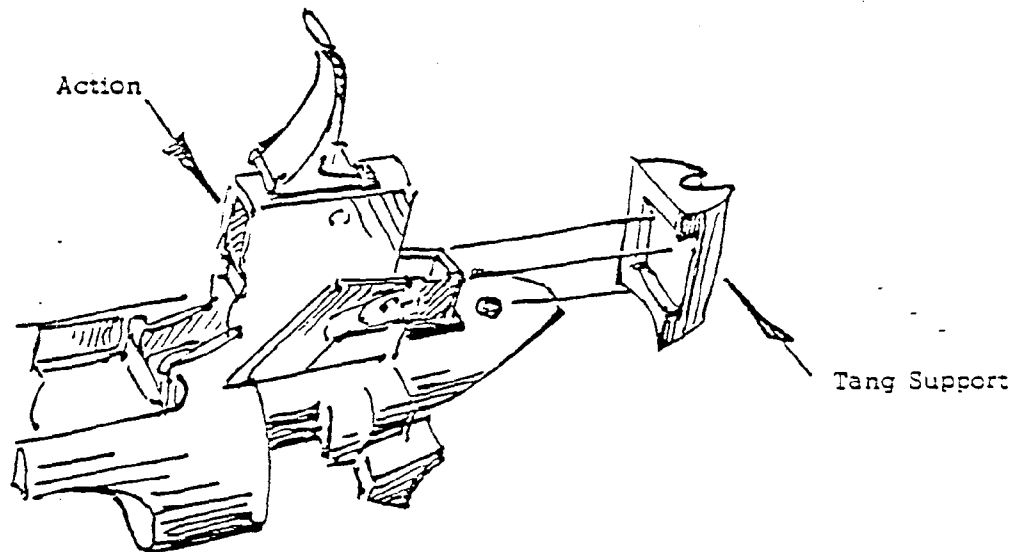
To Disassemble - Remove stock assembly. Remove loosened tang support from rear of action.

To Service - Replacement tang supports are interchangeable with no adjustment required.

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FIELD SERVICE MANUAL

TANG SUPPORT - Continued

To Reassemble - 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.

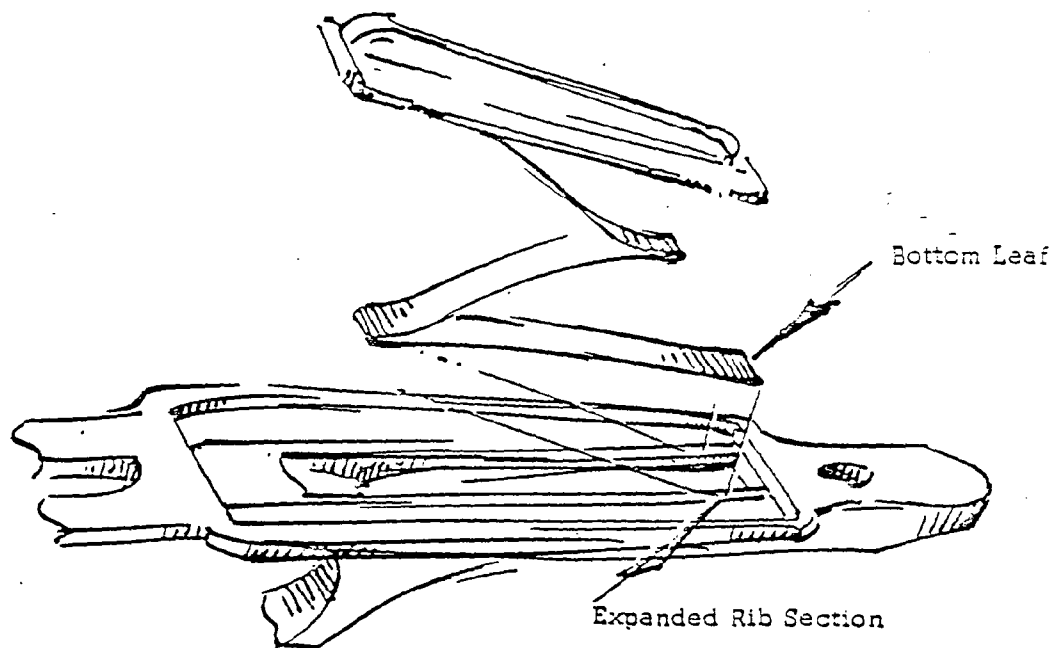
To Disassemble - Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

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 without expanded rib section on Standard Model 600.

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FIELD SERVICE MANUAL

TRIGGER GUARD - Continued

To Reassemble - 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.

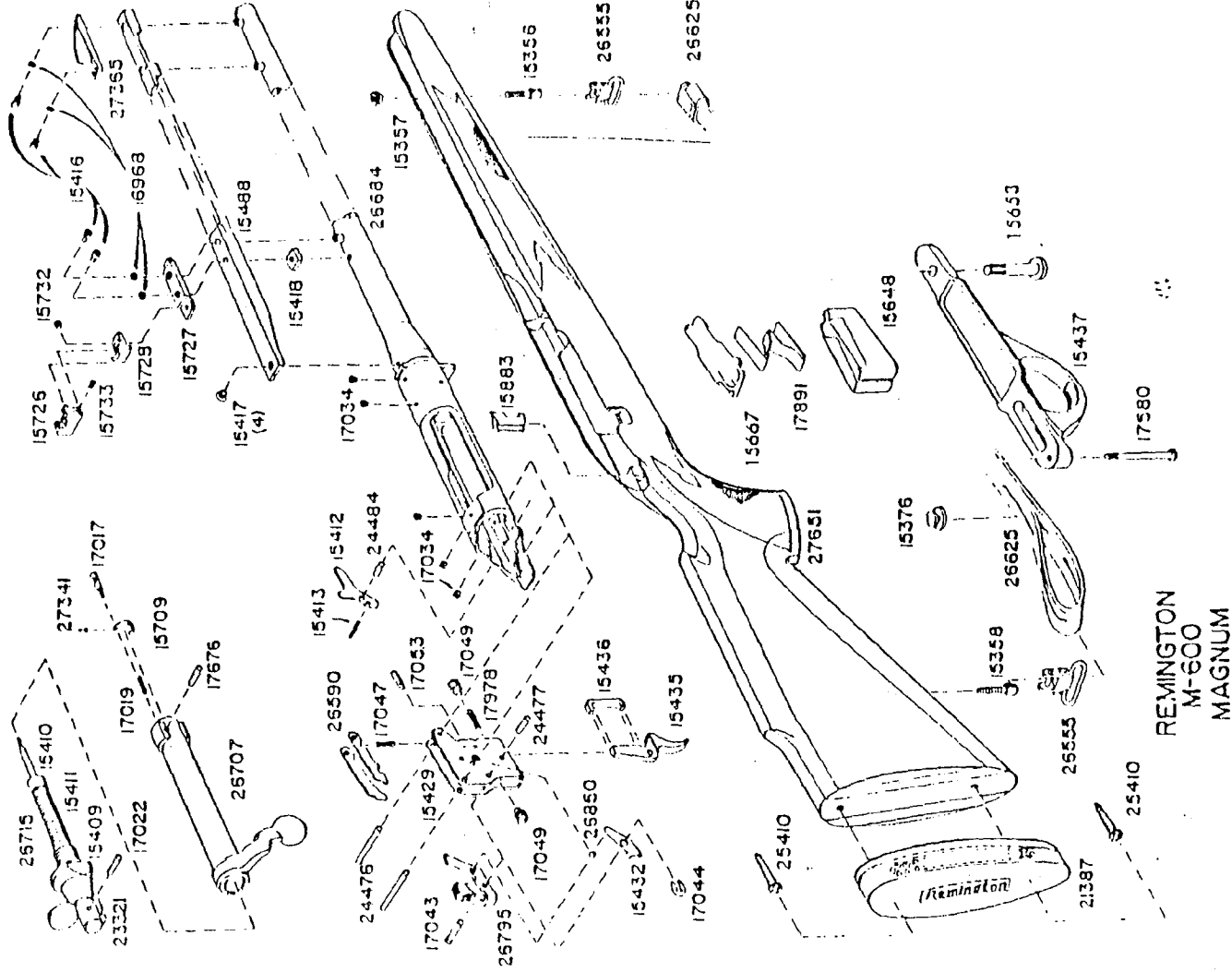
REMINGTON
FIELD SERVICE MANUAL

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.

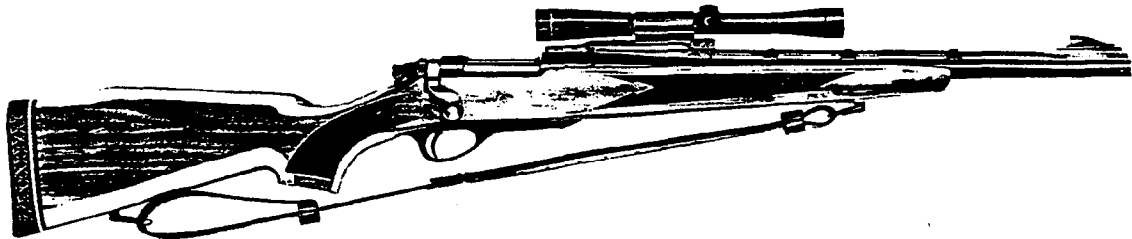
To Reassemble - Make certain magazine locates correctly into base of receiver. Upper magazine rim must assemble fully into magazine recess channel in receiver.

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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
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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.

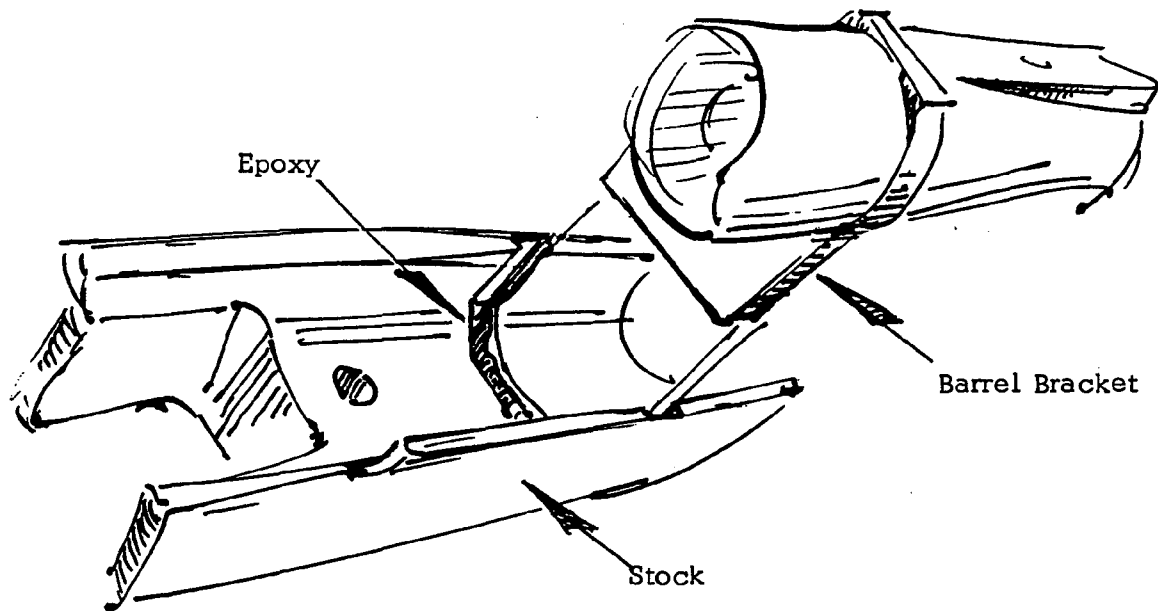
MAGNUM Parts - See added SECTIONAL VIEW for complete listing of MAGNUM Model.

JFF:T 665
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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.

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. See Sketch.



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.

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STOCK ASSEMBLY - Continued

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. 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.

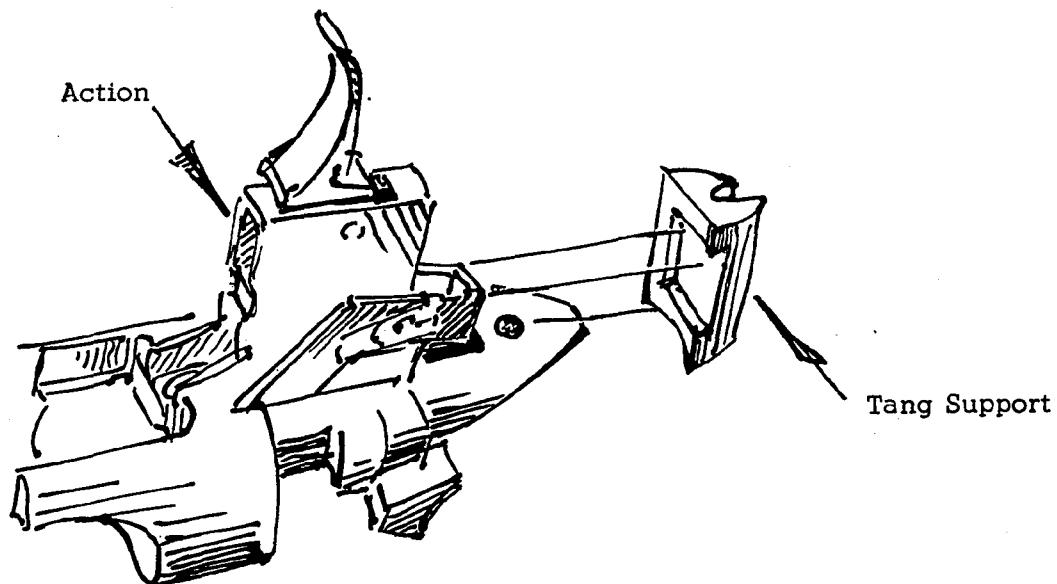
To Disassemble - Remove stock assembly. Remove loosened tang support from rear of action.

To Service - Replacement tang supports are interchangeable with no adjustment required.

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TANG SUPPORT - Continued

To Reassemble - 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.

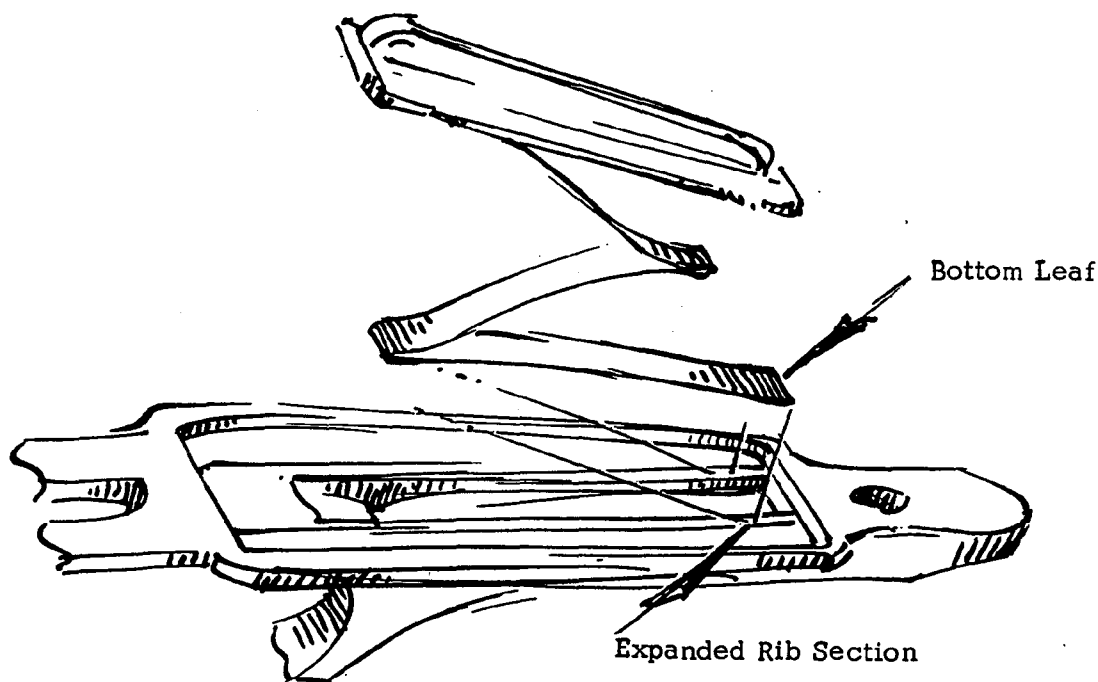
To Disassemble - Unscrew front guard screw, rear guard screw. Lift away and disassemble guard from stock.

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 without expanded rib section on Standard Model 600.

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TRIGGER GUARD - Continued

To Reassemble - 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.

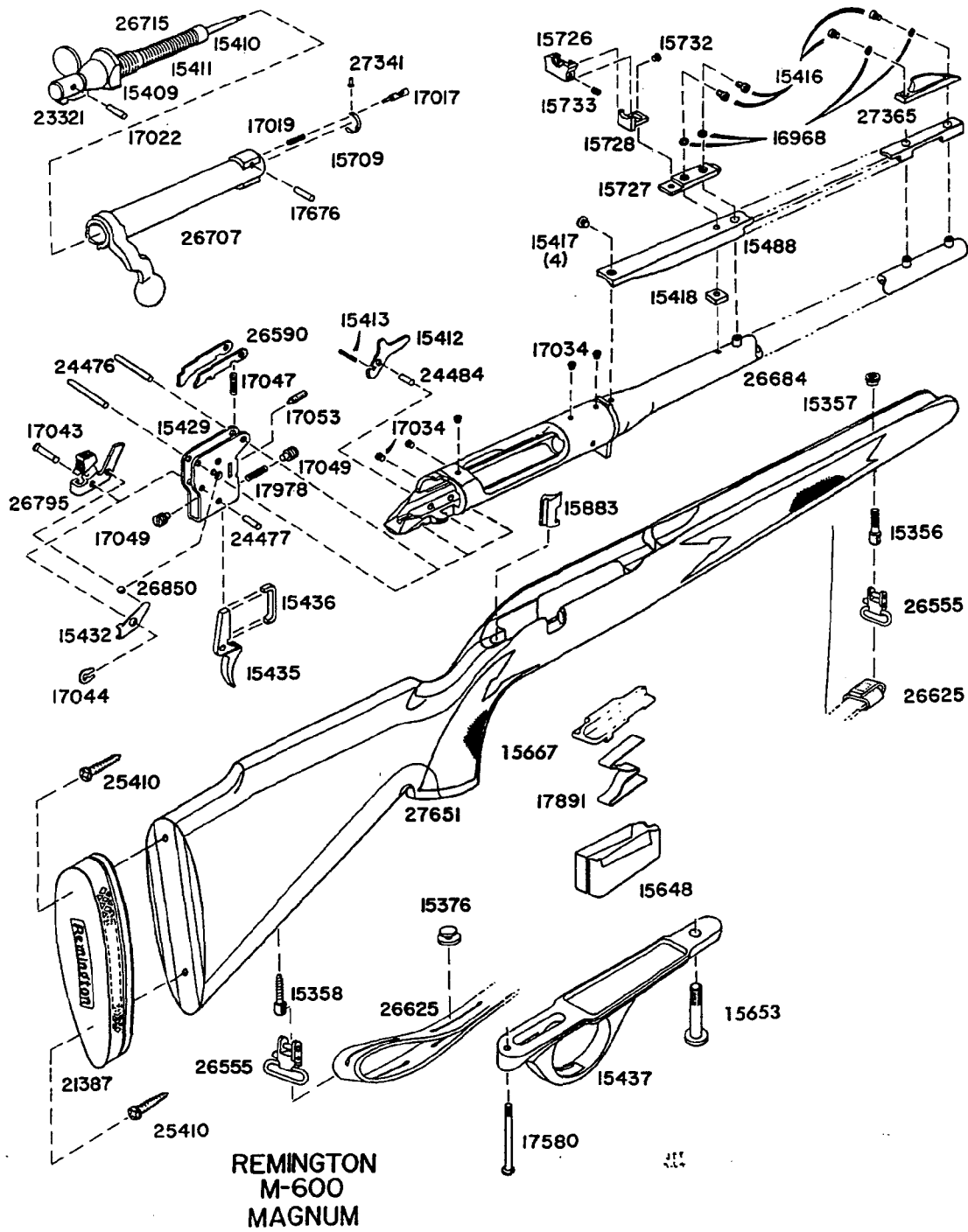
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MAGAZINE (marked MAGNUM) - is designed for MAGNUM model use only.
Do not use for Standard Model 600.

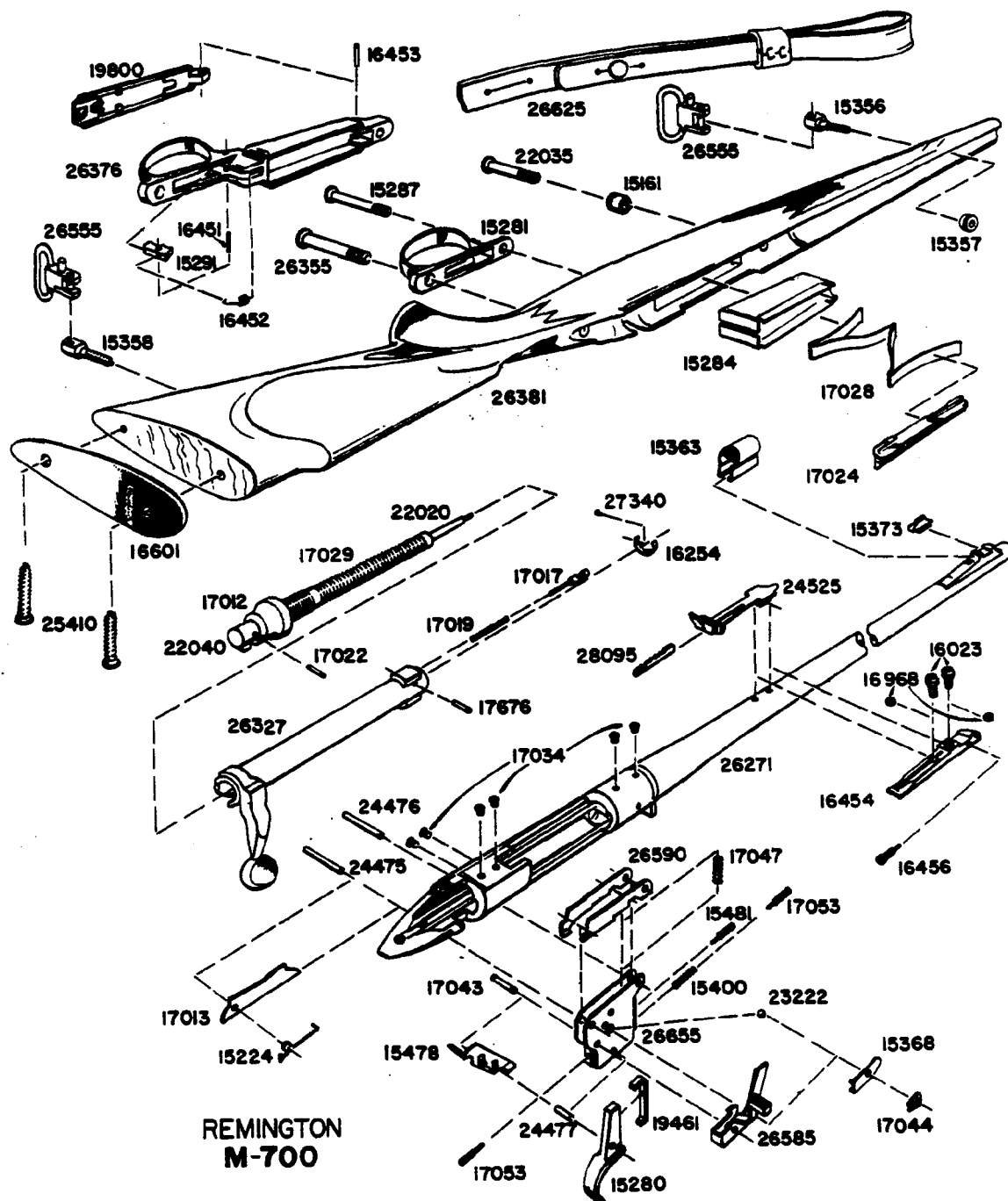
NOTE short width cross leaf (2) at bottom of MAGNUM magazine. This allows full depth for bottom leaf of magazine spring against trigger guard ---- and insures full Magnum cartridge capacity in magazine.

To Reassemble - 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

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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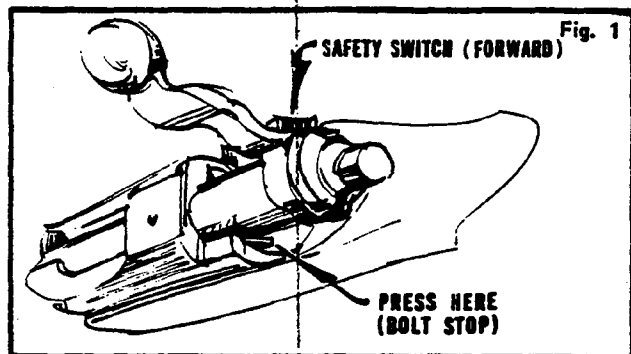
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Send all guns for factory service and inquiries on
service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

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.

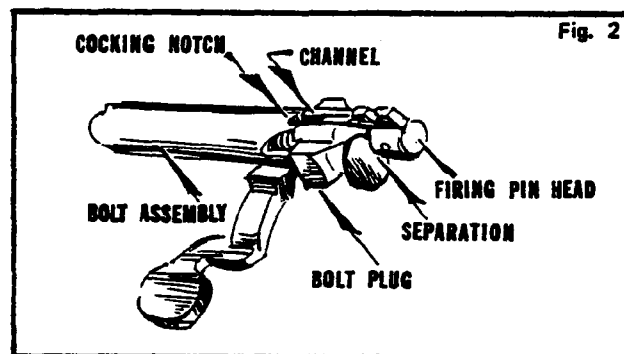
BOLT FINAL ASSEMBLY — COMPONENTS — Include Bolt Assembly; Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, and Firing Pin Assembly — which includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring.

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.

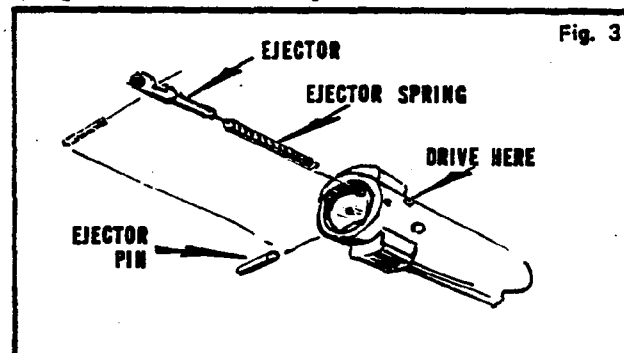
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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 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)

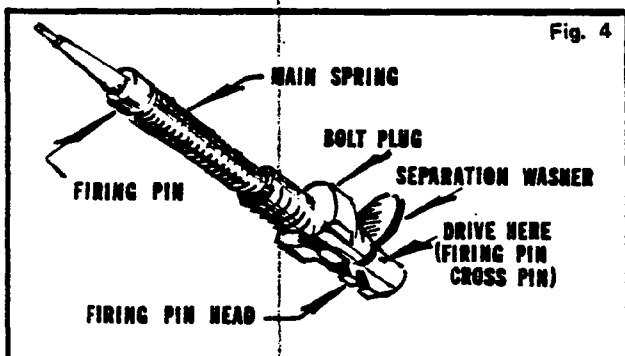
To Disassemble — Remove bolt final assembly from gun. Remove ejector. Drive out extractor rivet — from outside of bolt. Remove rivet from inside of bolt rim. Dislodge loosened extractor and disassemble from inside of bolt rim.

To Service — Interchangeable. However, extractor rivet will mutilate when extractor is disassembled. Use replacement rivet to secure extractor properly, when reassembled. Use fired cartridge 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).

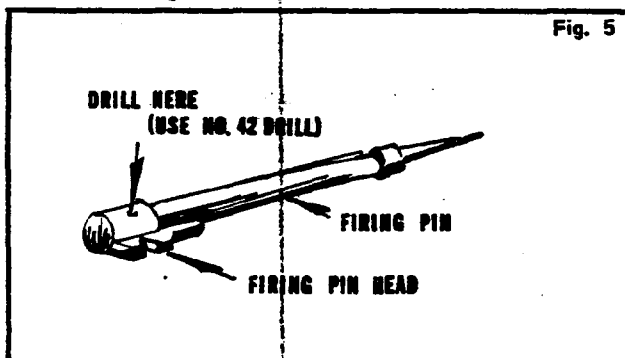
To Disassemble — Remove bolt final assembly from gun. Separate firing pin assembly (with holding washer). Unscrew and disassemble from bolt assembly. Hold firing pin head securely (in separation from bolt plug) and drive out firing pin cross pin. All parts of firing pin assembly should separate for disassembly.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

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° 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.

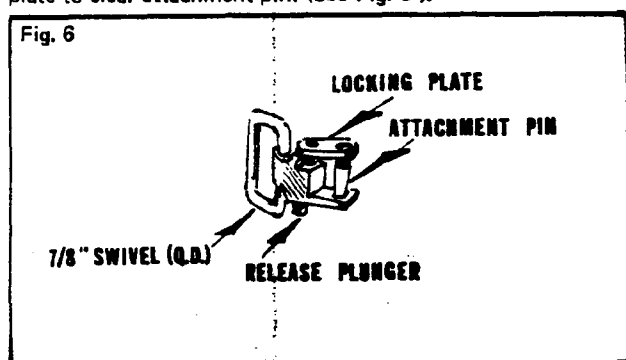
Front Swivel Screw — Use No. 13 drill.

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 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 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 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 tell-tale 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 style="list-style-type: none">1. Firing pin damaged.2. Firing pin binds.3. Firing pin protrusion faulty.4. Trigger assembly out of adjustment.5. Faulty ammunition. |
| Correction: | <ol style="list-style-type: none">1. Replace.2. Free up or replace.3. Replace firing pin.4. Return the firearm to the factory.5. Replace ammunition. |

UNLOCKING

- | | |
|--------------------|---|
| Cause: | <ol style="list-style-type: none">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: | <ol style="list-style-type: none">1. See Extraction.2. Smooth up bolt handle cam.3. Deburr.4. Ammunition may be at fault. |

EXTRACTION

- | | |
|--------------------|--|
| Cause: | <ol style="list-style-type: none">1. Fouled, rough, or enlarged chamber.2. Extractor broken or damaged.3. Not enough hook space on extractor.4. Height of claw not correct. |
| Correction: | <ol style="list-style-type: none">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

Cause:

1. Guard screws protrude into bolt track.
2. Receiver plug screws protrude into bolt track.
3. Bolt handle interferes with stock.
4. Damage at rear of bolt lugs.

Correction:

1. File end of screws.
2. File end of screws.
3. Clear stock or fit new stock.
4. Stone to blend. Check head space.

EJECTION

Cause:

1. Burr at ejector hole in bolt.
2. Ejector binds or fails to retract far enough.
3. Extractor binds.

Correction:

1. Deburr.
2. Free up or replace.
3. Adjust or fit new extractor (and rivet).

BOLT PULLS OUT

Cause:

1. Bolt stop or bolt release binds.
2. Bolt stop or bolt release broken.
3. Bolt stop spring damaged.

Correction:

1. Free up.
2. Return the firearm to the factory.
3. Return the firearm to the factory.

FEEDING

Cause:

1. Magazine follower binds.
2. Weak or defective follower spring.
3. Magazine spring caught under guard.
4. Damaged chamfer on bolt head.
5. Tabs on follower bent.

Correction:

1. Adjust side angle on magazine.
2. Replace spring.
3. Correct.
4. Replace bolt, or stone smooth.
5. Straighten or replace follower.

LOADING

Cause:

1. Damaged receiver rails.
2. Sharp edge — rear end of chamber.
3. Rough loading ramp in receiver.

Correction:

1. Polish or reshape.
2. Remove sharpness.
3. Polish ramp.

LOCKING

Cause:

1. Shallow throat.
2. Min. head space.
3. Damaged chamber.
4. Extractor interferes with shell rim.
5. Ejector binds or fails to retract far enough.
6. Burr at ejector hole in bolt.
7. Sharp corners in bolt lugs.

Correction:

1. Ream.
2. Re-head.
3. Re-head.
4. Fit new extractor (grind relief in new extractor behind claw).
5. Free up or replace.
6. Deburr.
7. Stone radius.

COCKING

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.

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.

BULGES OR BLOWS CASES

Cause:

1. Oversize chamber.
2. Max. head space.

Correction:

1. Replace barrel assembly.
2. Fit new bolt.

SAFETY SWITCH

Cause:

1. Safety switch binds (safety switch works hard).
2. Safety switch snap washer stretches out (safety switch works too freely).
3. Safety switch damaged.

Correction:

1. Return the firearm to the factory.
2. Return the firearm to the factory.
3. Return the firearm to the factory.

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.

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 Rem. Mag.		26990	Sling Strap Assembly and Mountings, Complete
		Bolt Assembly, 308 Win.			Includes: 44 thru 49
		Bolt Final Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.	44	15376	Fastener
		Bolt Final Assembly, 308 Win.	45	15357	Front Swivel Nut
3	15409	Bolt Plug	46	15356	Front Swivel Screw
4	15412	Bolt Stop (Restricted)	47	15358	Rear Swivel Screw
5	24484	Bolt Stop Pin (Restricted)	48	26625	Sling Strap Assembly, 7/8"
6	15413	Bolt Stop Spring (Restricted)	49	26555	Swivel Assembly, Q.D. (each)
	15741	Butt Plate (Model 800 only)	50	27651	Stock Assembly, 350 Rem. Mag., 6.5 MM Rem. Mag.
	25410	Butt Plate Screw (Model 600 only)		27650	Stock Assembly
7	17017	Ejector	51	15883	Tang Support (Magnum only)
8	17676	Ejector Pin	52	15435	Trigger (Restricted)
9	17019	Ejector Spring	53	17049	Trigger Screw, Front (Restricted)
10	15709	Extractor, 350 Rem. Mag., 6.5 MM Rem. Mag.		26730	Trigger Assembly (Restricted)
	16254	Extractor	54	15436	Trigger Connector (Restricted)
11	27341	Extractor Rivet, 350 Rem. Mag., 6.5 MM Rem. Mag.	55	15437	Trigger Guard
	27340	Extractor Rivet (except 222 Rem.)	56	15429	Trigger Housing (Restricted)
12	15410	Firing Pin	57	24477	Trigger Pin (Restricted)
13	26715	Firing Pin Assembly	58	17978	Trigger Spring (Restricted)
14	17022	Firing Pin Cross Pin	59	17053	Trigger Stop Screw (Restricted)
15	23321	Firing Pin Head			
16	15653	Front Guard Screw			
17	27365	Front Sight Assembly			
18	15648	Magazine 350 Rem. Mag., 6.5 MM Rem. Mag.			
	27260	Magazine, 308 Win., 6MM Rem., 243 Win.			
19	15667	Magazine Follower, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	17056	Magazine Follower			
20	17891	Magazine Spring			
21	15411	Main Spring			
22	17580	Rear Guard Screw			
	26841	Rear Sight Assembly			
23	15600	Rear Sight Base, 350 Rem. Mag.			
	15727	Rear Sight Base			
24	15733	Rear Sight Elevation Screw			
25	15726	Rear Sight Eyepiece			
26	15728	Rear Sight Leaf			
27	15418	Rear Sight Nut			
28	15732	Rear Sight Windage Screw			
	15778	Rear Sight Wrench			
29	17034	Receiver Plug Screw			
	15651	Reinforcing Screw, 350 Rem. Mag., 6.5 MM Rem. Mag.			
	18186	Reinforcing Screw			
30	15488	Rib			
31	15417	Rib Screw			
32	26795	Safety Switch Assembly (Restricted)			
33	21386	Recoil Pad (Magnum only)			
34	25410	Recoil Pad Screw (Magnum only)			
35	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)			
40	24476	Sear Pin (Restricted)			

ADDITIONAL CALIBER PARTS

(Not Shown in Sectional View)

Barrel Assembly, 35 Rem. (Superseded)

Barrel Assembly, 222 Rem.

Barrel Assembly, 6MM Rem.

Barrel Assembly, 243 Win.

Bolt Assembly, 35 Rem. (Superseded)

Bolt Assembly, 222 Rem.

Bolt Final Assembly, 35 Rem. (Superseded)

Bolt Final Assembly, 222 Rem.

Ejector, 222 Rem.

Extractor, 222 Rem.

Extractor Rivet, 222 Rem.

Front Sight Assembly, 6 MM Rem., 243 Win.

Magazine, 222 Rem.

Magazine, 35 Rem. (Superseded)

Magazine Follower, 222 Rem.

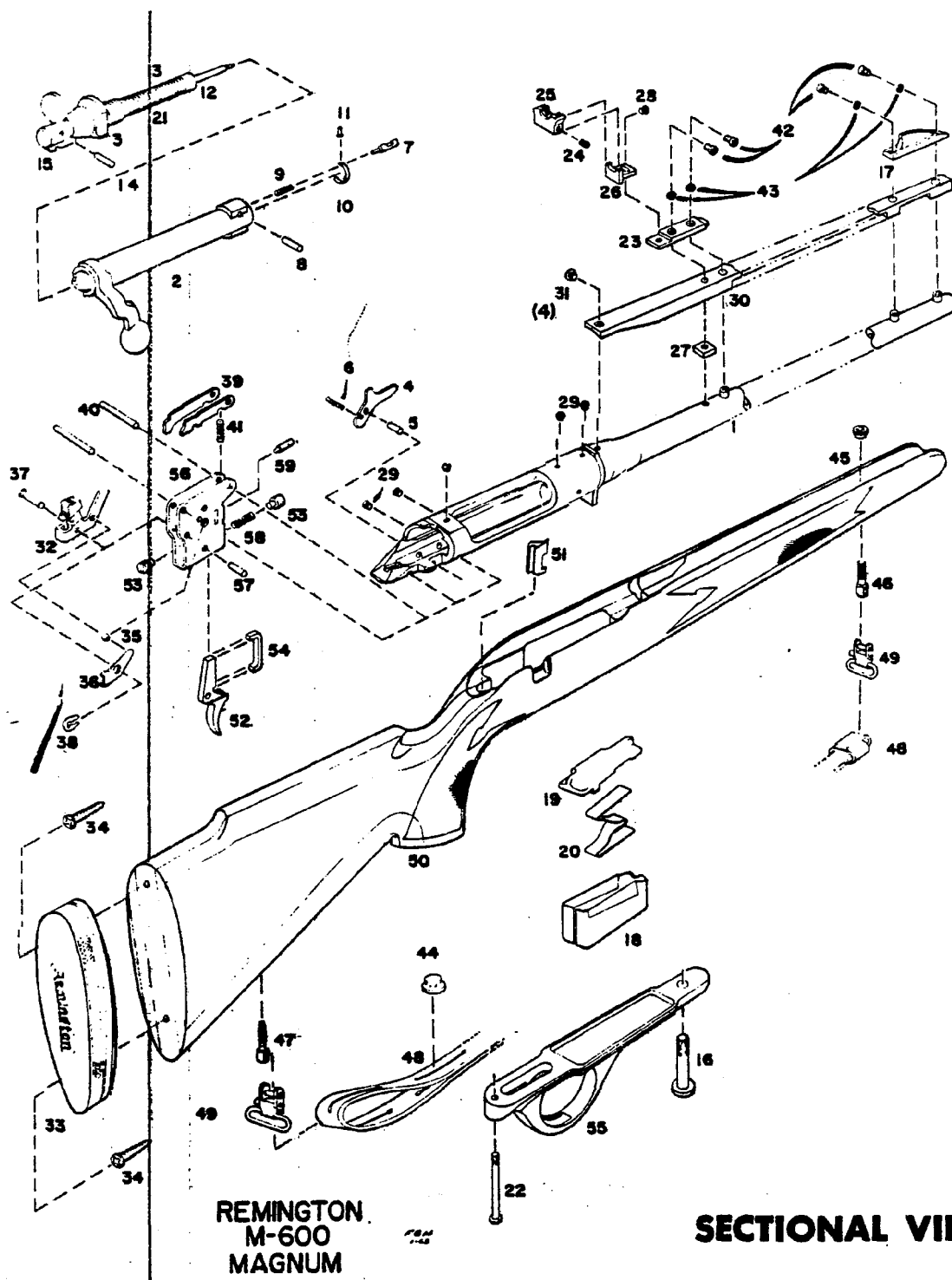
Magazine Spacer, 222 Rem.

Magazine Spring, 222 Rem.

Rear Sight Base, 35 Rem. (Superseded)

NOTE: See Basic Parts List for parts not listed above.

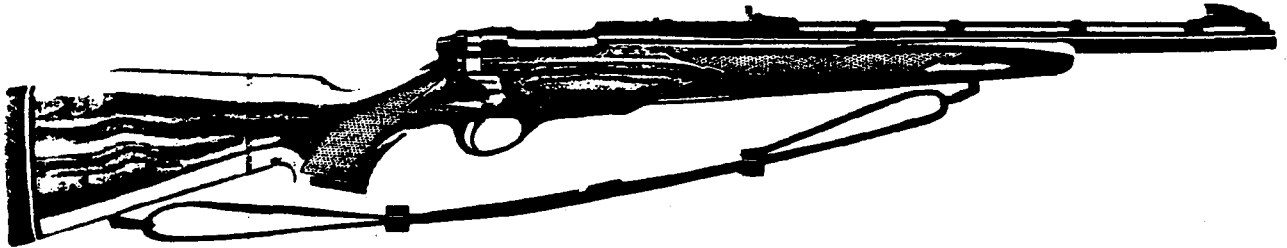
REMINGTON FIELD SERVICE MANUAL



SECTIONAL VIEW

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.

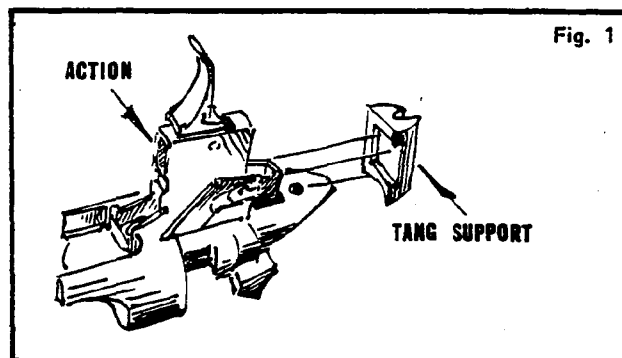
NOTE: Make certain tang support relocated properly at rear of action before stock is reassembled. See **TANG SUPPORT**

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).



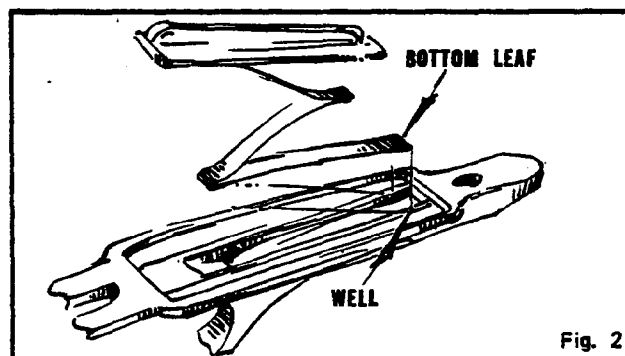
Reassemble stock assembly to action. Tighten firmly with guard screws.

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.

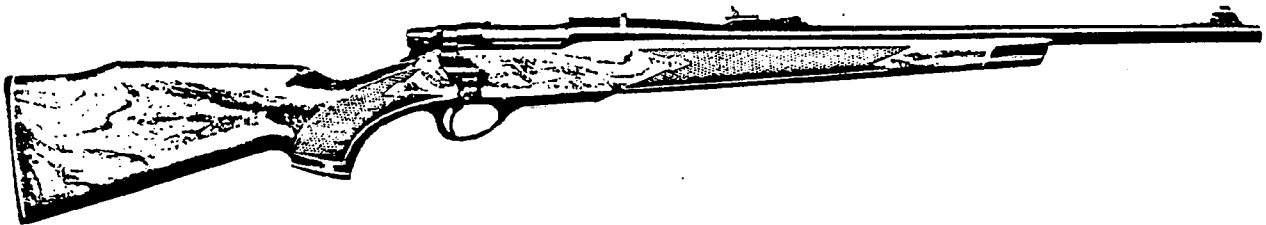
MAGAZINE (marked MAGNUM) — is designed for MAGNUM model use only. Do not use for Standard Model 600.

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 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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Rear Sight Assembly	1	Parts List	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 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

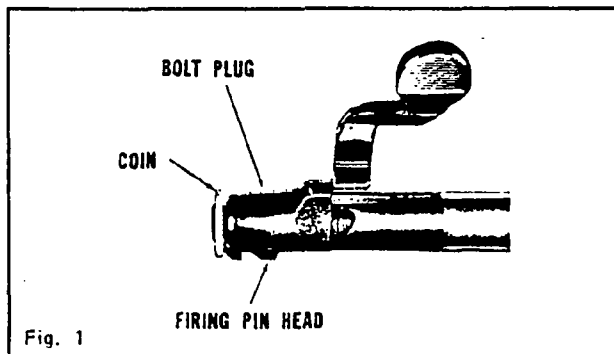
1969

MODEL 660 & 660 MAGNUM

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.



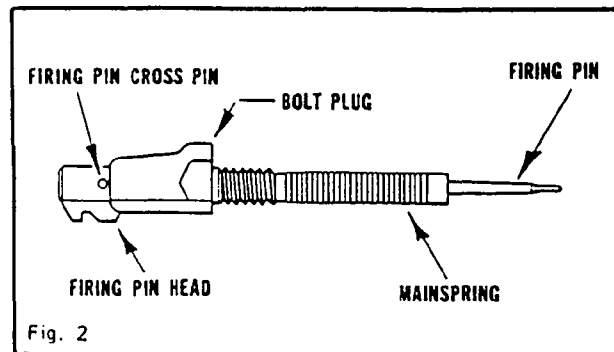
To Service – Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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 COMPLETE— include 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)

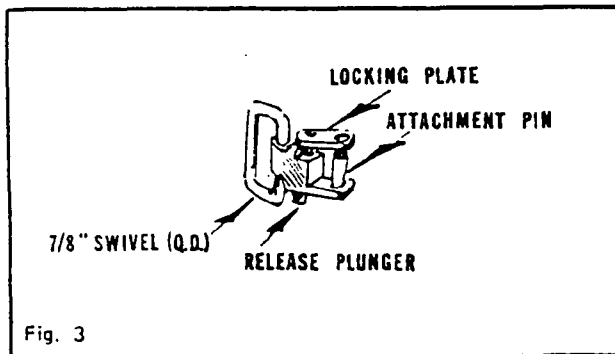
Rear Swivel Screw — Use No. 15 size drill (.180"). Locate screw hole 2 1/2 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with no. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder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

Front Swivel Screw — Use No. 13 drill.

Front Swivel Nut — Use 3/8 inch drill. Locate screw hole approximately 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. (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 spring-loaded 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.

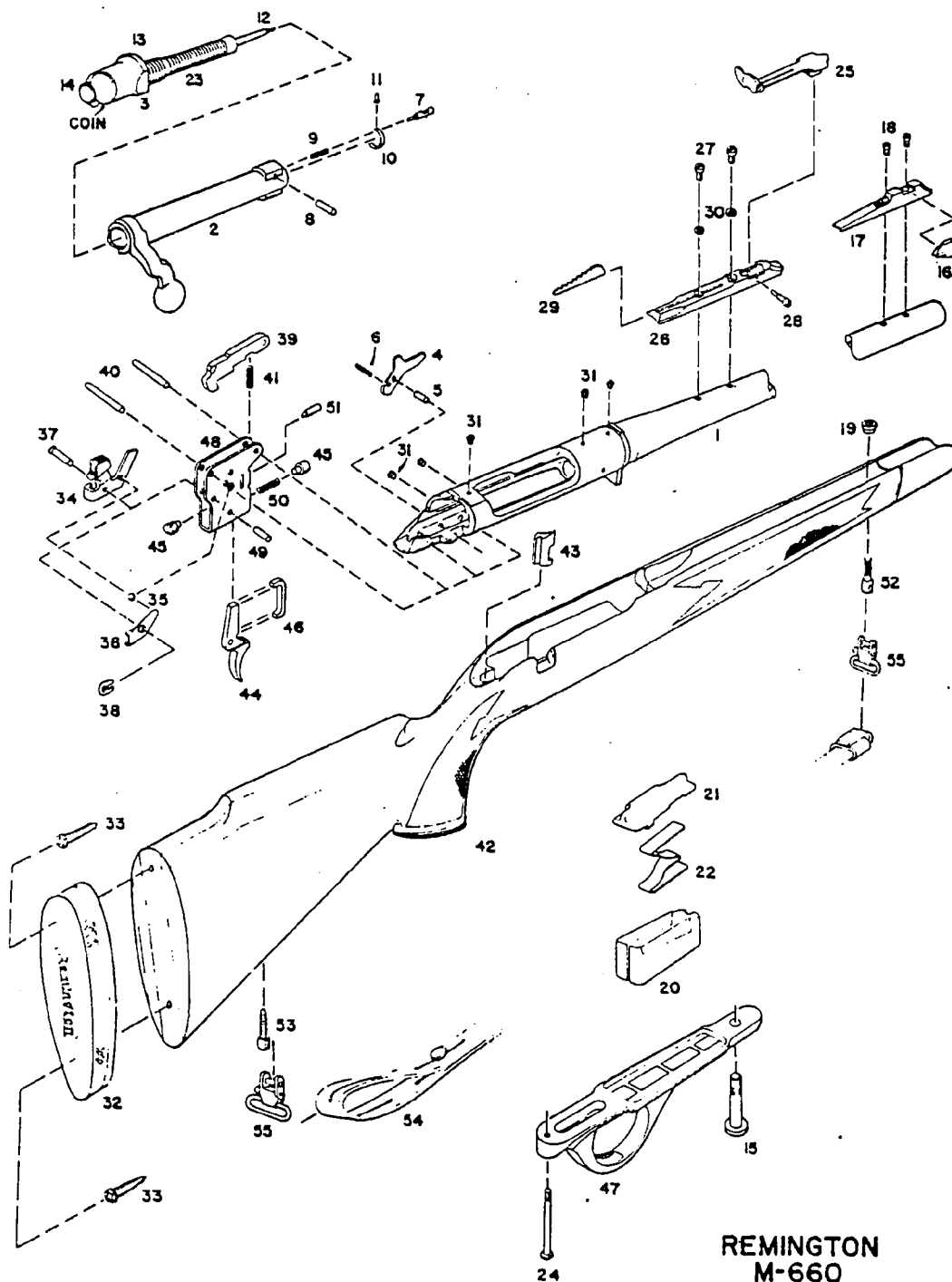
(Cont. on Page 5)

View No.	Part No.	NAME OF PART
	29860	Barrel Assembly, 308 Win. (includes Barrel, Barrel Bracket, Receiver)
	29861	Barrel Assembly, 222 Rem.
	29863	Barrel Assembly, 6MM Rem.
	29865	Barrel Assembly, 243 Win.
1	29866	Barrel Assembly, 6.5 Rem. Mag.
	29867	Barrel Assembly, 350 Rem. Mag.
	29870	Bolt Assembly, 308 Win. (includes Bolt Body Assembly and Bolt Handle)
	29871	Bolt Assembly, 222 Rem.
2	29873	Bolt Assembly, 6.5 Rem. Mag., 350 Rem. Mag.
	29890	Bolt Final Assembly, 308 Win. (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)
	29891	Bolt Final Assembly, 222 Rem.
	29893	Bolt Final Assembly, 6.5 Rem. Mag., 350 Rem. Mag.
- 3	15676	Bolt Plug
4	15412	Bolt Stop
5	24484	Bolt Stop Pin
6	15413	Bolt Stop Spring
	15741	Butt Plate
	25410	Butt Plate Screw
	14390	Butt Plate Spacer
7	17017	Ejector
	15852	Ejector, 222 Rem.
8	17676	Ejector Pin
9	17019	Ejector Spring
	16254	Extractor
	15850	Extractor, 222 Rem.
10	15709	Extractor, 6.5 Rem. Mag., 350 Rem. Mag.
	27340	Extractor Rivet
	27342	Extractor Rivet, 222 Rem.
11	27341	Extractor Rivet, 6.5 Rem. Mag., 350 Rem. Mag.
12	15410	Firing Pin
13	28600	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)
	17022	Firing Pin Cross Pin
14	15673	Firing Pin Head
15	15653	Front Guard Screw
16	15373	Front Sight
17	28510	Front Sight Ramp
18	28505	Front Sight Ramp Screw
19	15357	Front Swivel Nut
	14391	Grip Cap
	15390	Grip Cap Inlay
	15757	Grip Cap Screw
	14392	Grip Cap Spacer
	15433	Magazine
	15842	Magazine, 222 Rem.
20	15648	Magazine, 6.5 Rem. Mag., 350 Rem. Mag.
	17056	Magazine Follower
	16793	Magazine Follower, 222 Rem.
21	15667	Magazine Follower, 6.5 Rem. Mag., 350 Rem. Mag.
	15742	Magazine Spacer, 222 Rem.
22	17891	Magazine Spring
	17983	Magazine Spring, 222 Rem.
23	15411	Main Spring
24	17580	Rear Guard Screw
25	24525	Rear Sight Assembly (includes Rear Sight Collar, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw)
26	25313	Rear Sight Base
27	16023	Rear Sight Base Screw
28	16456	Rear Sight Screw
29	28095	Rear Sight Step (selected sizes)
30	16968	Rear Sight Washer
31	17034	Receiver Plug Screw
32	21386	Recoil Pad, Magnum Caliber
33	25410	Recoil Pad Screw, Magnum Caliber
	15651	Reinforcing Screw
34	26795	Safety Assembly (includes Safety and Safety Thumbpiece)
35	26850	Safety Detent Ball
36	15432	Safety Detent Spring
37	17043	Safety Pivot Pin
38	17044	Safety Snap Washer
39	15666	Sear Safety Cam
40	24476	Sear Pin
41	17047	Sear Spring
	29835	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), Butt Plate Spacer, Fore-end Tip, Fore-end Tip Plug, Fore-end Tip Spacer, Grip Cap, Grip Cap Inlay, Grip Cap Screw, Grip Cap Spacer, Reinforcing Screw (2), Stock)
42	29880	Stock Assembly, Magnum Caliber (includes Fore-end Tip, Fore-end Tip Plug, Fore-end Tip Spacer, Grip Cap, Grip Cap Inlay, Grip Cap Screw, Grip Cap Spacer, Recoil Pad, Recoil Pad Screw (2), Front Swivel Nut, Reinforcing Screw (2), Stock)
43	15883	Tang Support, Magnum Caliber
44	15435	Trigger
45	17049	Trigger Adjusting Screw
	14714	Trigger Adjusting Screw, Front
	26730	Trigger Assembly (includes Trigger Housing, Safety Snap Washer, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
46	15436	Trigger Connector
47	15437	Trigger Guard
48	15429	Trigger Housing
49	24477	Trigger Pin
50	17978	Trigger Spring
51	17053	Trigger Stop Screw
SLING STRAP EQUIPMENT		
	14694	Sling Strap Assembly and Mountings Complete Includes:
52	15356	Front Swivel Screw
53	15358	Rear Swivel Screw
54	30855	Sling Strap Assembly 7/8"
55	26555	Swivel Assembly, Q.D.
	15357	Front Swivel Nut

EXPLODED
VIEW

MODEL 660 & 660 MAGNUM

REMINGTON FIELD SERVICE MANUAL



MODEL 660 & 660 MAGNUM

(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

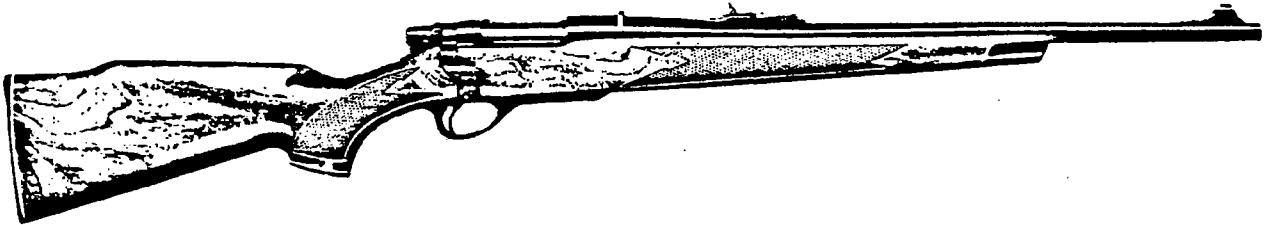
Locking cycle is accomplished by rotating bolt with a downward motion of bolt handle, locking cartridge in chamber. Four engagements are made by this cycle: (1) locking lugs on bolt head are engaged with recoil shoulders in receiver. (2) Head of cartridge is seated into bolt head depressing ejector and 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) nullifies above condition and will allow firing.

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.



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Rear Sight Step	1	Exploded View	4

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

1973

MODEL 660 & 660 MAGNUM

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.

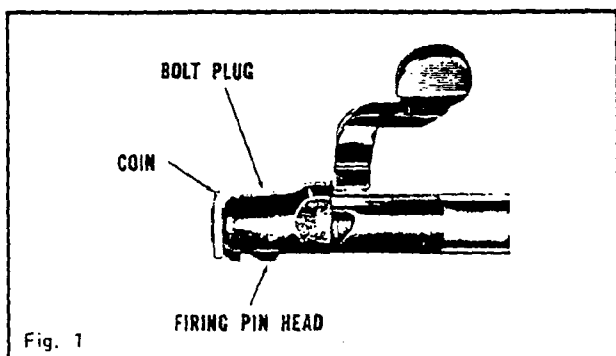


Fig. 1

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).

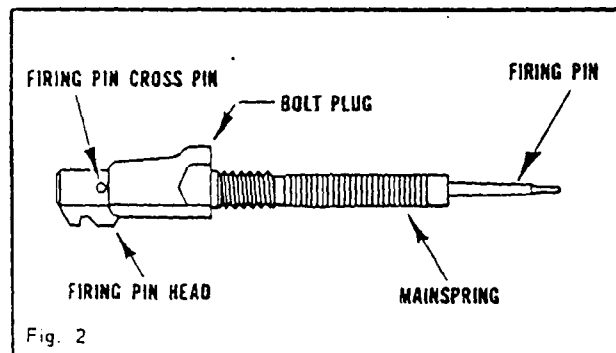


Fig. 2

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 main spring. 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 COMPLETE— include 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 1/4 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 approximately 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. (See Fig. 3).

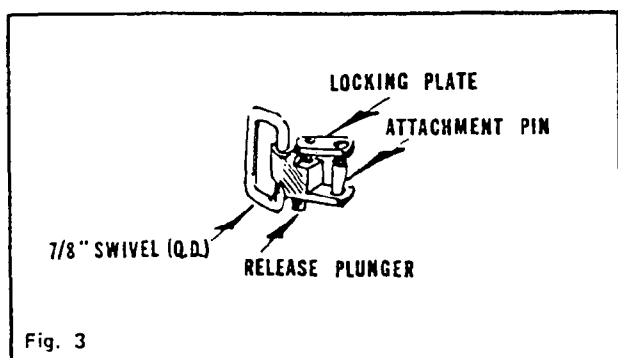


Fig. 3

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 spring-loaded 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)

REMINGTON FIELD SERVICE MANUAL

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
	29860	Barrel Assembly, 308 Win. (includes Barrel, Barrel Bracket, Receiver)	22	17891	Magazine Spring
	29861	Barrel Assembly, 222 Rem.		17983	Magazine Spring, 222 Rem.
	29863	Barrel Assembly, 6MM Rem.	23	15411	Main Spring
	29865	Barrel Assembly, 243 Win.	24	17580	Rear Guard Screw
1	29866	Barrel Assembly, 6.5 Rem. Mag.	25	24525	Rear Sight Assembly (includes Rear Sight Collar, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw)
	29867	Barrel Assembly, 350 Rem. Mag.	26	25313	Rear Sight Base
	29870	Bolt Assembly, 308 Win. (includes Bolt Body Assembly 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 Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	30	16968	Rear Sight Washer
	29891	Bolt Final Assembly, 222 Rem.	31	17034	Receiver Plug Screw
	29893	Bolt Final Assembly, 6.5 Rem. Mag., 350 Rem. Mag.	32	21386	Recoil Pad, Magnum Caliber
3	15676	Bolt Plug	33	25410	Recoil Pad Screw, Magnum Caliber
4	15412	Bolt Stop		15651	Reinforcing Screw
5	24484	Bolt Stop Pin	34	26795	Safety Assembly (includes Safety and Safety Thumpiece)
6	15413	Bolt Stop Spring	35	26850	Safety Detent Ball
	15741	Butt Plate	36	15432	Safety Detent Spring
	25410	Butt Plate Screw	37	17043	Safety Pivot Pin
	14390	Butt Plate Spacer	38	17044	Safety Snap Washer
7	17017	Ejector	39	15666	Sear Safety Cam
	15852	Ejector, 222 Rem.	40	24476	Sear Pin
8	17676	Ejector Pin	41	17047	Sear Spring
9	17019	Ejector Spring		29835	Stock Assembly (includes Butt Plate, Butt Plate Screw (2), Butt Plate Spacer, Fore-end Tip, Fore-end Tip Plug, Fore-end Tip Spacer, Grip Cap, Grip Cap Inlay, Grip Cap Screw, Grip Cap Spacer, Reinforcing Screw (2), Stock)
	16254	Extractor	42	29880	Stock Assembly, Magnum Caliber (includes Fore-end Tip, Fore-end Tip Plug, Fore-end Tip Spacer, Grip Cap, Grip Cap Inlay, Grip Cap Screw, Grip Cap Spacer, Recoil Pad, Recoil Pad Screw (2), Front Swivel Nut, Reinforcing Screw (2), Stock)
10	15709	Extractor, 6.5 Rem. Mag., 350 Rem. Mag.	43	15883	Tang Support, Magnum Caliber
	27340	Extractor Rivet	44	15435	Trigger
	27342	Extractor Rivet, 222 Rem.	45	17049	Trigger Adjusting Screw
11	27341	Extractor Rivet, 6.5 Rem. Mag., 350 Rem. Mag.		14714	Trigger Adjusting Screw, Front
12	15410	Firing Pin		26730	Trigger Assembly (includes Trigger Housing, Safety Snap Washer, Sear Safety Cam, Sear Spring, Trigger, Trigger Adjusting Screw (2), Trigger Connector, Trigger Pin, Trigger Spring, Trigger Stop Screw)
13	28600	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	46	15436	Trigger Connector
	17022	Firing Pin Cross Pin	47	15437	Trigger Guard
14	15673	Firing Pin Head	48	15429	Trigger Housing
15	15653	Front Guard Screw	49	24477	Trigger Pin
16	15373	Front Sight	50	17978	Trigger Spring
17	28510	Front Sight Ramp	51	17053	Trigger Stop Screw
18	28505	Front Sight Ramp Screw			
19	15357	Front Swivel Nut			
	14391	Grip Cap			
	15390	Grip Cap Inlay			
	15757	Grip Cap Screw			
	14392	Grip Cap Spacer			
	15433	Magazine			
	15842	Magazine, 222 Rem.			
20	15648	Magazine, 6.5 Rem. Mag., 350 Rem. Mag.			
	17056	Magazine Follower			
	16793	Magazine Follower, 222 Rem.			
21	15667	Magazine Follower, 6.5 Rem. Mag., 350 Rem. Mag.			
	15742	Magazine Spacer, 222 Rem.			

MODEL 660 & 660 MAGNUM

(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.

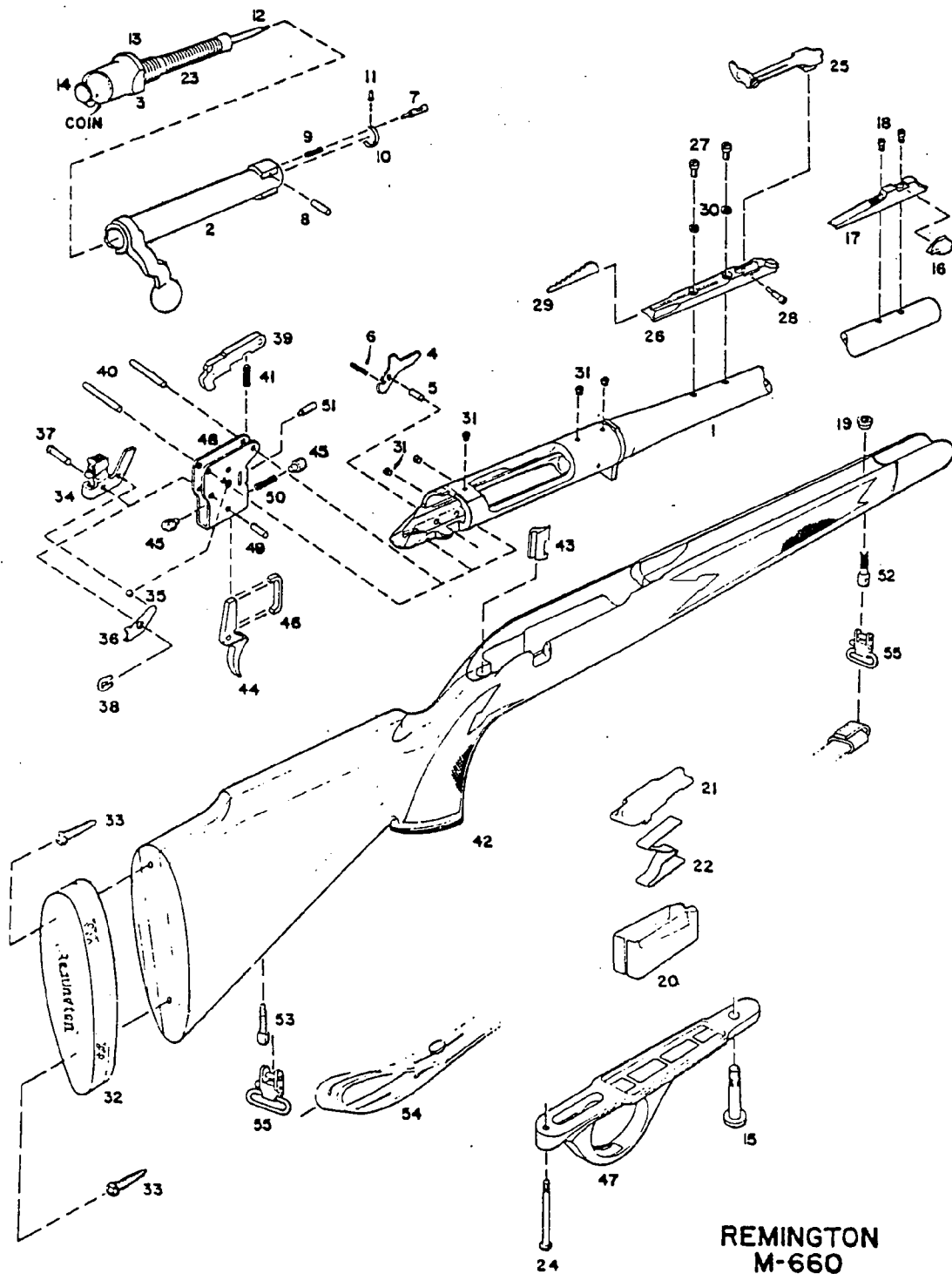
SAFETY

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) nullifies above condition and will allow firing.

EXPLODED
VIEW

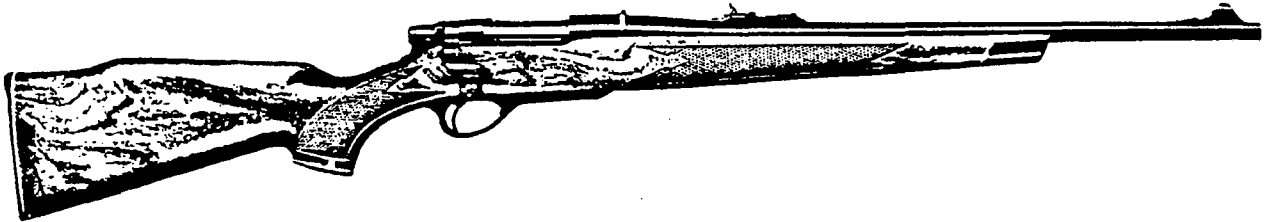
MODEL 660 & 660 MAGNUM

REMINGTON FIELD SERVICE MANUAL



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
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

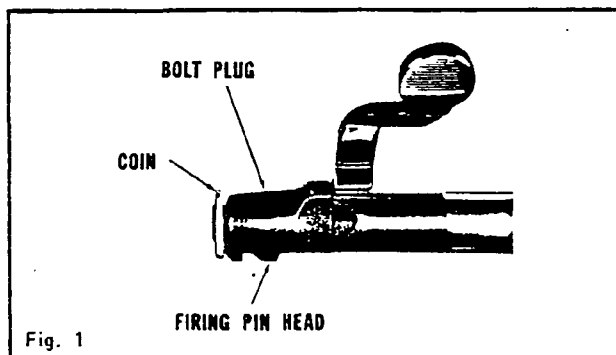
1982

MODEL 660 & 660 MAGNUM

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.



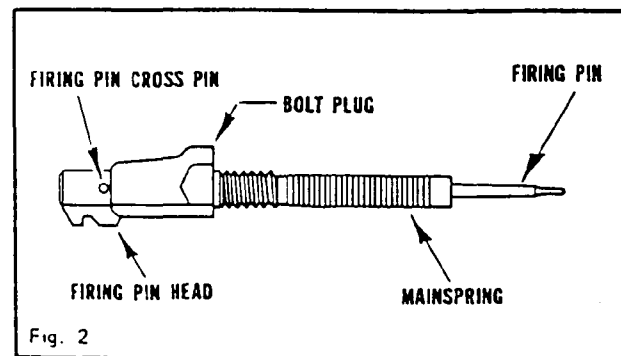
To Service — Firing pin assembly is interchangeable. May be replaced as a unit with no factory adjustment required. Replacement of bolt assembly requires selective assembly for proper function.

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 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 COMPLETE—include 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)

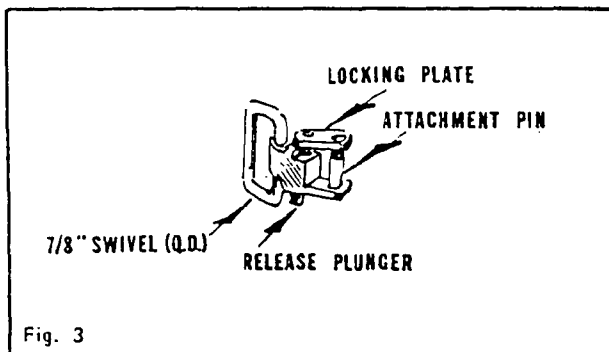
Rear Swivel Screw — Use No. 15 size drill (.180"). Locate screw hole 2 1/4 inches from toe of stock (minus butt plate). Drill hole 1 inch deep at 90° with bottom line of stock. Countersink this drilled hole with no. 1 size (.228") drill to depth of 1/8 inch. This countersink allows for seating shoulder on swivel screw.

Front Swivel Screw — Use No. 13 drill.

Front Swivel Nut — Use 3/8 inch drill. Locate screw hole approximately 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. (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 spring-loaded 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)

REMINGTON FIELD SERVICE MANUAL

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
		Barrel Assembly, 308 Win.	30	16968	Rear Sight Washer
		Barrel Assembly, 222 Rem.	31	17034	Receiver Plug Screw
		Barrel Assembly, 6MM Rem.	32	21386	Recoil Pad, Magnum Caliber
		Barrel Assembly, 243 Win.	33	25410	Recoil Pad Screw, Magnum Caliber
1		Barrel Assembly, 6.5 Rem. Mag.		15651	Reinforcing Screw
		Barrel Assembly, 350 Rem. Mag.	34	26795	Safety Switch Assembly (Restricted)
		Bolt Assembly, 308 Win.	35	26850	Safety Switch Detent Ball (Restricted)
		Bolt Assembly, 222 Rem.	36	15432	Safety Switch Detent Spring (Restricted)
2		Bolt Assembly, 6.5 Rem. Mag., 350 Rem. Mag.			
		Bolt Final Assembly, 308 Win.	37	17043	Safety Switch Pivot Pin (Restricted)
		Bolt Final Assembly, 222 Rem.	38	17044	Safety Switch Snap Washer (Restricted)
		Bolt Final Assembly, 6.5 Rem. Mag., 350 Rem. Mag.	39	15666	Sear Safety Cam (Restricted)
3	15676	Bolt Plug	40	24476	Sear Pin (Restricted)
4	15412	Bolt Stop (Restricted)	41	17047	Sear Spring (Restricted)
5	24484	Bolt Stop Pin (Restricted)		29835	Stock Assembly
6	15413	Bolt Stop Spring (Restricted)	42	29880	Stock Assembly, Magnum Caliber
	15741	Butt Plate	43	15883	Tang Support, Magnum Caliber
	25410	Butt Plate Screw	44	15435	Trigger (Restricted)
	14390	Butt Plate Spacer	45	17049	Trigger Screw (Restricted)
7	17017	Ejector		14714	Trigger Screw, Front (Restricted)
	15852	Ejector, 222 Rem.		26730	Trigger Assembly (Restricted)
8	17676	Ejector Pin	46	15436	Trigger Connector (Restricted)
9	17019	Ejector Spring	47	15437	Trigger Guard
	16254	Extractor	48	15429	Trigger Housing (Restricted)
	15850	Extractor, 222 Rem.	49	24477	Trigger Pin (Restricted)
10	15709	Extractor, 6.5 Rem. Mag., 350 Rem. Mag.	50	17978	Trigger Spring (Restricted)
	27340	Extractor Rivet	51	17053	Trigger Stop Screw (Restricted)
	27342	Extractor Rivet, 222 Rem.			
11	27341	Extractor Rivet, 6.5 Rem. Mag., 350 Rem. Mag.			
12	15410	Firing Pin			
13	28600	Firing Pin Assembly			
	17022	Firing Pin Cross Pin			
14	15673	Firing Pin Head			
15	15653	Front Guard Screw			
16	15373	Front Sight			
17	28510	Front Sight Ramp			
18	28505	Front Sight Ramp Screw			
19	15357	Front Swivel Nut			
	14391	Grip Cap			
	15390	Grip Cap Inlay			
	15757	Grip Cap Screw			
	14392	Grip Cap Spacer			
	15433	Magazine			
	15842	Magazine, 222 Rem.			
20	15648	Magazine, 6.5 Rem. Mag., 350 Rem. Mag.			
	17056	Magazine Follower			
	16793	Magazine Follower, 222 Rem.			
21	15667	Magazine Follower, 6.5 Rem. Mag., 350 Rem. Mag.			
	15742	Magazine Spacer, 222 Rem.			
22	17891	Magazine Spring			
	17893	Magazine Spring, 222 Rem.			
23	15411	Main Spring			
24	17580	Rear Guard Screw			
25	24525	Rear Sight Assembly			
26	25313	Rear Sight Base			
27	16023	Rear Sight Base Screw			
28	16456	Rear Sight Screw			
29	28095	Rear Sight Step (selected sizes)			

SLING STRAP EQUIPMENT

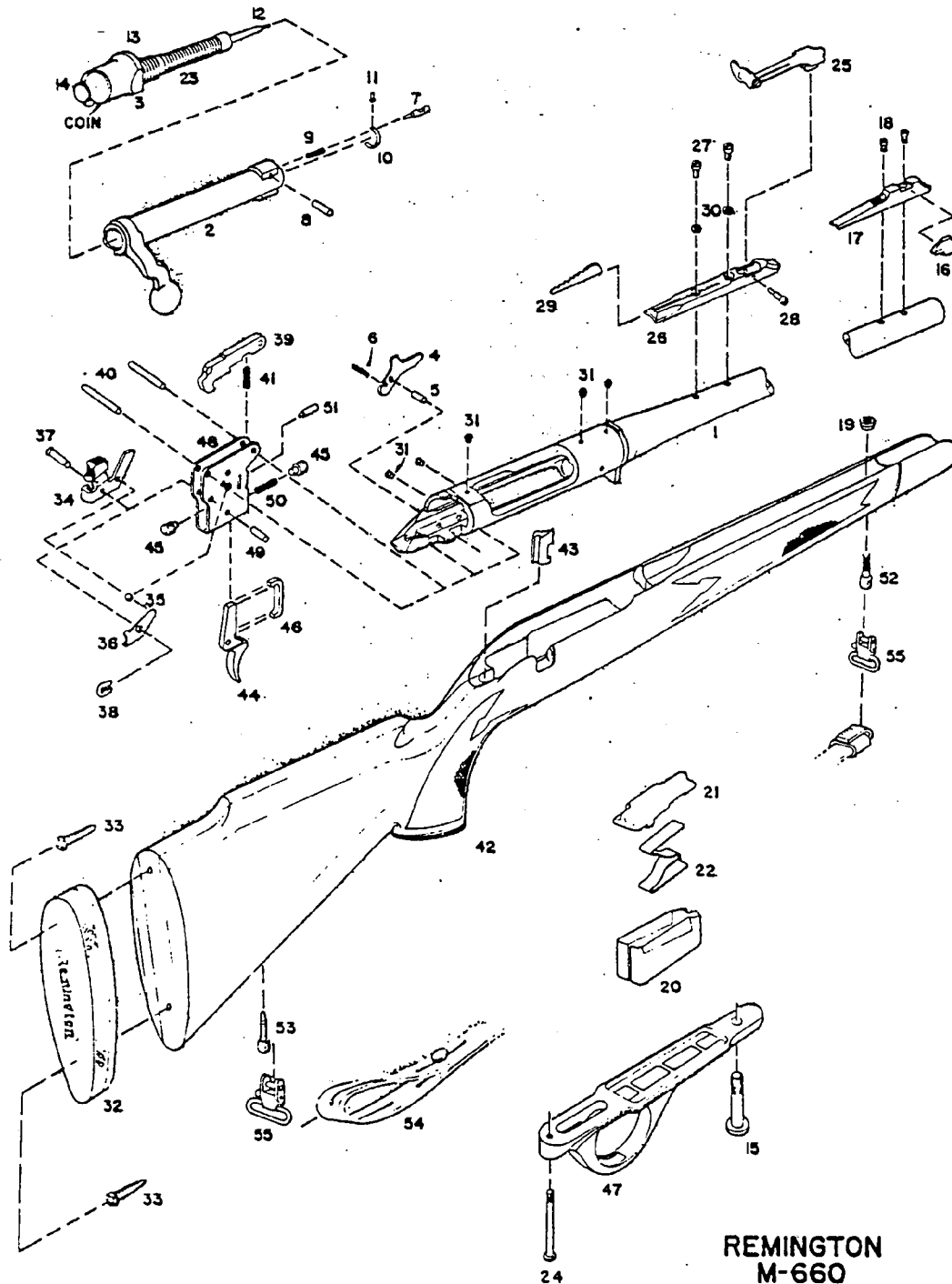
14694 Sling Strap Assembly and Mountings Complete
Includes:

52 15356 Front Swivel Screw
53 15358 Rear Swivel Screw
54 30855 Sling Strap Assembly 7/8"
55 26556 Swivel Assembly, O.D.
15357 Front Swivel Nut

EXPLODED
VIEW

MODEL 660 & 660 MAGNUM

REMINGTON FIELD SERVICE MANUAL



MODEL 660 & 660 MAGNUM

(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.

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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FIELD SERVICE MANUAL

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Send all guns for factory service and inquiries on
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Ilion, New York

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut

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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)

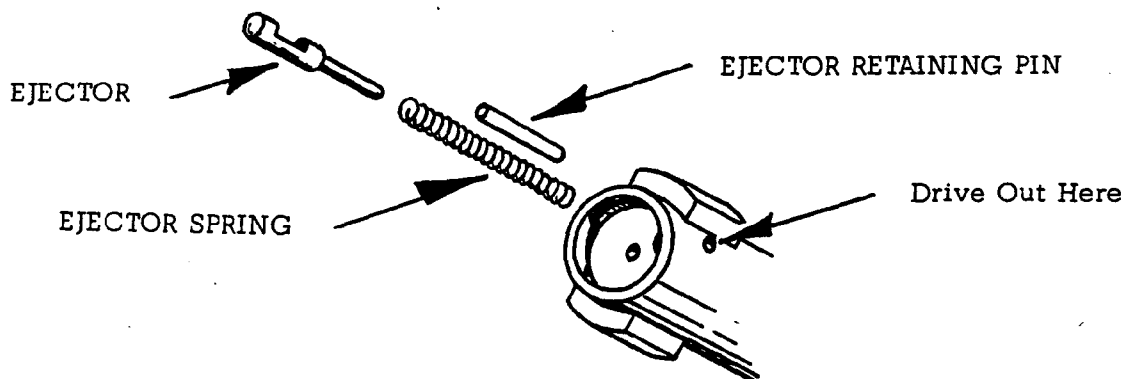
MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

Caution: 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.

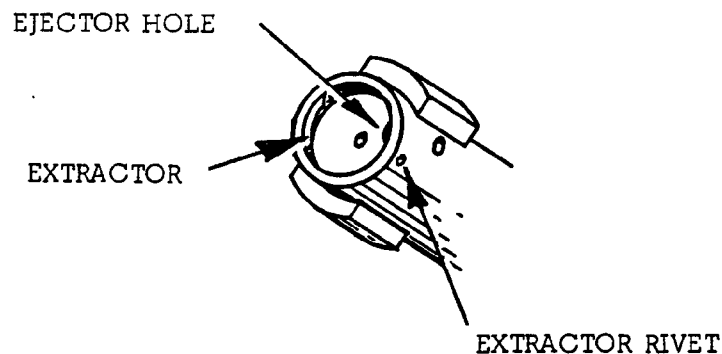
To Disassemble - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

Caution: Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.



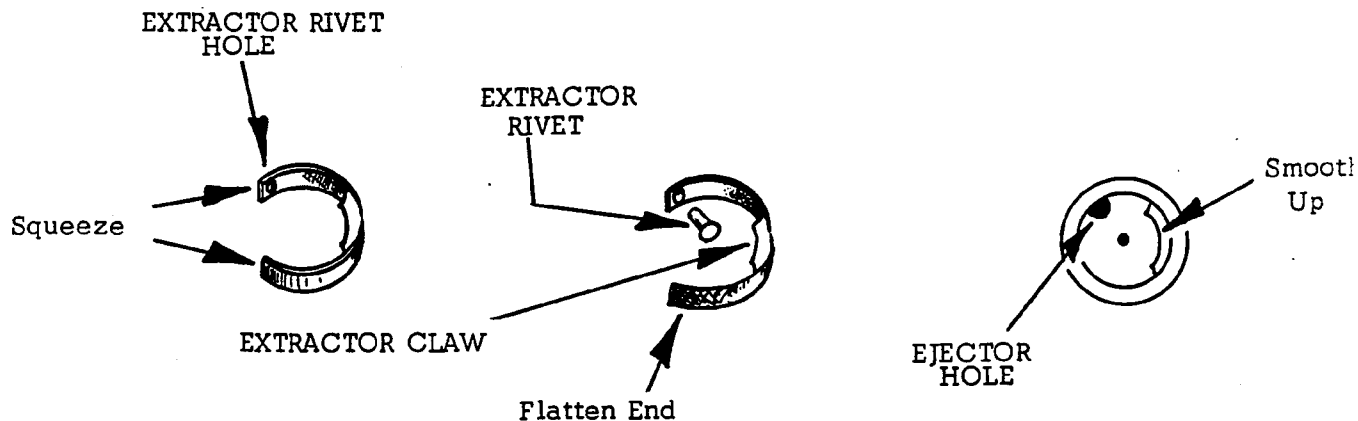
BOLT FINAL ASSEMBLY Continued

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 face of bolt, and disassemble extractor and rivet from bolt.

To Reassemble - Adjust replacement for proper tension before reassembly 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.

Note: 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)

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)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

To Reassemble - 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.

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.

To Disassemble - Spread cover slightly and push forward in cover slots on either side of the ramp.

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

To Disassemble - 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)

To Disassemble - Unscrew front sight ramp screw and pry ramp up off ramp pins.

To Replace - Interchangeable - no factory adjustment required.

To Reassemble - 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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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.

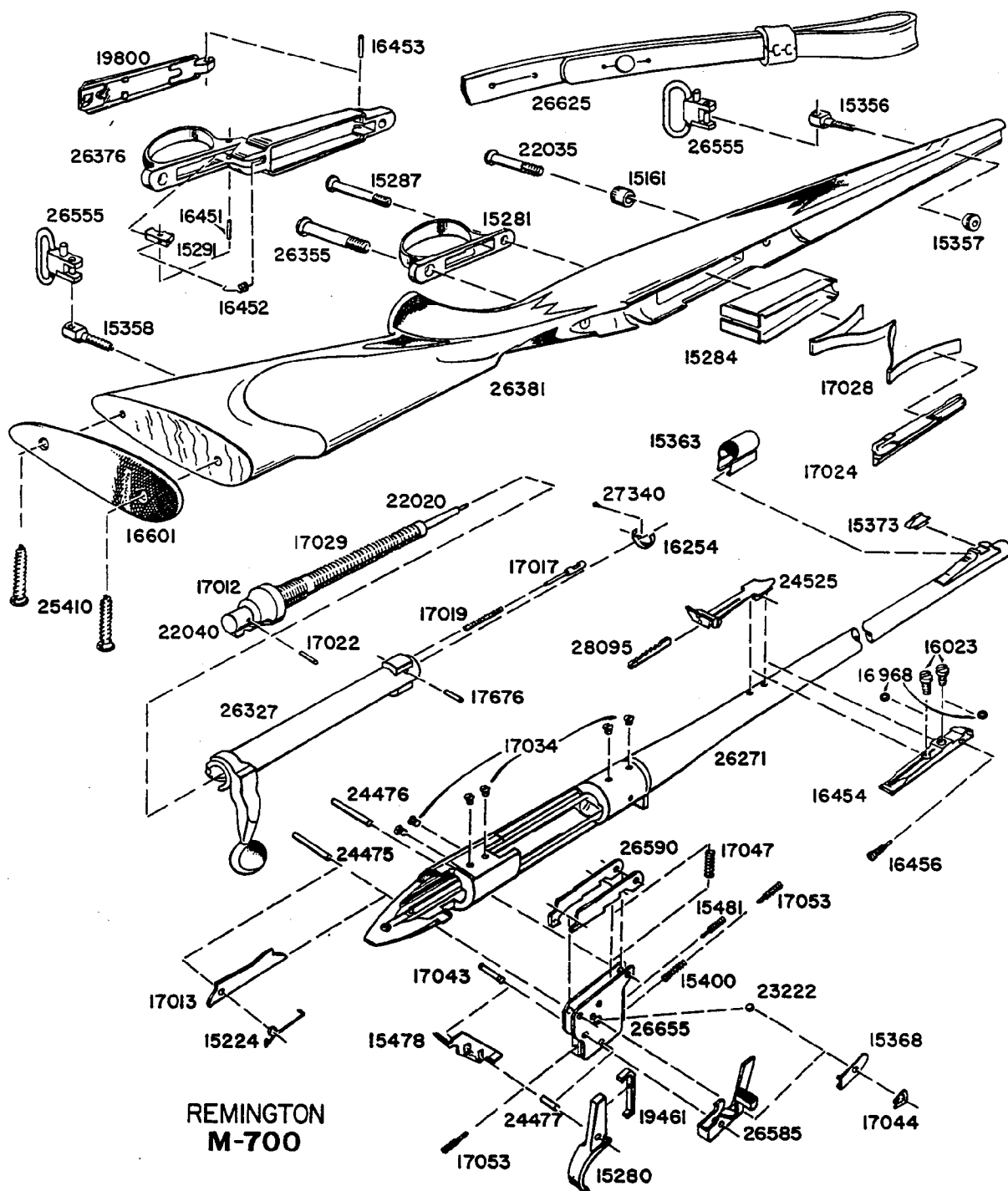
To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

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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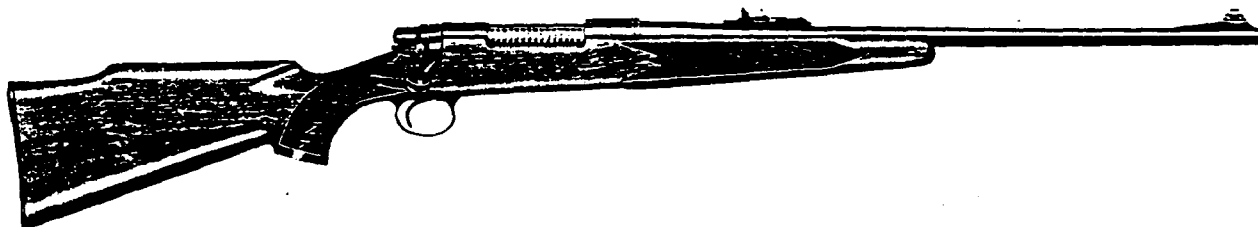
REMINGTON FIELD SERVICE MANUAL



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M-700

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

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)

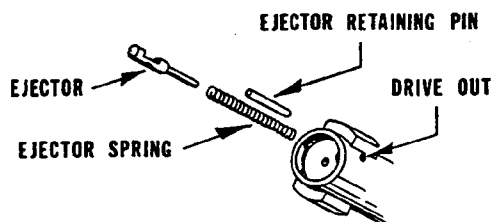


FIG. 1

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.

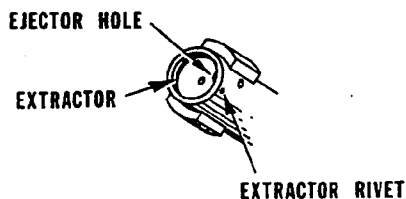


FIG. 2

Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.

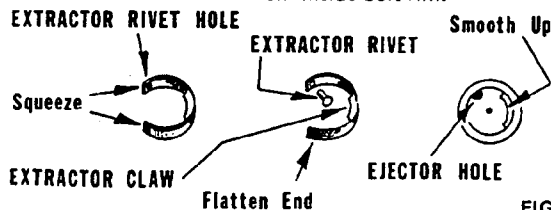


FIG. 3

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.

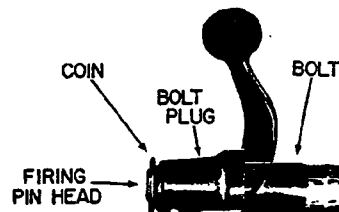
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

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.

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.

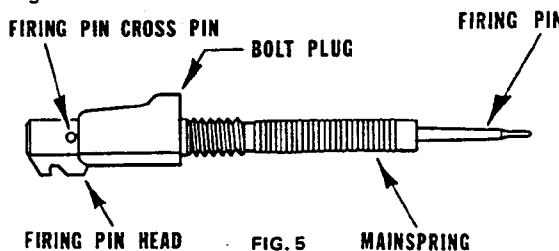


FIG. 5

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.

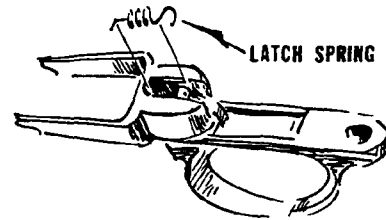


FIG. 6

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)

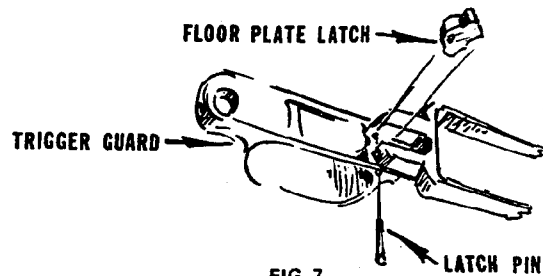


FIG. 7

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.
 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

- 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).

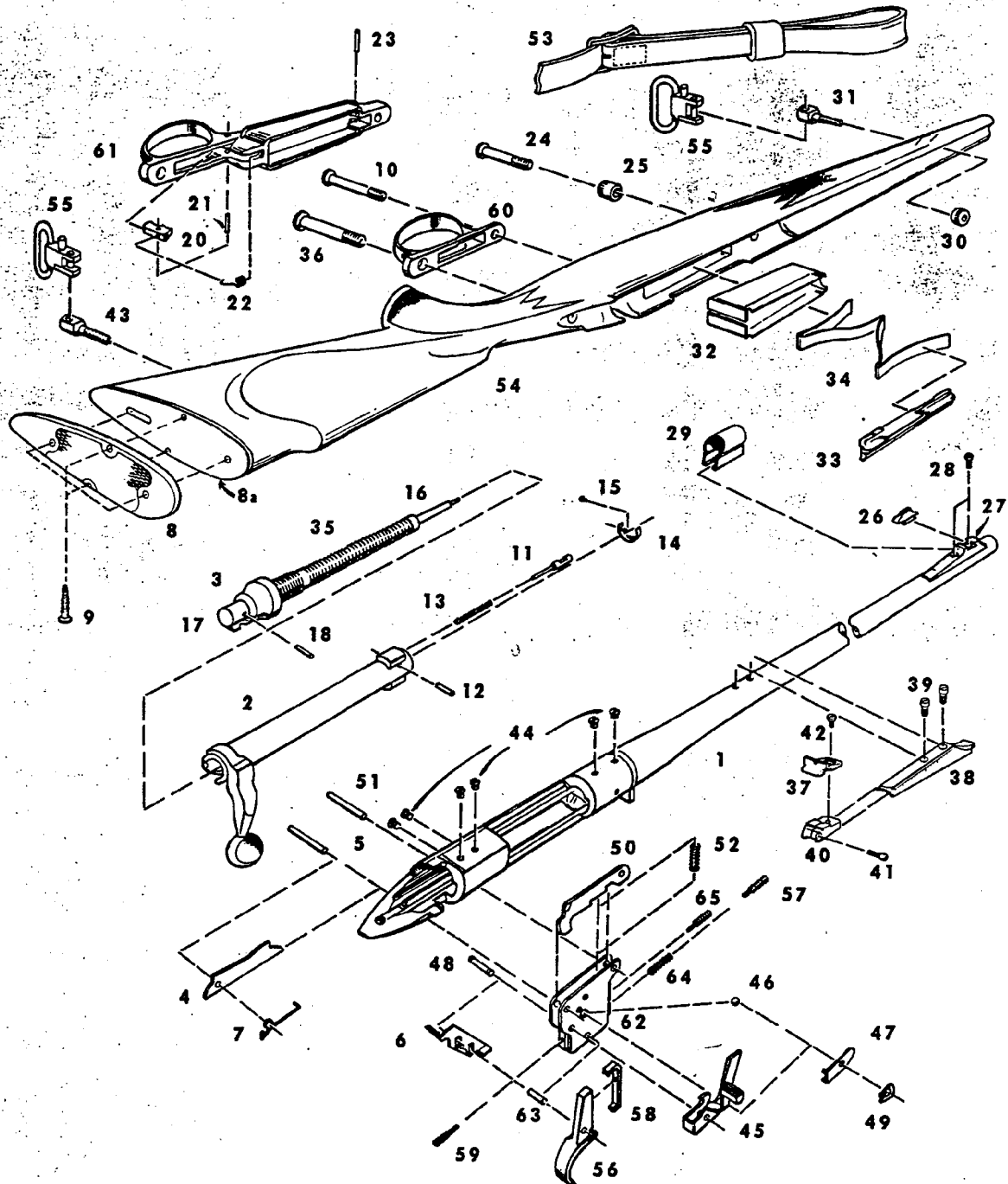
Bolt Binds

- 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

View No.	NAME OF PART	View No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts.		35	Main Spring
1	Barrel Assembly	36	Rear Guard Screw
2	Bolt Assembly	37	Rear Sight Aperture
	Bolt Final Assembly	38	Rear Sight Base
3	Bolt Plug	39	Rear Sight Base Screw (2)
4	Bolt Stop (Restricted)	40	Rear Sight Slide
5	Bolt Stop Pin (Restricted)	41	Elevation Screw
6	Bolt Stop Release (Restricted)	42	Windage Screw
7	Bolt Stop Spring (Restricted)	43	Rear Swivel Screw, BDL Grade
8	Butt Plate	44	Receiver Plug Screw
8a	Butt Plate Spacer, BDL	45	Safety Switch Assembly (Restricted)
9	Butt Plate Screw	46	Safety Switch Detent Ball (Restricted)
10	Center Guard Screw, ADL Grade	47	Safety Switch Detent Spring (Restricted)
11	Ejector	48	Safety Switch Pivot Pin (Restricted)
12	Ejector Pin	49	Safety Switch Snap Washer (Restricted)
13	Ejector Spring	50	Sear Safety Cam (Restricted)
14	Extractor	51	Sear Pin (Restricted)
	Fastener, Sling Strap	52	Sear Spring (Restricted)
16	Firing Pin	53	Sling Strap Assembly, BDL Grade
17	Firing Pin Assembly		Sling Strap Assembly and Mountings Complete
18	Firing Pin Cross Pin	54	Stock Assembly, ADL Grade
20	Floor Plate Latch, BDL Grade		Stock Assembly, BDL Grade
21	Floor Plate Latch Pin, BDL Grade		Stock Reinforcing Screw (not shown)
22	Floor Plate Latch Spring, BDL Grade		Stock Reinforcing Screw Dowel (not shown)
23	Floor Plate Pivot Pin, BDL Grade	55	Swivel Assembly, BDL Grade (Q.D.)
24	Front Guard Screw	56	Trigger (Restricted)
25	Front Guard Screw Bushing, ADL Grade	57	Trigger Adjusting Screw (Restricted)
26	Front Sight		Trigger Assembly (Restricted)
	Front Sight (Low)	58	Trigger Connector (Restricted)
27	Front Sight Ramp	59	Trigger Engagement Screw (Restricted)
	Front Sight Ramp, BDL Grade	60	Trigger Guard
28	Front Sight Ramp Screw	61	Trigger Guard, BDL Grade
29	Front Sight Hood, BDL Grade		Trigger Guard Assembly, BDL Grade
30	Front Swivel Nut, BDL Grade	62	Trigger Housing Assembly (Restricted)
31	Front Swivel Screw, BDL Grade	63	Trigger Pin (Restricted)
	Grip Cap, BDL Grade (not shown)	64	Trigger Spring (Restricted)
	Grip Cap Screw	65	Trigger Stop Screw (Restricted)
	Grip Cap Spacer, BDL Grade (not shown)		
32	Magazine, ADL Grade		
	Magazine, BDL Grade (not shown)		
33	Magazine Follower		
	Magazine Follower, BDL Grade		
	Magazine Tab Screw, ADL Grade		
34	Magazine Spring		
	Magazine Spring, BDL Grade		



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.
 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.

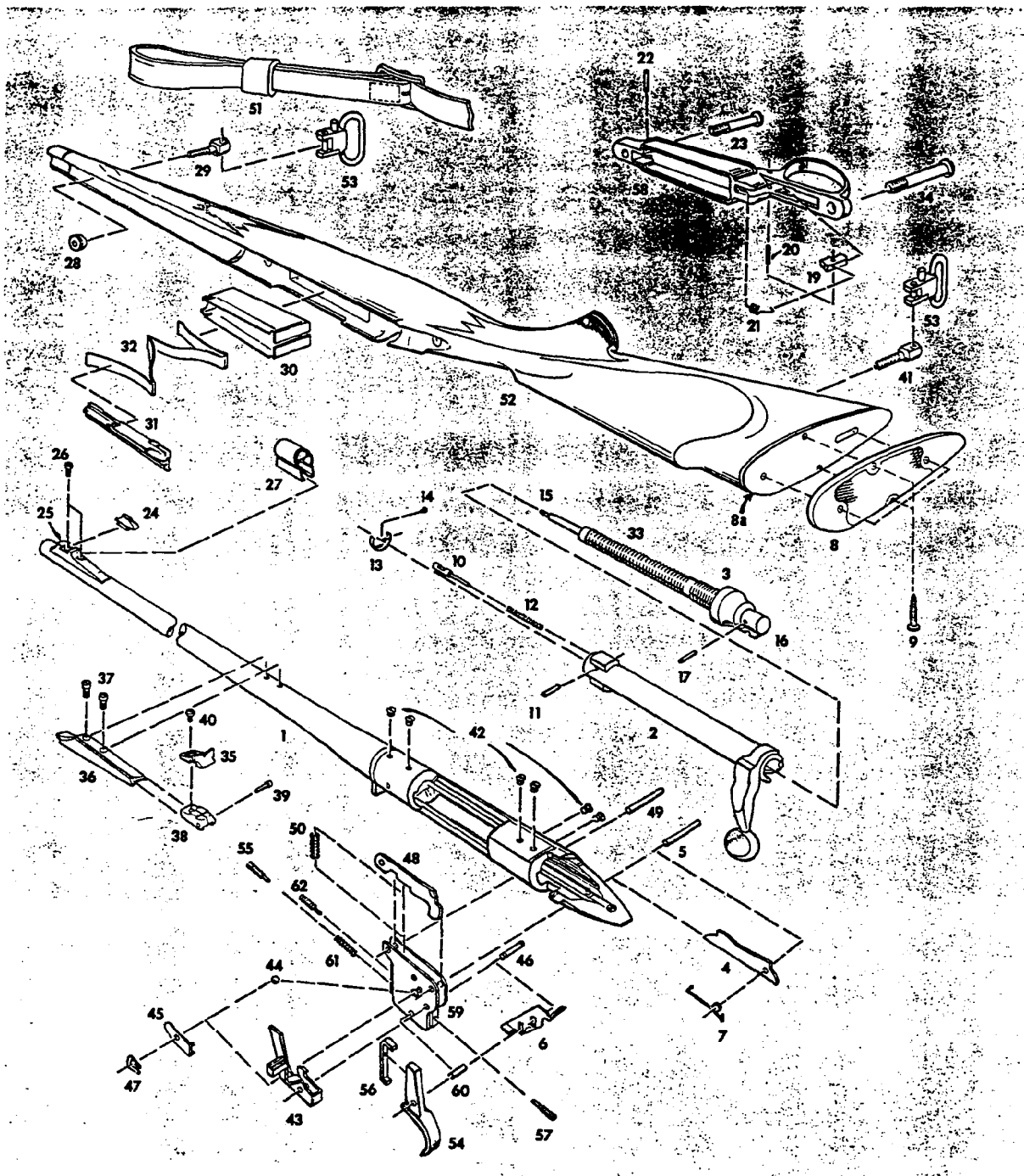
REMINGTON FIELD SERVICE MANUAL

View No.	NAME OF PART	View No.	NAME OF PART
NOTE:	Basic 30-06 caliber listed below.	46	Safety Switch Pivot Pin (Restricted)
1	Barrel Assembly	47	Safety Switch Snap Washer (Restricted)
2	Bolt Assembly	48	Sear Safety Cam (Restricted)
	Bolt Final Assembly	49	Sear Pin (Restricted)
3	Bolt Plug	50	Sear Spring (Restricted)
4	Bolt Stop (Restricted)	51	Sling Strap Assembly
5	Bolt Stop Pin (Restricted)		Sling Strap Assembly and Mountings Complete
6	Bolt Stop Release (Restricted)	52	Stock Assembly
7	Bolt Stop Spring (Restricted)		Stock Reinforcing Screw
8	Butt Plate		Stock Reinforcing Screw Dowel
8a	Butt Plate Spacer	53	Swivel Assembly (Q.D.)
9	Butt Plate Screw	54	Trigger (Restricted)
10	Ejector	55	Trigger Adjusting Screw (Restricted)
11	Ejector Pin		Trigger Assembly (Restricted)
12	Ejector Spring	56	Trigger Connector (Restricted)
13	Extractor	57	Trigger Engagement Screw (Restricted)
14	Extractor Rivet	58	Trigger Guard
	Fastener, Sling Strap		Trigger Guard Assembly
15	Firing Pin	59	Trigger Housing Assembly (Restricted)
16	Firing Pin Assembly	60	Trigger Pin (Restricted)
17	Firing Pin Cross Pin	61	Trigger Spring (Restricted)
19	Floor Plate Latch	62	Trigger Stop Screw (Restricted)
20	Floor Plate Latch Pin		
21	Floor Plate Latch Spring		
22	Floor Plate Pivot Pin		
23	Front Guard Screw		
24	Front Sight		
	Front Sight (Low)		
25	Front Sight Ramp		
26	Front Sight Ramp Screw		
27	Front Sight Hood		
28	Front Swivel Nut		
29	Front Swivel Screw		
	Grip Cap		
	Grip Cap Spacer		
	Grip Cap Spacer Screw		
30	Magazine		
31	Magazine Follower		
32	Magazine Spring		
33	Main Spring		
34	Rear Guard Screw		
35	Rear Sight Aperture		
36	Rear Sight Base		
37	Rear Sight Screw		
38	Rear Sight Slide		
39	Elevation Screw		
40	Windage Screw		
41	Rear Swivel Screw		
42	Receiver Plug Screw		
43	Safety Switch Assembly (Restricted)		
44	Safety Switch Detent Ball (Restricted)		
45	Safety Switch Detent Spring (Restricted)		

MODEL
700
LEFT HAND MODEL

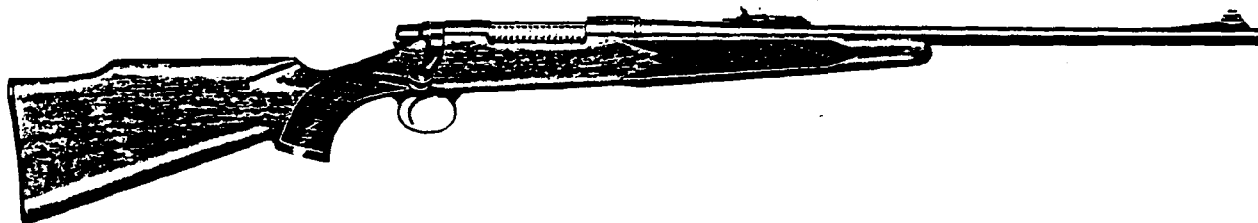
REMINGTON FIELD SERVICE MANUAL

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
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 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)

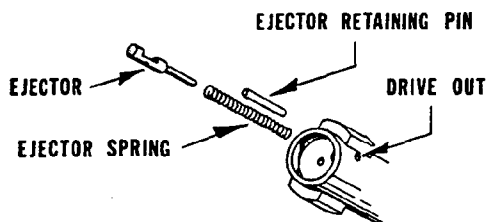


FIG. 1

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.

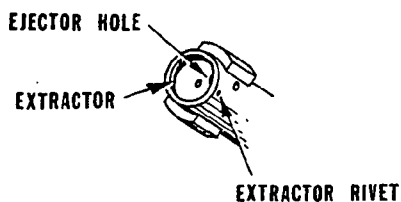


FIG. 2

Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.

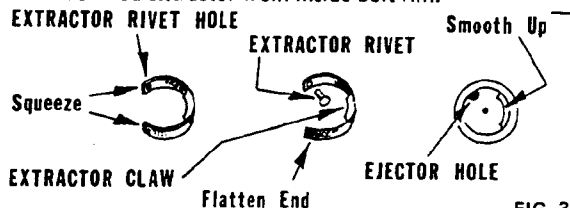


FIG. 3

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.

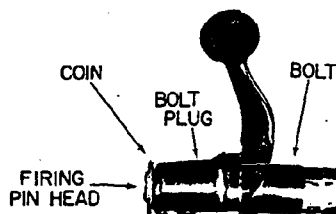
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

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.

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.

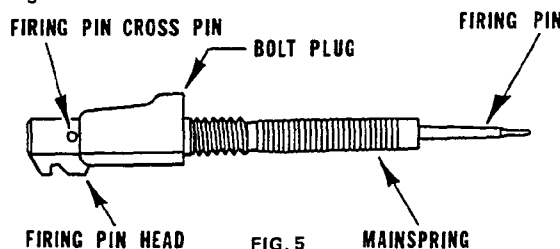


FIG. 5

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.

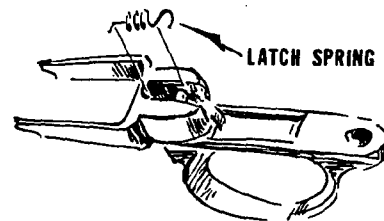


FIG. 6

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)

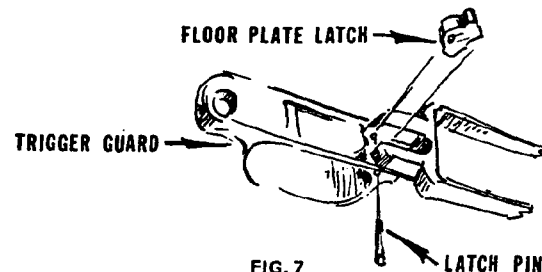


FIG. 7

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.

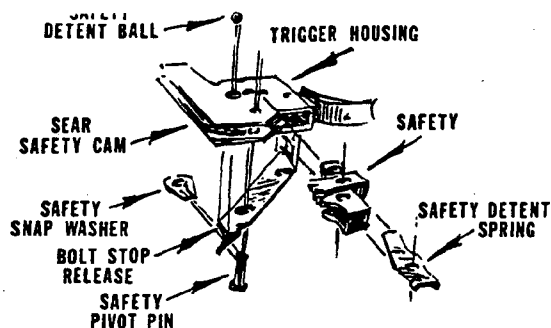


FIG. 8

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

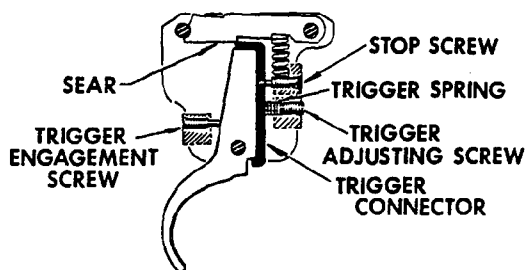


FIG. 9

and 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.

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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

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.
 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.

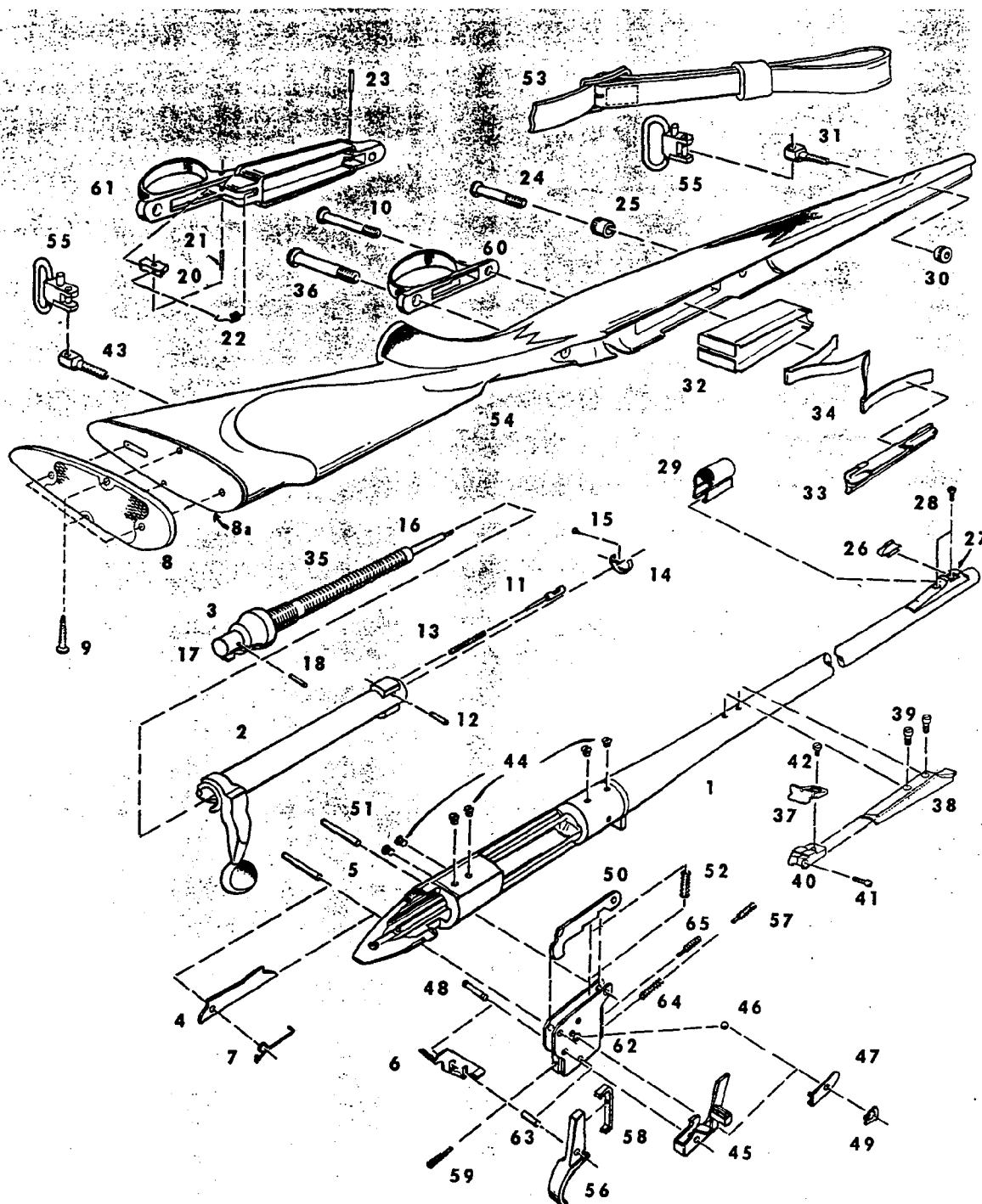
- Correction:
1. Remove interference or change Bolt.
 2. Fit new Extractor (grind relief in new Extractor behind Claw).
 3. Free up or replace.
 4. Deburr.
 5. File radius.
 6. Tighten or replace Rivet.

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.

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.			91017		Magazine Follower, BDL Grade
1		Barrel Assembly	15940		Magazine Tab Screw, ADL Grade
2		Bolt Assembly	34	17028	Magazine Spring
		Bolt Final Assembly		15677	Magazine Spring, BDL Grade
3	17012	Bolt Plug	35	17029	Main Spring
4	17013	Bolt Stop	36	26355	Rear Guard Screw
5	24475	Bolt Stop Pin	37	32510	Rear Sight Aperture
6	15478	Bolt Stop Release	38	32500	Rear Sight Base
7	15224	Bolt Stop Spring	39	28505	Rear Sight Base Screw (2)
8	90953	Butt Plate	40	90905	Rear Sight Slide
8a	90954	Butt Plate Spacer, BDL	41	90906	Elevation Screw
9	25380	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 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
20	15291	Floor Plate Latch, BDL Grade	53	30855	Sling Strap Assembly, BDL Grade
21	16451	Floor Plate Latch Pin, BDL Grade		26990	Sling Strap Assembly and Mountings Complete
22	16452	Floor Plate Latch Spring, BDL Grade	54	33366	Stock Assembly, ADL Grade
23	16453	Floor Plate Pivot Pin, BDL Grade		33371	Stock Assembly, BDL Grade
24	22035	Front Guard Screw		18186	Stock Reinforcing Screw (not shown)
25	15161	Front Guard Screw Bushing, ADL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
26	15373	Front Sight	55	26555	Swivel Assembly, BDL Grade (Q.D.)
	15719	Front Sight (Low)	56	15280	Trigger
27	28510	Front Sight Ramp	57	17053	Trigger Adjusting Screw
	15635	Front Sight Ramp, BDL Grade		26345	Trigger Assembly
28	28505	Front Sight Ramp Screw	58	19461	Trigger Connector
29	15363	Front Sight Hood, BDL Grade	59	91128	Trigger Engagement Screw
30	15357	Front Swivel Nut, BDL Grade	60	15281	Trigger Guard
31	15356	Front Swivel Screw, BDL Grade	61	26376	Trigger Guard, BDL Grade
	90957	Grip Cap, BDL Grade (not shown)		26371	Trigger Guard Assembly, BDL Grade
	25380	Grip Cap Screw	62	26655	Trigger Housing Assembly
	90958	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	90952	Magazine Follower			



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)

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 Rem., 22-250 Rem., BDL Grade, 17 Rem.
15850	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
27342	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
22021	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem., 223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308 Win., 6mm Rem., 22-250 Rem. 223 Rem.	CALIBERS: 375 H & H Magnum, 458 WIN. MAGNUM	
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27265	Barrel Assembly, 375 H & H Mag.
22037	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	27266	Barrel Assembly, 458 Win. Mag.
16204	Front Scope Base, Varmint	15709	Extractor
14659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	16771	Front Sight, 375 H & H Mag.
28511	Front Sight Ramp, ADL Grade	23805	Front Sight, 458 Win. Mag.
15992	Front Sight Ramp, BDL Grade	27270	Stock Assembly, 375 H & H Mag., 458 Win. Mag. (includes same as standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used)
15282	Magazine, ADL Grade, 222 Rem.	DISCONTINUED or SERVICE PARTS	
16716	Magazine, BDL Grade, 222 Rem., 223 Rem., 17 Rem.	26270	Barrel Assembly, 280 Rem.
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	20467	Extractor, 222 Cal.
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	17639	Ejector, 222 Cal.
14756	Magazine, BDL Grade	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
90951	Magazine Follower, 222 Rem., 223 & 17 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
90982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
15742	Magazine Spacer, 222 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
15286	Magazine Spacer, 222 Rem., BDL Grade	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2))
91133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		
15698	Magazine Spring, 22-250 Rem.		
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.		
25410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		
18842	Scope Base Screw, Rear Varmint		
16205	Scope Base Screw, Front Varmint		
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		

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:

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:

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.
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.
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).
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.
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.
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.

MODEL
700
LEFT HAND MODEL

REMINGTON
FIELD SERVICE MANUAL

PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 caliber listed below. For other caliber parts and numbers see additional calibers list.			41	15358	Rear Swivel Screw
1		Barrel Assembly	42	17034	Receiver Plug Screw
2		Bolt Assembly	43	32900	Safety Assembly
		Bolt Final Assembly	44	23222	Safety Detent Ball
3	17012	Bolt Plug	45	90557	Safety Detent Spring
4	17013	Bolt Stop	46	17043	Safety Pivot Pin
5	24475	Bolt Stop Pin	47	17044	Safety Snap Washer
6	90555	Bolt Stop Release	48	15666	Sear Safety Cam
7	90554	Bolt Stop Spring	49	24476	Sear Pin
8	90953	Butt Plate	50	17047	Sear Spring
8a	90954	Butt Plate Spacer	51	30855	Sling Strap Assembly
9	25380	Butt Plate Screw		26990	Sling Strap Assembly and Mountings Complete
10	17017	Ejector	52	33391	Stock Assembly
11	17676	Ejector Pin		18186	Stock Reinforcing Screw
12	17019	Ejector Spring		16970	Stock Reinforcing Screw Dowel
13	14669	Extractor	53	26555	Swivel Assembly (Q.D.)
14	27340	Extractor Rivet	54	15280	Trigger
	15376	Fastener, Sling Strap	55	17053	Trigger Adjusting Screw
15	22020	Firing Pin		32895	Trigger Assembly
16	22040	Firing Pin Assembly	56	19461	Trigger Connector
17	17022	Firing Pin Cross Pin	57	91128	Trigger Engagement Screw
19	15291	Floor Plate Latch	58	26376	Trigger Guard
20	16451	Floor Plate Latch Pin		26371	Trigger Guard Assembly
21	16452	Floor Plate Latch Spring	59	32905	Trigger Housing Assembly
22	16453	Floor Plate Pivot Pin	60	24477	Trigger Pin
23	22035	Front Guard Screw	61	15400	Trigger Spring
24	15373	Front Sight	62	15481	Trigger Stop Screw
	15719	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			
	90957	Grip Cap			
	90958	Grip Cap Spacer			
	25380	Grip Cap Spacer Screw			
30	16430	Magazine			
31	91017	Magazine Follower			
32	15677	Magazine Spring			
33	17029	Main Spring			
34	26355	Rear Guard Screw			
35	23510	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			

ADDITIONAL CALIBERS

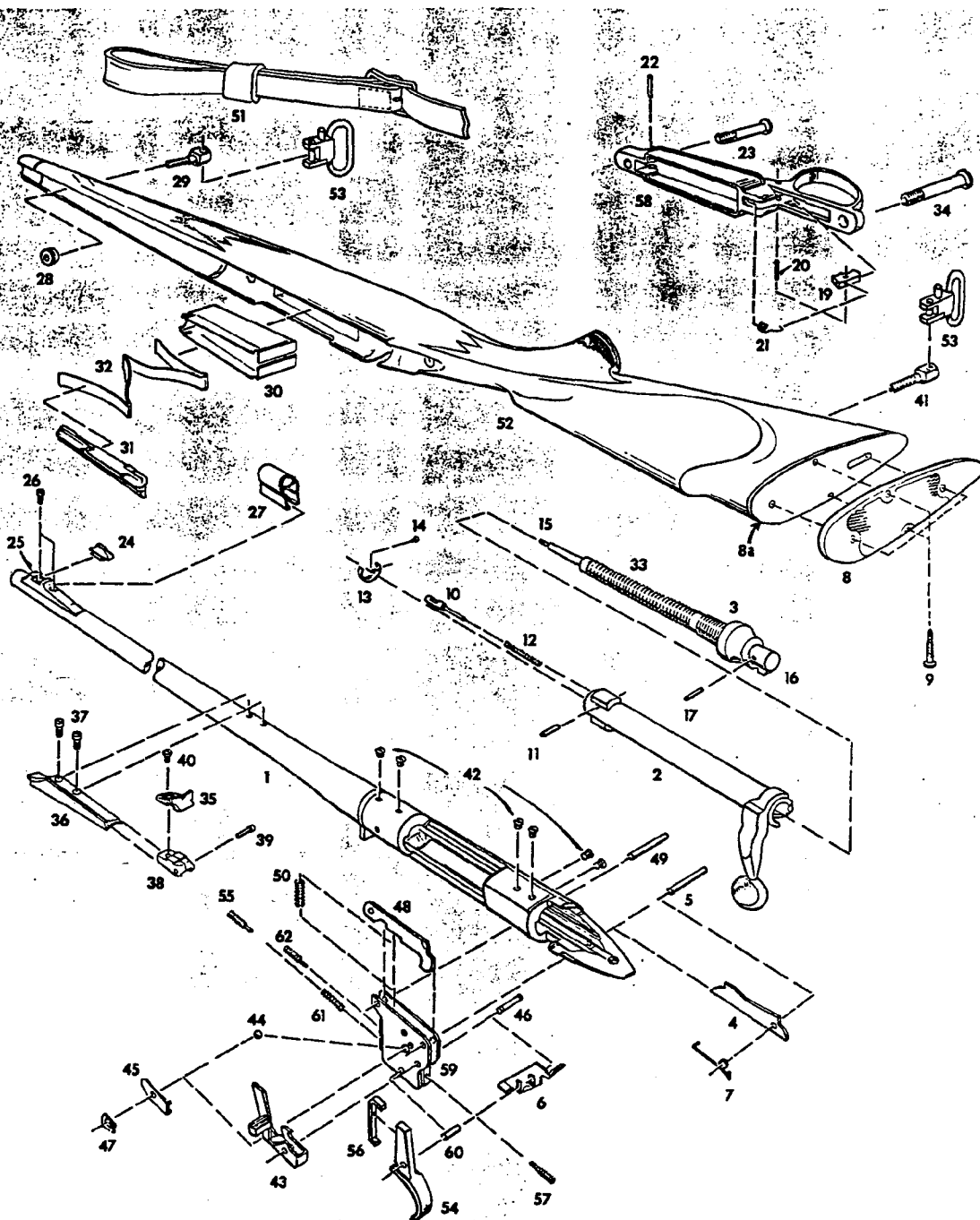
NOTE: Part not listed same as 30-06 Caliber

Barrel Assembly, 7mm Rem. Mag. _____
 Barrel Assembly, 270 Win. _____
 Bolt Assembly, 7mm Rem. Mag. _____
 15709 Extractor, 7mm Rem. Mag. _____
 27341 Extractor Rivet, 7mm Rem. Mag. _____
 14659 Front Sight, 7mm Rem. Mag. _____
 90949 Recoil Pad, 7mm Rem. Mag. _____
 25410 Recoil Pad Screw, 7mm Rem. Mag. _____
 33395 Stock Assembly, 7mm Rem. Mag. _____

EXPLODED
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700
LEFT HAND MODEL



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.

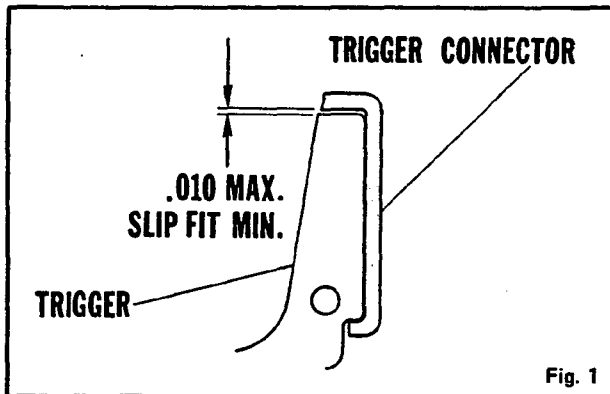


Fig. 1

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).

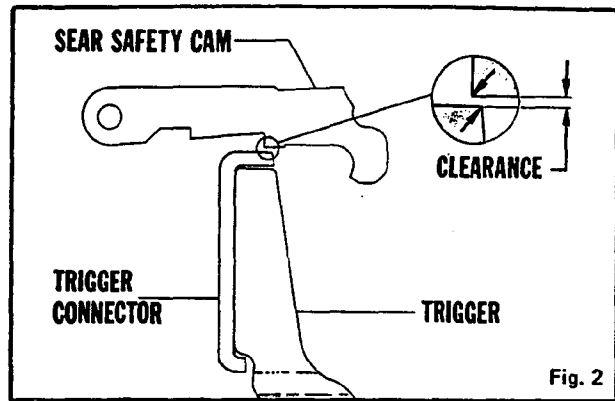


Fig. 2

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).

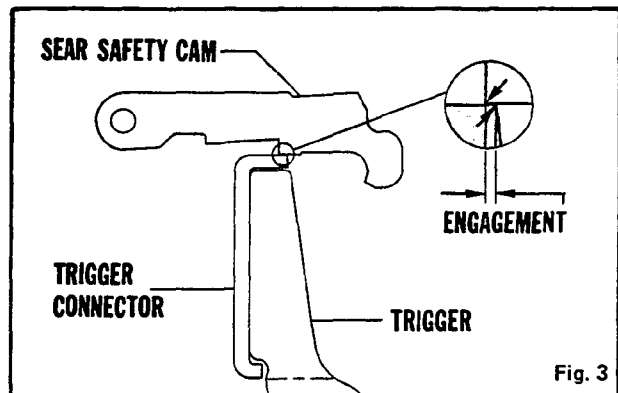


Fig. 3

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

1. **"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).

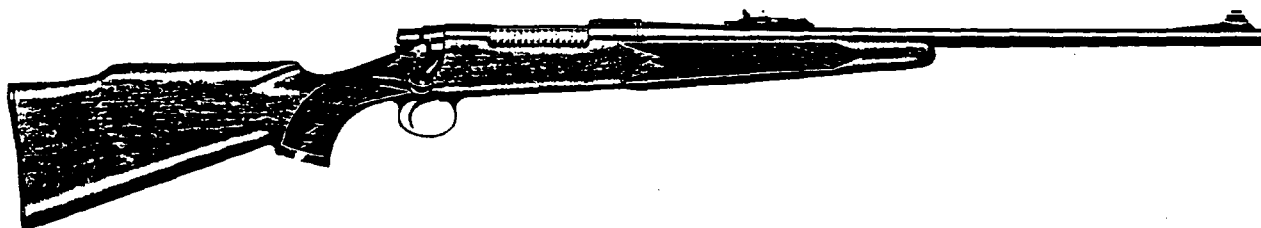
3. **"Firing Pin Fails to Fall."** If firing pin fails to fall when trigger is pulled or trigger has to be pulled more than once. See firing pin falls for possible cause and corrections. (see note B).

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.

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

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)

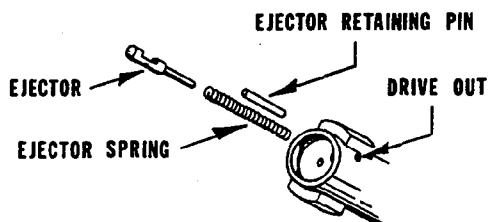


FIG. 1

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.

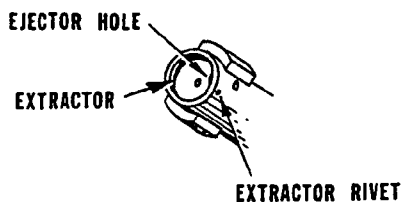


FIG. 2

Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.

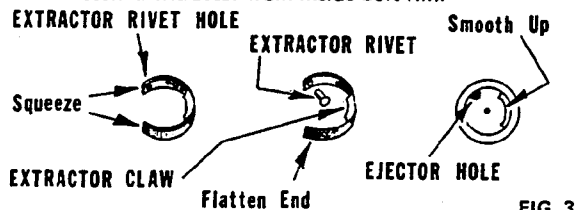


FIG. 3

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.

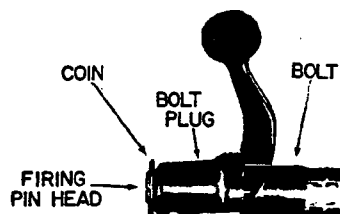
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

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.

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.

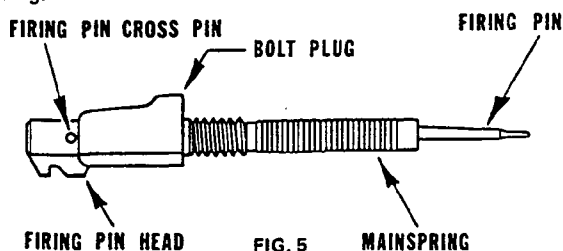


FIG. 5

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.

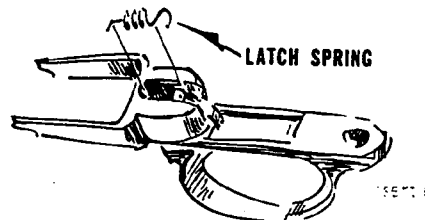


FIG. 6

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)

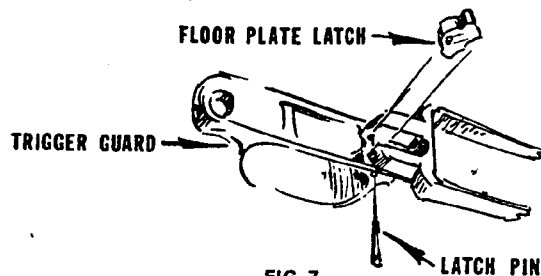


FIG. 7

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.
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

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

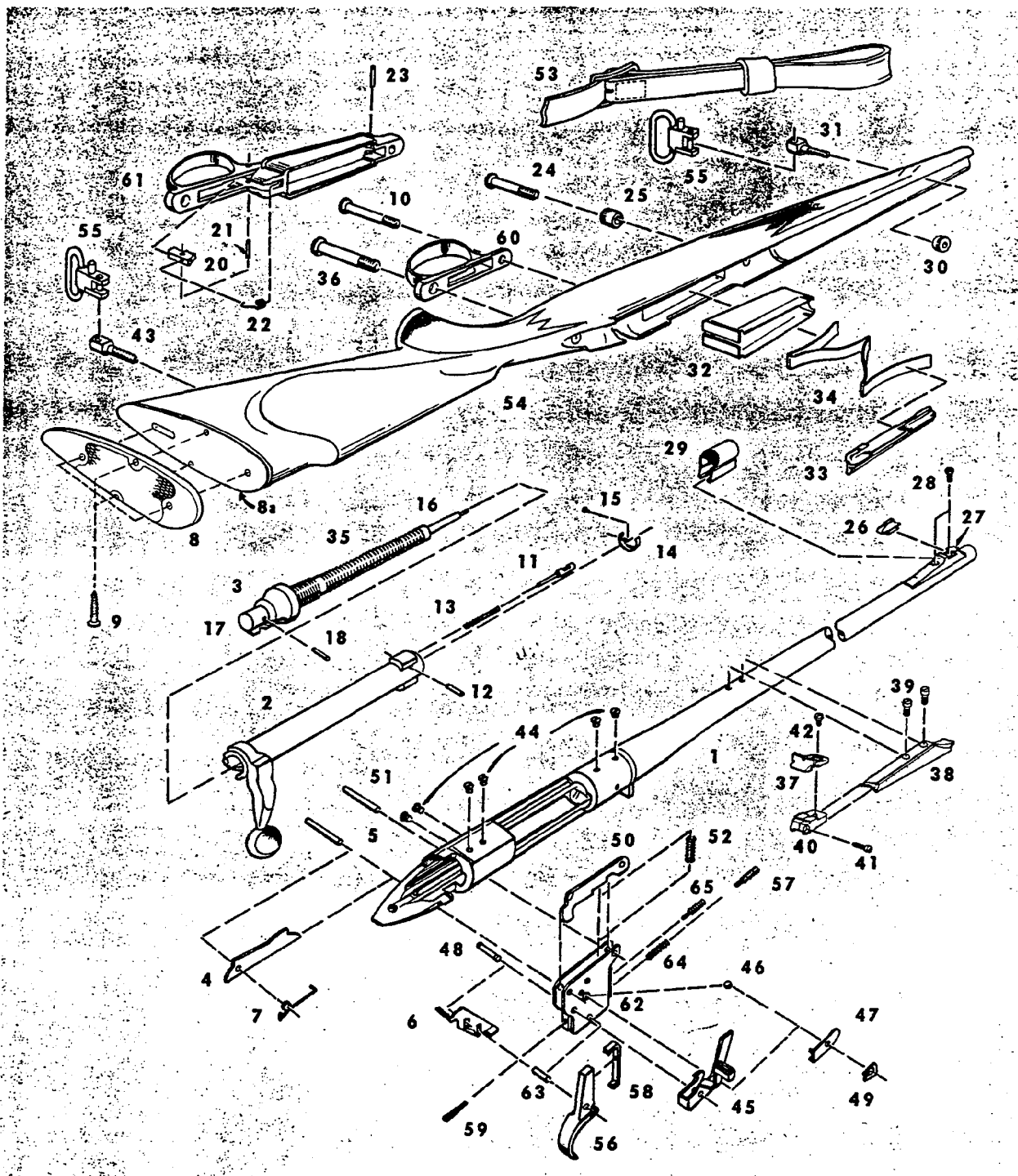
Cause:

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.

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.					
1		Barrel Assembly	35	17029	Main Spring
2		Bolt Assembly	36	26355	Rear Guard Screw
		Bolt Final Assembly	37	32510	Rear Sight Aperture
3	17012	Bolt Plug	38	91595	Rear Sight Base
4	17013	Bolt Stop (Restricted)	39	28505	Rear Sight Base Screw (2)
5	24475	Bolt Stop Pin (Restricted)	40	90905	Rear Sight Slide
6	15478	Bolt Stop Release (Restricted)	41	90906	Elevation Screw
7	15224	Bolt Stop Spring (Restricted)	42	90904	Windage Screw
8	90953	Butt Plate	43	15358	Rear Swivel Screw, BDL Grade
8a	90954	Butt Plate Spacer, BDL	44	17034	Receiver Plug Screw
9	25380	Butt Plate Screw	45	26585	Safety Switch Assembly (Restricted)
10	15287	Center Guard Screw, ADL Grade	46	23222	Safety Switch Detent Ball (Restricted)
11	17017	Ejector	47	15368	Safety Switch Detent Spring (Restricted)
12	17676	Ejector Pin	48	17043	Safety Switch Pivot Pin (Restricted)
13	17019	Ejector Spring	49	17044	Safety Switch Snap Washer (Restricted)
14	91816	Extractor	50	15666	Sear Safety Cam (Restricted)
	15376	Fastener, Sling Strap	51	24476	Sear Pin (Restricted)
16	22020	Firing Pin	52	17047	Sear Spring (Restricted)
17	22040	Firing Pin Assembly	53	30855	Sling Strap Assembly, BDL Grade
18	17022	Firing Pin Cross Pin		26990	Sling Strap Assembly and Mountings Complete
20	15291	Floor Plate Latch, BDL Grade	54	33366	Stock Assembly, ADL Grade
21	16451	Floor Plate Latch Pin, BDL Grade		33371	Stock Assembly, BDL Grade
22	16452	Floor Plate Latch Spring, BDL Grade		18186	Stock Reinforcing Screw (not shown)
23	16453	Floor Plate Pivot Pin, BDL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
24	22035	Front Guard Screw	55	26555	Swivel Assembly, BDL Grade (Q.D.)
25	15161	Front Guard Screw Bushing, ADL Grade	56	15280	Trigger (Restricted)
26	15373	Front Sight	57	17053	Trigger Adjusting Screw (Restricted)
	15719	Front Sight (Low)		26345	Trigger Assembly (Restricted)
27	28510	Front Sight Ramp	58	19461	Trigger Connector (Restricted)
	15635	Front Sight Ramp, BDL Grade	59	91128	Trigger Engagement Screw (Restricted)
28	28505	Front Sight Ramp Screw	60	15281	Trigger Guard
29	15363	Front Sight Hood, BDL Grade	61	26376	Trigger Guard, BDL Grade
30	15357	Front Swivel Nut, BDL Grade		26371	Trigger Guard Assembly, BDL Grade
31	15358	Front Swivel Screw, BDL Grade	62	26655	Trigger Housing Assembly (Restricted)
	90957	Grip Cap, BDL Grade (not shown)	63	24477	Trigger Pin (Restricted)
	25380	Grip Cap Screw	64	15400	Trigger Spring (Restricted)
	90958	Grip Cap Spacer, BDL Grade (not shown)	65	15481	Trigger Stop Screw (Restricted)
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			
	15677	Magazine Spring, BDL Grade			



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)

Part No.	NAME OF PART	Part No.	NAME OF PART
91837	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem. 22-250 Rem., BDL Grade, 17 Rem.
91906	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.
22021	Firing Pin, 222 Rem., 234-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308 Win., 6mm Rem., 22-250 Rem. 223 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 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. (includes same as standard Magnum except Stock Bolt (2) Nut (2), Cover (4) used)
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.		DISCONTINUED or SERVICE PARTS
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem. 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 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag. 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
15742	Magazine Spacer, 222 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
15286	Magazine Spacer, 222 Rem., BDL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
91133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2))
15698	Magazine Spring, 22-250 Rem.	15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag.
15699	Magazine Spring, 22-250 Rem., 6mm Rem. 243 Win., BDL Grade	15850	Extractor, 222-223 Rem., 17 Rem.
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win., 17 Rem.	27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.
18843	Rear Scope Base, Varmint	27342	Extractor Rivet, 222-223 Rem., 17 Rem.
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		
16204	Scope Base Screw, Front Varmint		
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		

Deliveries are F.O.B. Ilian, New York

Parts Subject to Change Without Notice

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.
 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.

**MODEL
700
LEFT HAND MODEL**

**REMINGTON
FIELD SERVICE MANUAL**

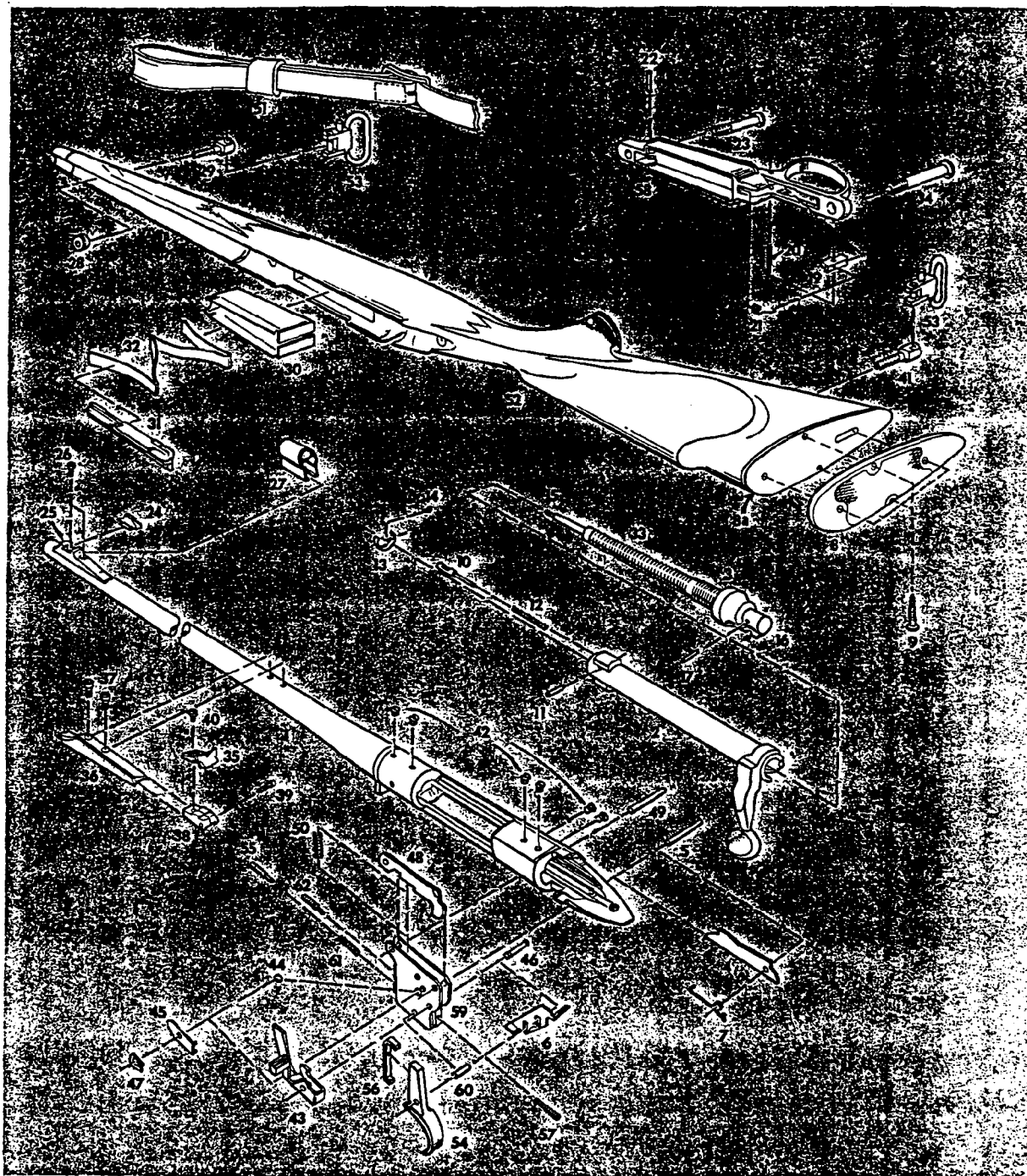
PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 caliber listed below. For other caliber parts and numbers, see additional calibers list.			46	17043	Safety Switch Pivot Pin (Restricted)
1		Barrel Assembly	47	17044	Safety Switch Snap Washer (Restricted)
2		Bolt Assembly	48	15666	Sear Safety Cam (Restricted)
		Bolt Final Assembly	49	24476	Sear Pin (Restricted)
3	17012	Bolt Plug	50	17047	Sear Spring (Restricted)
4	17013	Bolt Stop (Restricted)	51	30855	Sling Strap Assembly
5	24475	Bolt Stop Pin (Restricted)		26990	Sling Strap Assembly and Mountings Complete
6	90555	Bolt Stop Release (Restricted)	52	33391	Stock Assembly
7	90554	Bolt Stop Spring (Restricted)		18186	Stock Reinforcing Screw
8	90953	Butt Plate		16970	Stock Reinforcing Screw Dowel
8a	90954	Butt Plate Spacer	53	26555	Swivel Assembly (Q.D.)
9	25380	Butt Plate Screw	54	15280	Trigger (Restricted)
10	17017	Ejector	55	17053	Trigger Adjusting Screw (Restricted)
11	17676	Ejector Pin		32895	Trigger Assembly (Restricted)
12	17019	Ejector Spring	56	19461	Trigger Connector (Restricted)
13	91816	Extractor	57	91128	Trigger Engagement Screw (Restricted)
14	27340	Extractor Rivet	58	26376	Trigger Guard
	15376	Fastener, Sling Strap		26371	Trigger Guard Assembly
15	22020	Firing Pin	59	32905	Trigger Housing Assembly (Restricted)
16	22040	Firing Pin Assembly	60	24477	Trigger Pin (Restricted)
17	17022	Firing Pin Cross Pin	61	15400	Trigger Spring (Restricted)
19	15291	Floor Plate Latch	62	15481	Trigger Stop Screw (Restricted)
20	16451	Floor Plate Latch Pin	ADDITIONAL CALIBERS		
21	16452	Floor Plate Latch Spring			
22	16453	Floor Plate Pivot Pin	NOTE: Parts not listed, same as 30-06 Caliber.		
23	22035	Front Guard Screw			
24	15373	Front Sight	Barrel Assembly, 7mm Rem. Mag.		
	15719	Front Sight (Low)			
25	15635	Front Sight Ramp	Barrel Assembly, 270 Win.		
26	28505	Front Sight Ramp Screw			
27	15363	Front Sight Hood	Bolt Assembly, 7mm Rem. Mag.		
28	15357	Front Swivel Nut			
29	15358	Front Swivel Screw	91837	Extractor, 7mm Rem. Mag.	
	90957	Grip Cap	27341	Extractor Rivet, 7mm Rem. Mag.	
	90958	Grip Cap Spacer	14659	Front Sight, 7mm Rem. Mag.	
	25380	Grip Cap Spacer Screw	90949	Recoil Pad, 7mm Rem. Mag.	
30	16430	Magazine	25410	Recoil Pad Screw, 7mm Rem. Mag.	
31	91017	Magazine Follower	33395	Stock Assembly, 7mm Rem. Mag.	
32	15677	Magazine Spring			
33	17029	Main Spring			
34	26355	Rear Guard Screw			
35	32510	Rear Sight Aperture			
36	91595	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 Switch Assembly (Restricted)			
44	23222	Safety Switch Detent Ball (Restricted)			
45	90557	Safety Switch Detent Spring (Restricted)			

EXPLODED
VIEW

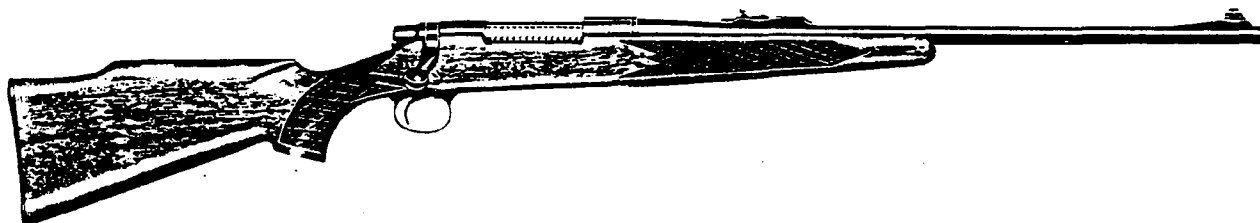
REMINGTON FIELD SERVICE MANUAL

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 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 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)

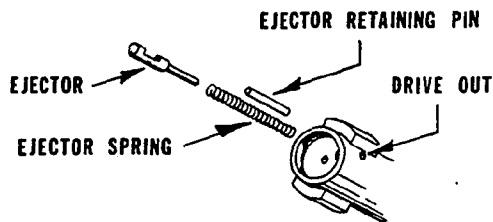


FIG. 1

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.

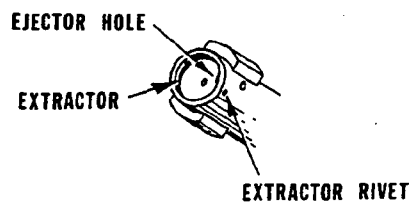


FIG. 2

Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.

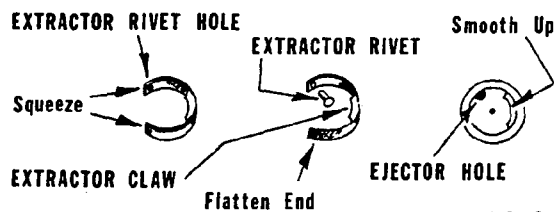


FIG. 3

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.

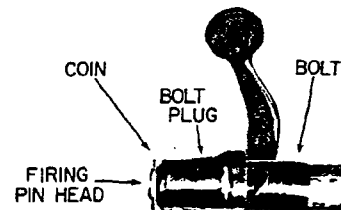
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

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.

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.

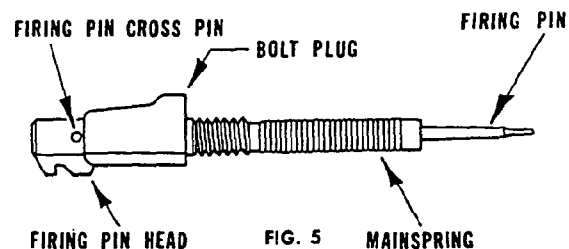


FIG. 5

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 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 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.

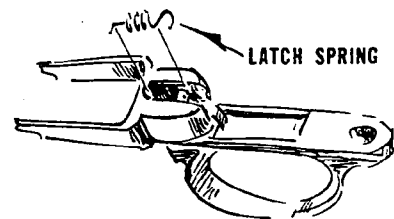


FIG. 6

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.

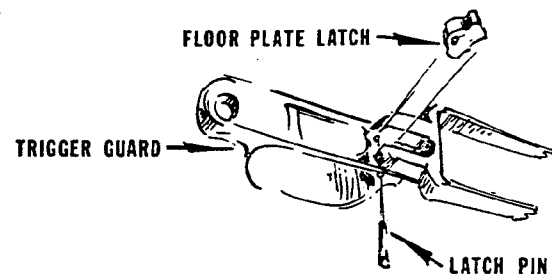


FIG. 7

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

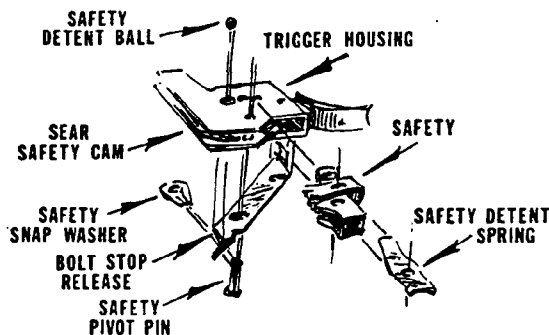


FIG. 8

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

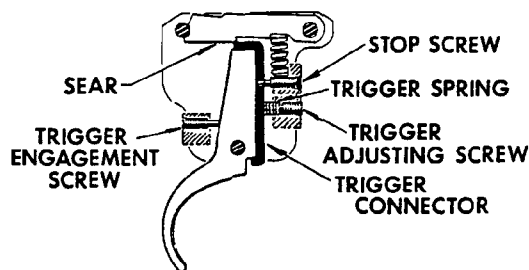


FIG. 9

and 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 (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 $\frac{3}{8}$ " 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.

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 $\frac{1}{8}$ " 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.
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.

(Continued on page 8)

**MODEL
700**

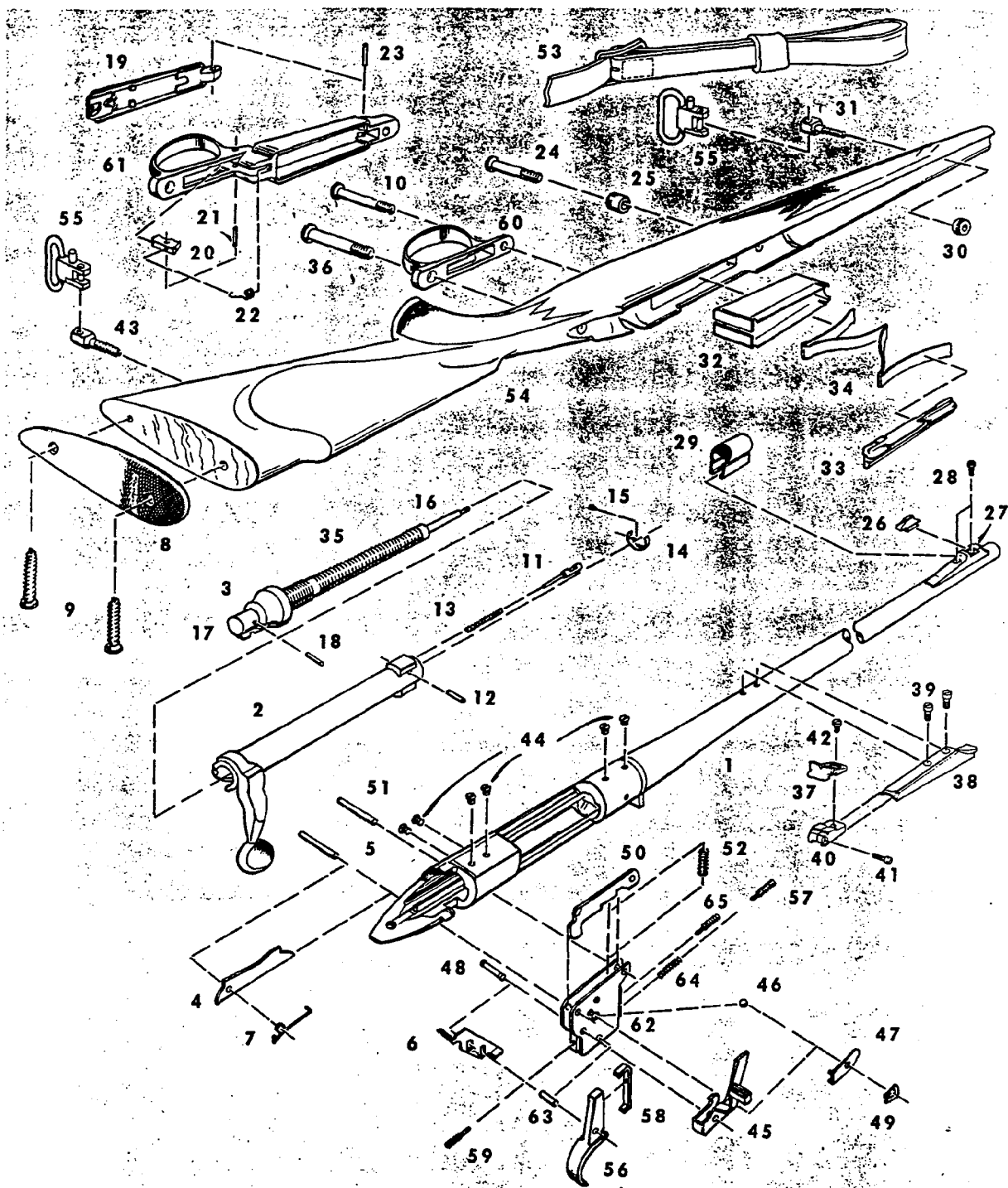
**REMINGTON
FIELD SERVICE MANUAL**

PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below, See Sectional View for proper identity of parts. See added page for other caliber part listings.					
1		Barrel Assembly	34	15752	Magazine Follower, BDL Grade
2		Bolt Assembly		15940	Magazine Tab Screw (ADL Grade)
		Bolt Final Assembly		17028	Magazine Spring
3	17012	Bolt Plug	35	15677	Magazine Spring, BDL Grade
4	17013	Bolt Stop	36	17029	Main Spring
5	24475	Bolt Stop Pin	37	26355	Rear Guard Screw
6	15478	Bolt Stop Release	38	32510	Rear Sight Aperture
7	15224	Bolt Stop Spring	39	32500	Rear Sight Base
8	14472	Butt Plate	40	28505	Rear Sight Base Screw (2)
9	25410	Butt Plate Screw	41	90905	Rear Sight Slide
10	15287	Center Guard Screw, ADL Grade	42	90906	Elevation Screw
11	17017	Ejector	43	90904	Windage Screw
12	17676	Ejector Pin	44	15358	Rear Swivel Screw, BDL Grade
13	17019	Ejector Spring	45	17034	Receiver Plug Screw
14	14669	Extractor	46	26585	Safety Assembly
15	27340	Extractor Rivet	47	23222	Safety Detent Ball
	15376	Fastener, Sling Strap	48	15368	Safety Detent Spring
16	22020	Firing Pin	49	17043	Safety Pivot Pin
17	22040	Firing Pin Assembly	50	17044	Safety Snap Washer
18	17022	Firing Pin Cross Pin	51	15666	Sear Safety Cam
19	19800	Floor Plate, BDL Grade	52	24476	Sear Pin
20	15291	Floor Plate Latch, BDL Grade	53	17047	Sear Spring
21	16451	Floor Plate Latch Pin, BDL Grade		30855	Sling Strap Assembly, BDL Grade
22	16452	Floor Plate Latch Spring, BDL Grade		26990	Sling Strap Assembly and Mountings Complete
23	16453	Floor Plate Pivot Pin, BDL Grade	54	26381	Stock Assembly, ADL Grade
24	22035	Front Guard Screw		26401	Stock Assembly, BDL Grade
25	15161	Front Guard Screw Bushing, ADL Grade		18186	Stock Reinforcing Screw (not shown)
26	15373	Front Sight	55	16970	Stock Reinforcing Screw Dowel (not shown)
	15719	Front Sight (Low)	56	26555	Swivel Assembly, BDL Grade (Q.D.)
27	28510	Front Sight Ramp	57	15280	Trigger
	15635	Front Sight Ramp, BDL Grade		17053	Trigger Adjusting Screw
28	28505	Front Sight Ramp Screw	58	26345	Trigger Assembly
29	15363	Front Sight Hood, BDL Grade	59	19461	Trigger Connector
30	15357	Front Swivel Nut, BDL Grade	60	17053	Trigger Engagement Screw
31	15356	Front Swivel Screw, BDL Grade	61	15281	Trigger Guard
	15331	Grip Cap, BDL Grade (not shown)		26376	Trigger Guard, BDL Grade
	30505	Grip Cap Spacer, BDL Grade (not shown)	62	26371	Trigger Guard Assembly, BDL Grade
32	15284	Magazine, ADL Grade	63	26655	Trigger Housing Assembly
	16430	Magazine, BDL Grade (not shown)	64	24477	Trigger Pin
33	17024	Magazine Follower	65	15400	Trigger Spring
				15481	Trigger Stop Screw

Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice



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)

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., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem., 223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.
27342	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.	CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM	
22021	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	27265	Barrel Assembly, 375 H&H Mag.
22041	Firing Pin Assembly, 222 Rem., 17 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 223 Rem.	27266	Barrel Assembly, 458 Win. Mag.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	15709	Extractor
22037	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	16771	Front Sight, 375 H&H Mag.
16204	Front Scope Base, Varmint	23805	Front Sight, 458 Win. Mag.
14659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as 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., 17 Rem.	17639	Ejector, 222 Cal.
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem., 22-250 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 223 Rem. Mag., 243 Win., ADL Grade
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem., 22-250 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 223 Rem. Mag., 243 Win., BDL Grade
14756	Magazine, BDL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
91018	Magazine Follower, 222 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 223 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., 223 Rem. Mag., 243 Win.
15285	Magazine Spacer, 222 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2))
16826	Magazine Spacer, 222 Rem., BDL Grade		
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.		
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.		
25410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		
18842	Scope Base Screw, Rear Varmint		
16205	Scope Base Screw, Front Varmint		
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		
33370	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:

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:

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.
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.
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).
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.
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.
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.

**MODEL
700
LEFT HAND MODEL**

**REMINGTON
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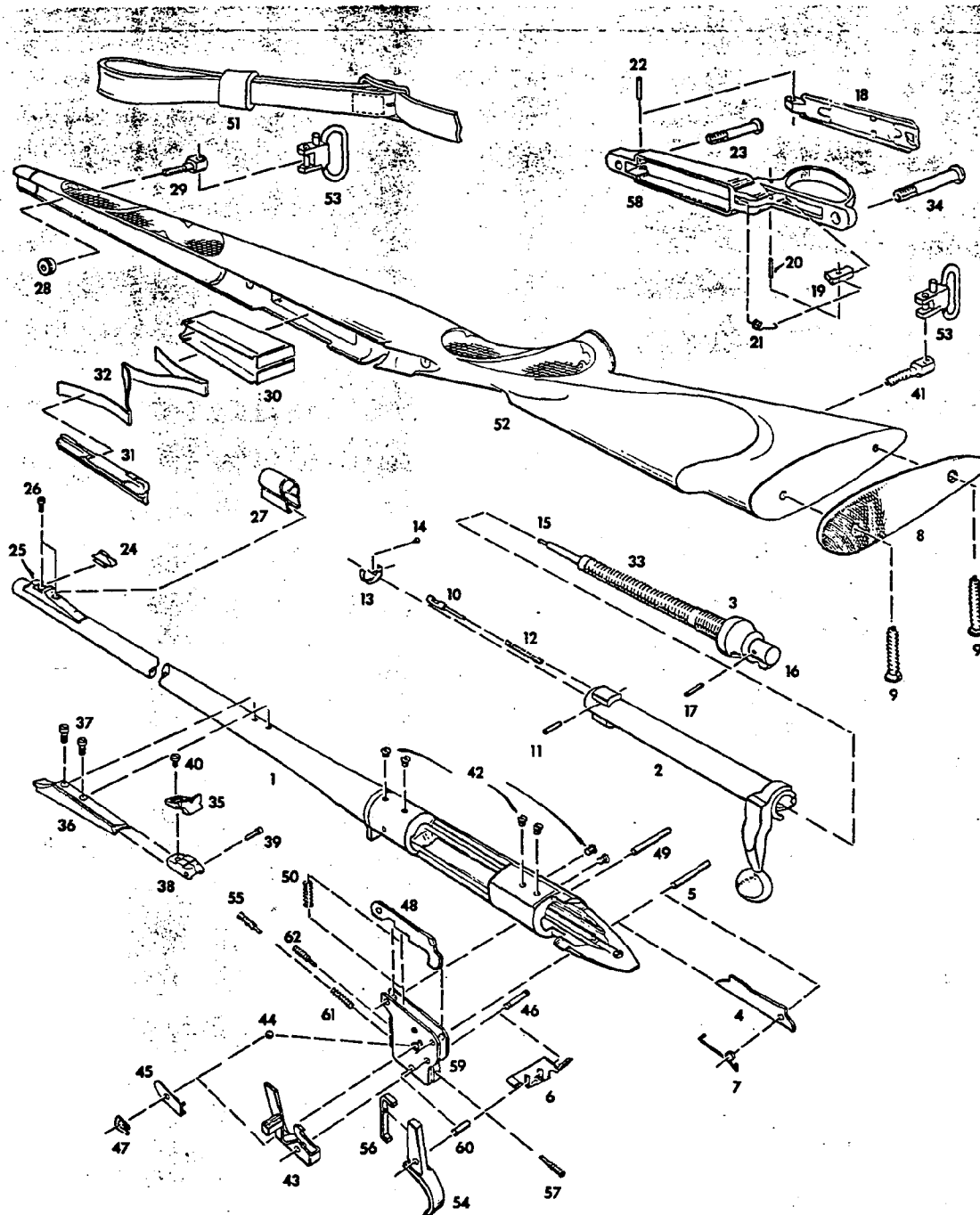
PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 caliber listed below. For other caliber parts and numbers see additional calibers list.			51	30855	Sling Strap Assembly.....
1		Barrel Assembly.....		26990	Sling Strap Assembly and Mountings Complete.....
2		Bolt Assembly.....	52	32890	Stock Assembly.....
		Bolt Final Assembly.....		18186	Stock Reinforcing Screw.....
3	17012	Bolt Plug.....		16970	Stock Reinforcing Screw Dowel.....
4	17013	Bolt Stop.....	53	26555	Swivel Assembly (Q. D.).....
5	24475	Bolt Stop Pin.....	54	15280	Trigger.....
6	90555	Bolt Stop Release.....	55	17053	Trigger Adjusting Screw.....
7	90554	Bolt Stop Spring.....		32895	Trigger Assembly.....
8	14472	Butt Plate.....	56	19461	Trigger Connector.....
9	25410	Butt Plate Screw.....	57	17053	Trigger Engagement Screw.....
10	17017	Ejector.....	58	26376	Trigger Guard.....
11	17676	Ejector Pin.....		26371	Trigger Guard Assembly.....
12	17019	Ejector Spring.....	59	32905	Trigger Housing Assembly.....
13	14669	Extractor.....	60	24477	Trigger Pin.....
14	27340	Extractor Rivet.....	61	15400	Trigger Spring.....
	15376	Fastener, Sling Strap.....	62	15481	Trigger Stop Screw.....
15	22020	Firing Pin.....	ADDITIONAL CALIBERS		
16	22040	Firing Pin Assembly.....	NOTE: Part not listed same as 30-06 Caliber		
17	17022	Firing Pin Cross Pin.....	Barrel Assembly, 7mm Rem. Mag.		
18	19800	Floor Plate.....	Barrel Assembly, 270 Win.		
19	15291	Floor Plate Latch.....	32862		Bolt Assembly, 7mm Rem. Mag.
20	16451	Floor Plate Latch Pin.....	15709		Extractor, 7mm Rem. Mag.
21	16452	Floor Plate Latch Spring.....	27341		Extractor Rivet, 7mm Rem. Mag.
22	16453	Floor Plate Pivot Pin.....	14659		Front Sight, 7mm Rem. Mag.
23	22035	Front Guard Screw.....	21387		Recoil Pad, 7mm Rem. Mag.
24	15373	Front Sight.....	25410		Recoil Pad Screw, 7mm Rem. Mag.
	15719	Front Sight (Low).....	32880		Stock Assembly, 7mm Rem. Mag.
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.....			
31	15752	Magazine Follower.....			
32	15677	Magazine Spring.....			
33	17029	Main 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.....			

EXPLODED
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700
LEFT HAND MODEL



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 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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Safety (See 721-722 Manual)	-
Trigger Assembly (See 721-722 Manual)	-

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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.

Caution: 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.

To Disassemble - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

Caution: Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

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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 face of bolt, and disassemble extractor and rivet from bolt.

To Reassemble - Adjust replacement for proper tension before reassembly 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.

Note: 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 above.

After proper tension has been adjusted, smooth up incline on extractor to match perfectly to breech bolt rim. (See sketch on preceding page)

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)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

To Reassemble - 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

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - 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.

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

To Disassemble - 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)

To Disassemble - Unscrew front sight ramp screw and pry ramp up off ramp pins.

To Replace - Interchangeable - no factory adjustment required.

To Reassemble - 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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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

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(Reserve for Sectional View)

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Safety (See 721-722 Manual)

Trigger Assembly (See 721-722 Manual)

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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.

Caution: 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.

To Disassemble - Pry up extractor from inner rim, on face of bolt, and disassemble extractor and rivet from bolt.

To Replace - Adjust replacement for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See sketch below)

Straighten tail of extractor. (See sketch above)

**REMINGTON
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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.

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MAGAZINE Continued

To Reassemble - 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.

Note: 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.

To Disassemble - Disassemble breech bolt from gun. Drive ejector retaining pin from breech bolt. (See sketch below)

Caution: 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

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.

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ASSEMBLY

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.

To Reassemble - 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.

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

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)

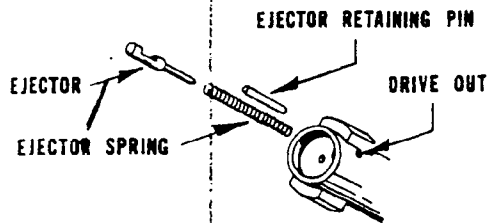


FIG. 1

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.

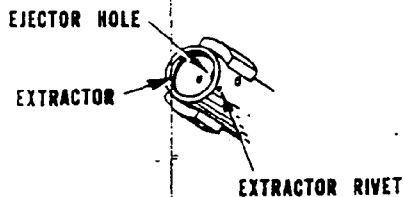


FIG. 2

Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.

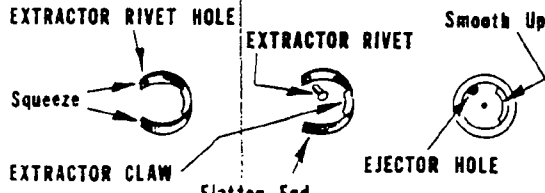


FIG. 3

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.

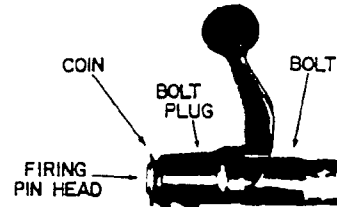
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

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.

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.

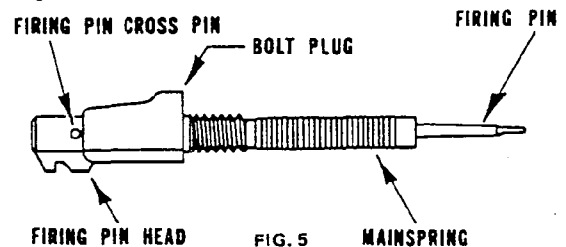


FIG. 5

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.

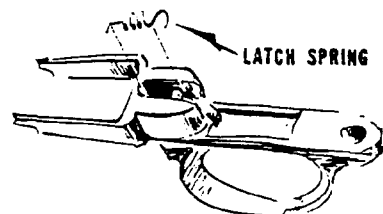


FIG. 6

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)

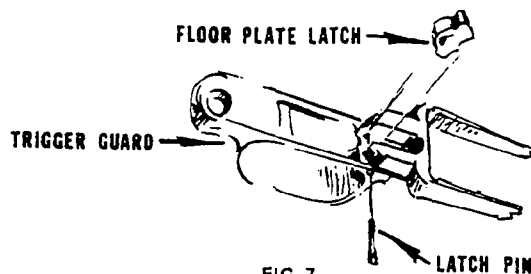


FIG. 7

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.
 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

- 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.

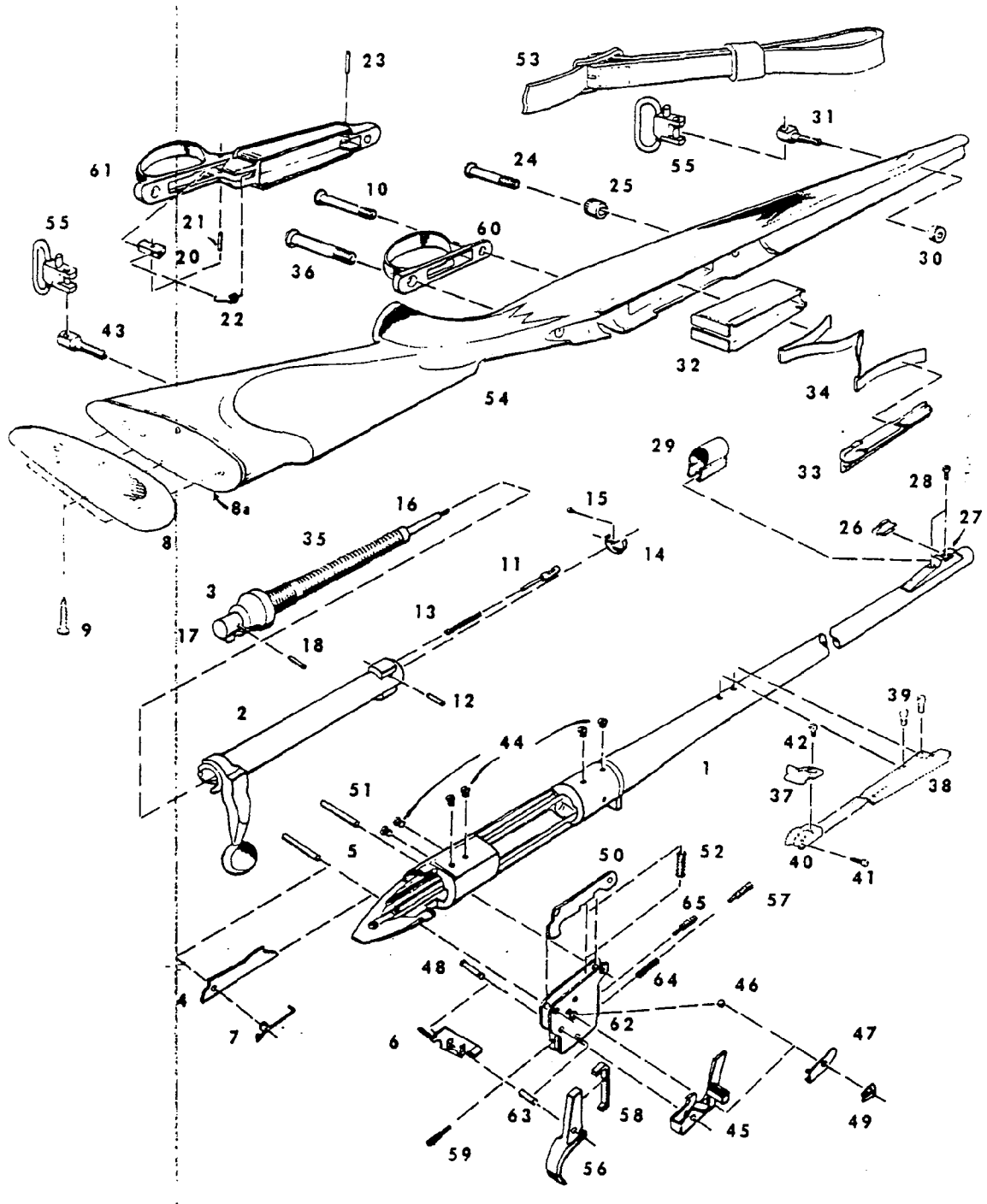
- Correction:**
1. File ends of Screws.
 2. File ends of Screws.
 3. Correct Stock or fit new Stock.
 4. File to blend.

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.					
1		Barrel Assembly	35	17029	Main Spring
2		Bolt Assembly	36	26355	Rear Guard Screw
		Bolt Final Assembly	37	32510	Rear Sight Aperture
3	17012	Bolt Plug	38	91595	Rear Sight Base
4	17013	Bolt Stop (Restricted)	39	28505	Rear Sight Base Screw (2)
5	24475	Bolt Stop Pin (Restricted)	40	90905	Rear Sight Slide
6	15478	Bolt Stop Release (Restricted)	41	90906	Elevation Screw
7	15224	Bolt Stop Spring (Restricted)	42	90904	Windage Screw
8	90953	Butt Plate	43	15358	Rear Swivel Screw, BDL Grade
8a	90954	Butt Plate Spacer, BDL	44	17034	Receiver Plug Screw
9	25380	Butt Plate Screw	45	26585	Safety Switch Assembly (Restricted)
10	15287	Center Guard Screw, ADL Grade	46	23222	Safety Switch Detent Ball (Restricted)
11	17017	Ejector	47	15368	Safety Switch Detent Spring (Restricted)
12	17676	Ejector Pin	48	17043	Safety Switch Pivot Pin (Restricted)
13	17019	Ejector Spring	49	17044	Safety Switch Snap Washer (Restricted)
14	91816	Extractor	50	15666	Sear Safety Cam (Restricted)
	15376	Fastener, Sling Strap	51	24476	Sear Pin (Restricted)
16	22020	Firing Pin	52	17047	Sear Spring (Restricted)
17	22040	Firing Pin Assembly	53	30855	Sling Strap Assembly, BDL Grade
18	17022	Firing Pin Cross Pin		26990	Sling Strap Assembly and Mountings Complete
20	15291	Floor Plate Latch, BDL Grade	54	33366	Stock Assembly, ADL Grade
21	16451	Floor Plate Latch Pin, BDL Grade		33371	Stock Assembly, BDL Grade
22	16452	Floor Plate Latch Spring, BDL Grade		18186	Stock Reinforcing Screw (not shown)
23	16463	Floor Plate Pivot Pin, BDL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
24	22035	Front Guard Screw	55	26555	Swivel Assembly, BDL Grade (Q.D.)
25	15161	Front Guard Screw Bushing, ADL Grade	56	15280	Trigger (Restricted)
26	15373	Front Sight	57	17053	Trigger Adjusting Screw (Restricted)
	15719	Front Sight (Low)		26345	Trigger Assembly (Restricted)
27	28510	Front Sight Ramp	58	19461	Trigger Connector (Restricted)
	15635	Front Sight Ramp, BDL Grade	59	91128	Trigger Engagement Screw (Restricted)
28	28505	Front Sight Ramp Screw	60	15281	Trigger Guard
29	15363	Front Sight Hood, BDL Grade	61	26376	Trigger Guard, BDL Grade
30	15357	Front Swivel Nut, BDL Grade		26371	Trigger Guard Assembly, BDL Grade
31	15358	Front Swivel Screw, BDL Grade	62	26655	Trigger Housing Assembly (Restricted)
	90957	Grip Cap, BDL Grade (not shown)	63	24477	Trigger Pin (Restricted)
	25380	Grip Cap Screw	64	15400	Trigger Spring (Restricted)
	90958	Grip Cap Spacer, BDL Grade (not shown)	65	15481	Trigger Stop Screw (Restricted)
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			
	15677	Magazine Spring, BDL Grade			

SECTIONAL
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700



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)

No.	NAME OF PART	Part No.	NAME OF PART
91837	Extractor, 7mm Rem., Mag., 264-300 Win. Mag.	33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem. 22-250 Rem., BDL Grade, 17 Rem.
91906	Extractor, 222-223 Rem., 17 Rem.	33376	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.
22021	Firing Pin, 222 Rem., 234-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	33375	Stock Assembly, Varmint, BDL Grade, 25-06
22041	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308 Win., 6mm Rem., 22-250 Rem. 223 Rem.	26375	Trigger Guard, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem. 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	26370	Trigger Guard Assembly, BDL Grade, 222 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. (includes same as standard Magnum except Stock Bolt (2) Nut (2), Cover (4) used)
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	DISCONTINUED or SERVICE PARTS	
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	26270	Barrel Assembly, 280 Rem.
14756	Magazine, BDL Grade	20467	Extractor, 222 Cal.
10951	Magazine Follower, 222 Rem., 223 & 17 Rem.	17639	Ejector, 222 Cal.
10982	Magazine Follower, 243 & 308 Win., 6mm Rem. 22-250 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag. 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
15742	Magazine Spacer, 222 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
15286	Magazine Spacer, 222 Rem., BDL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
15286	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
11133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.	19025	Front Sight Ramp Screw, 7mm Rem. Mag., 6mm Rem., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
17891	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade	28200	Rear Sight Assembly, Complete (Includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2))
15698	Magazine Spring, 22-250 Rem.	15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag.
15699	Magazine Spring, 22-250 Rem., 6mm Rem. 243 Win., BDL Grade	15850	Extractor, 222-223 Rem., 17 Rem.
17058	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win., 17 Rem.	27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.
18843	Rear Scope Base, Varmint	27342	Extractor Rivet, 222-223 Rem., 17 Rem.
10949	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		
16204	Scope Base Screw, Front Varmint		
13380	Stock Assembly, 7mm Rem. Mag., ADL Grade		
13365	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade		
13385	Stock Assembly, 7mm Rem. Mag., 264 & 300 Win. Mag., BDL Grade		

Deliveries are F.O.B. Union, New York

Parts Subject to Change Without Notice

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.
 2. Lead or change Barrel.
 3. Change Barrel.
 4. Correct bedding.
 5. Tighten or replace.

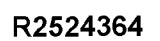
Point of Impact Not Correct

- 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.

9

MODEL
700
LEFT HAND MODEL



REMINGTON
MODEL 700

1963

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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REMINGTON
FIELD SERVICE MANUAL

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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
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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)

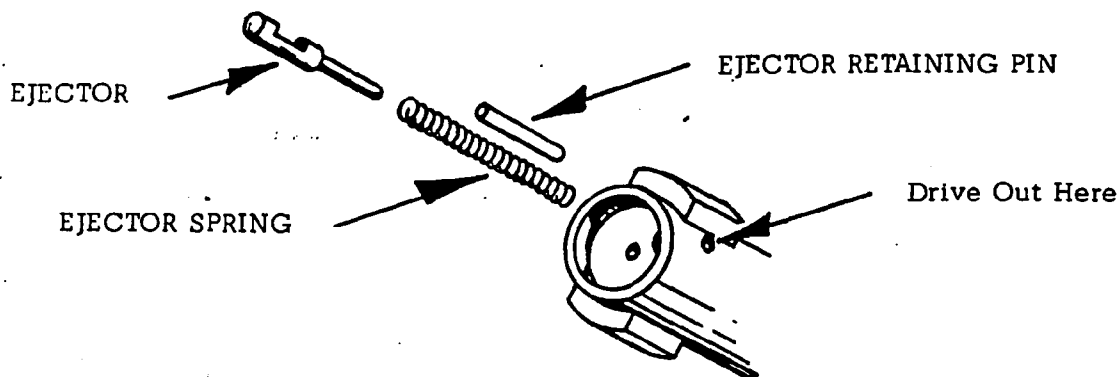
MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

Caution: 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.

To Disassemble - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

Caution: Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

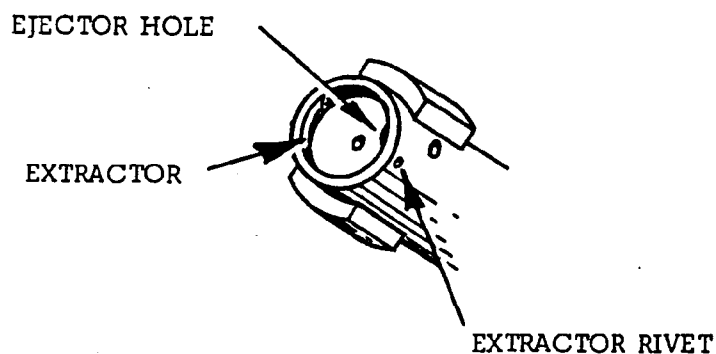


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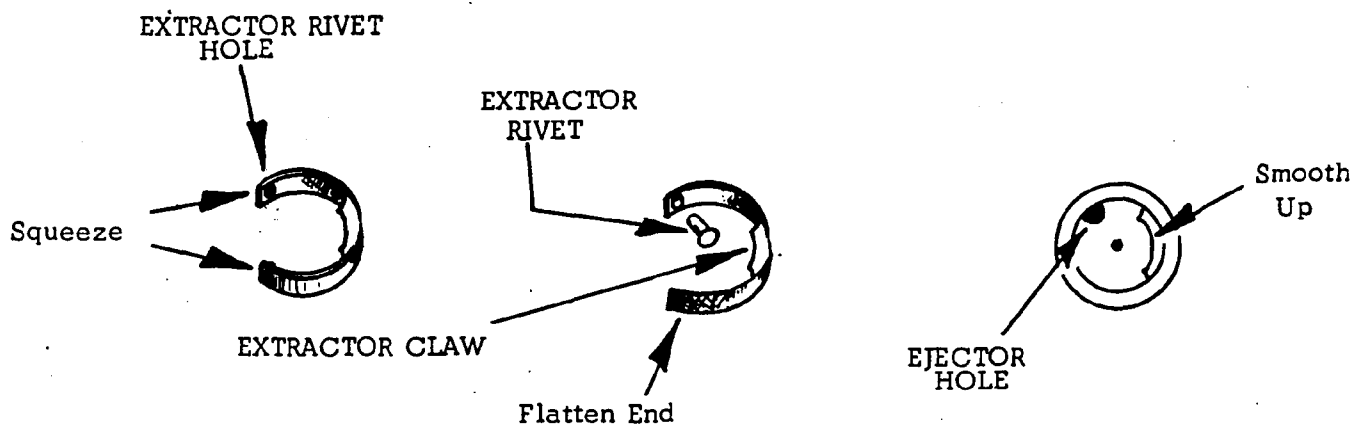
BOLT FINAL ASSEMBLY Continued

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.

To Reassemble - Adjust replacement for proper tension before reassembly 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.

Note: 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)

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)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

To Reassemble - 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

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - 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.

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

To Disassemble - 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)

To Disassemble - Unscrew front sight ramp screw and pry ramp up off ramp pins.

To Replace - Interchangeable - no factory adjustment required.

To Reassemble - 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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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.

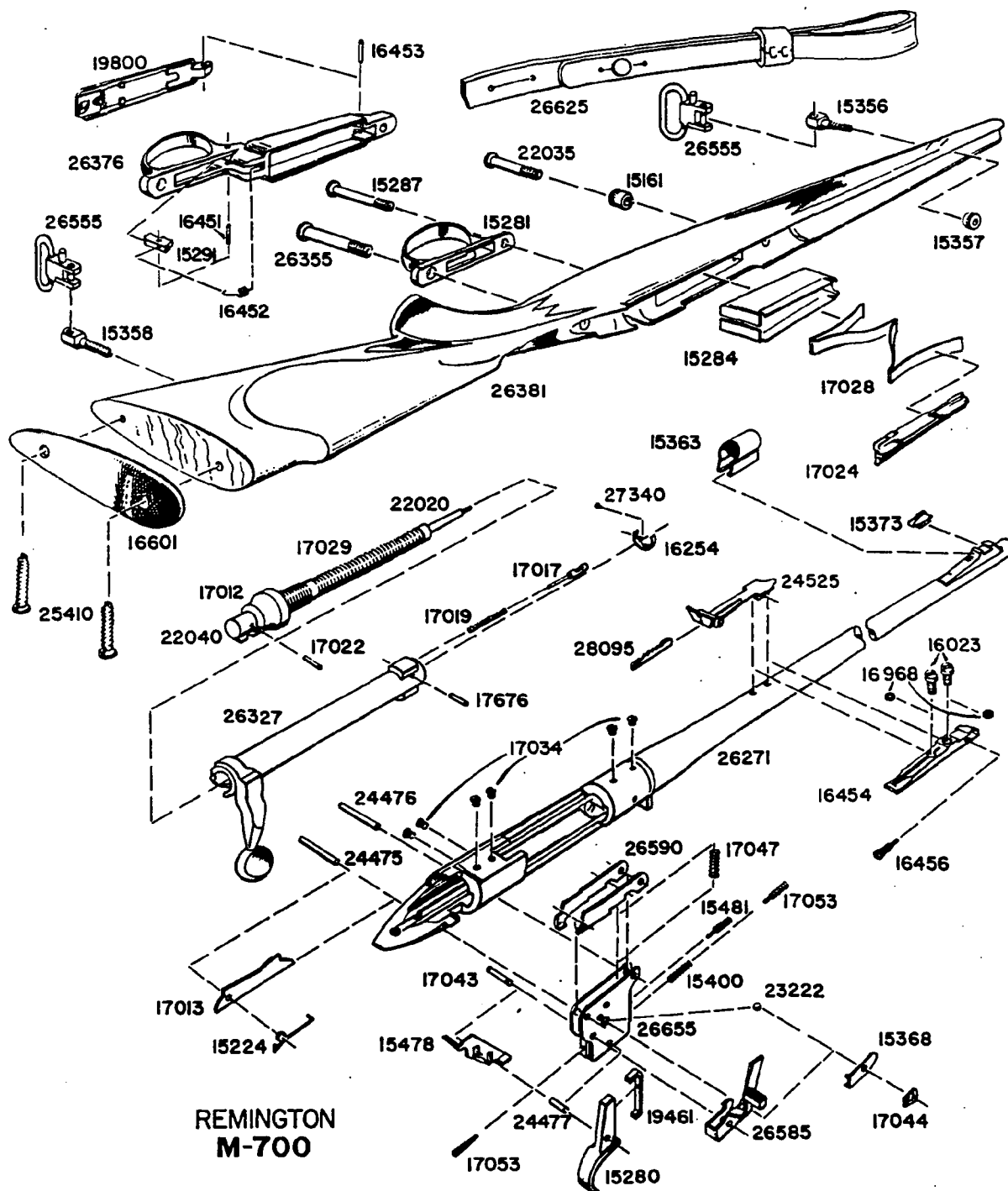
To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

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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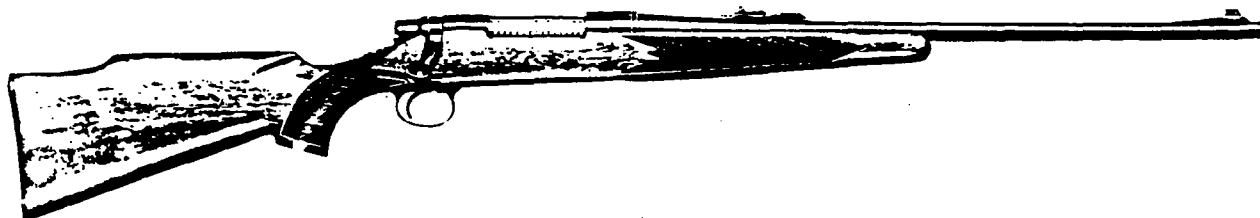
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REMINGTON FIELD SERVICE MANUAL

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 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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1969

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)

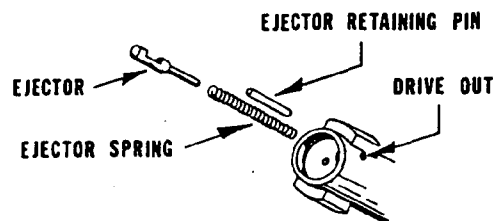


FIG. 1

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.

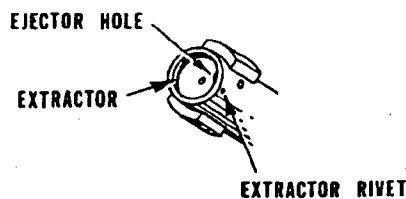


FIG. 2

Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.

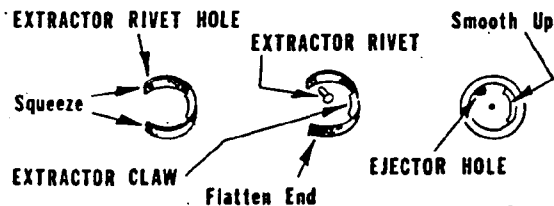


FIG. 3

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.

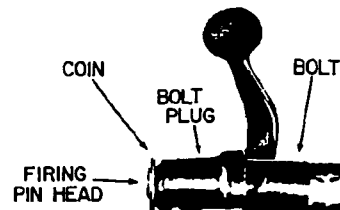
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

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.

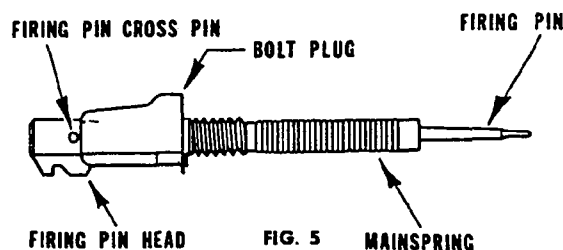
FIG. 4



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 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 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.

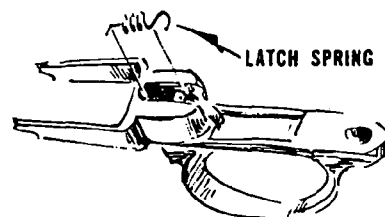


FIG. 6

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.

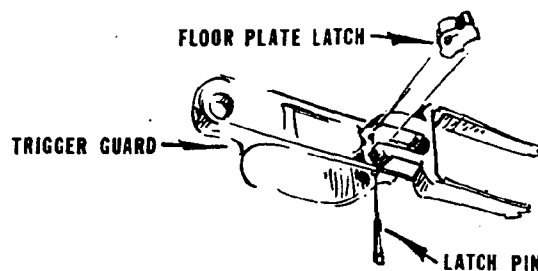


FIG. 7

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

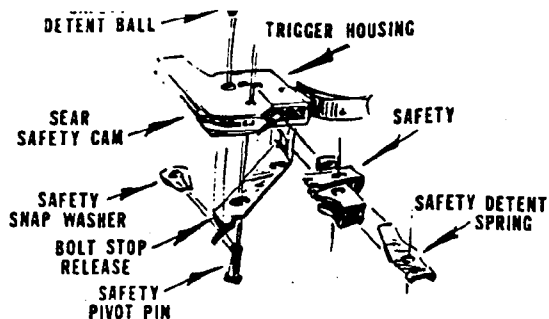


FIG. 8

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

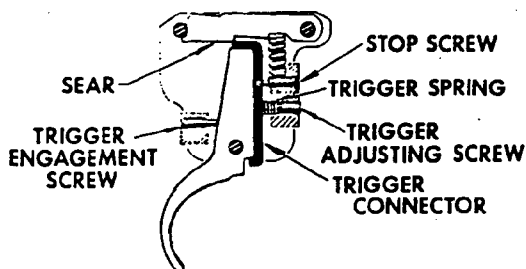


FIG. 9

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 (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 $\frac{3}{8}$ " 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.

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

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.
 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

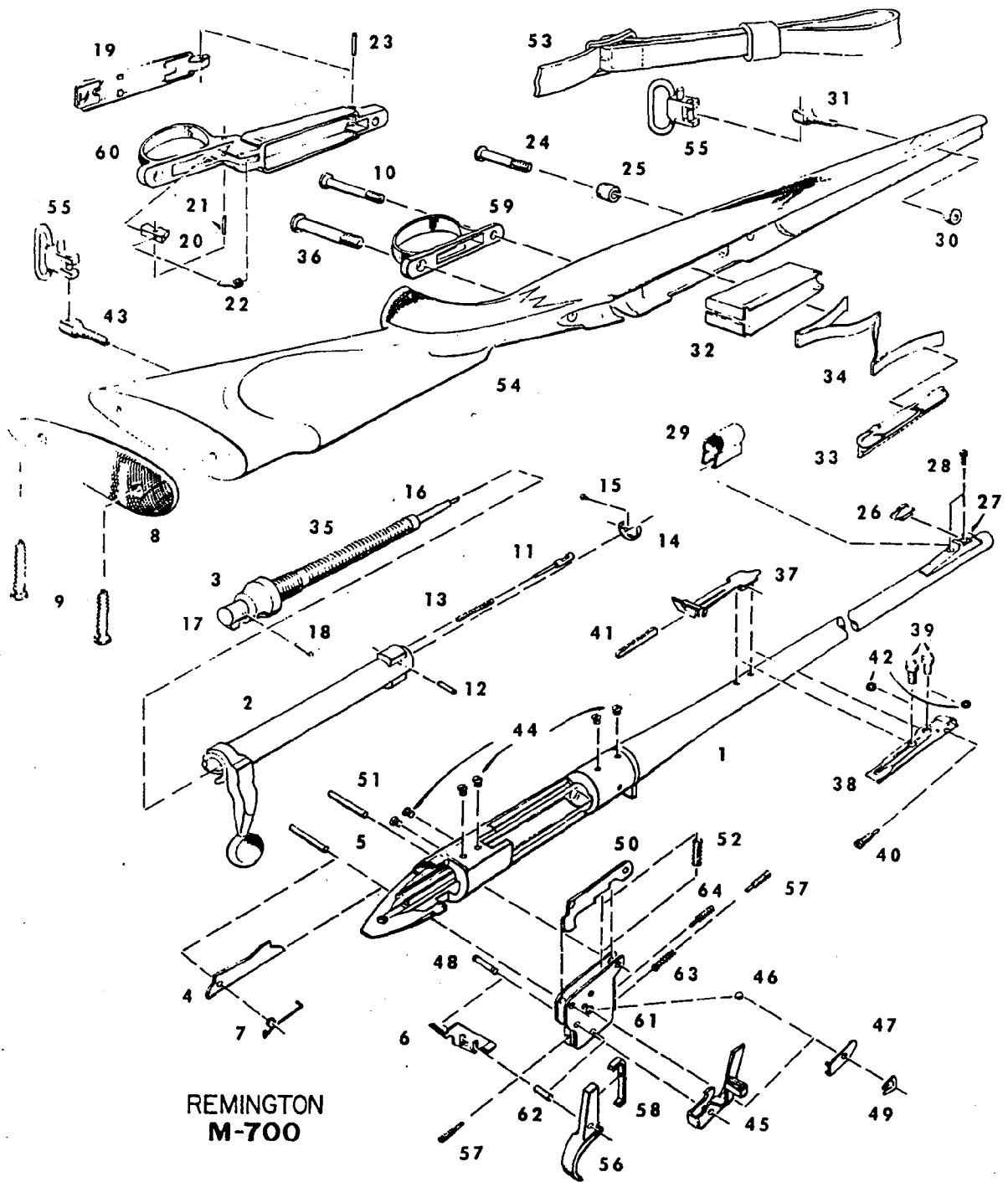
- Cause:**
1. Tight, rough or oversize Chamber.
 2. Extractor broken or damaged.
 3. Not enough Hook space on Extractor.
 4. Height of Claw not correct.
 5. Extractor stuck back.
- Correction:**
1. Ream if tight or rough.
Change Barrel Assembly if oversize.
 2. Fit new Extractor.
 3. Fit new Extractor.
 4. Fit new Extractor.
 5. Replace Extractor.

(Continued on page 8)

Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
RE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.		37	24525	Rear Sight Assembly (includes Rear Sight Collar, Rear Sight 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 Handle)	39	16023	Rear Sight Base Screw
26317	Bolt Final Assembly (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	40	16456	Rear Sight Screw
17012	Bolt Plug	41	28095	Rear Sight Step (Selected Sizes)
17013	Bolt Stop	42	16968	Rear Sight Washer
24475	Bolt Stop Pin	43	15358	Rear Swivel Screw, BDL Grade
15478	Bolt Stop Release	44	17034	Receiver Plug Screw
17014	Bolt Stop Spring	45	26585	Safety Assembly (includes Safety, Safety Button)
14472	Butt Plate	46	23222	Safety Detent Ball
25410	Butt Plate Screw	47	15368	Safety Detent Spring
15287	Center Guard Screw, ADL Grade	48	17043	Safety Pivot Pin
17017	Ejector	49	17044	Safety Snap Washer
17676	Ejector Pin	50	15666	Sear Safety Cam
17019	Ejector Spring	51	24476	Sear Pin
16254	Extractor	52	17047	Sear Spring
27340	Extractor Rivet	53	30855	Sling Strap Assembly, BDL Grade (includes Sling Strap, Fastener, Keeper, Buckle)
15376	Fastener, Sling Strap		26990	Sling Strap Assembly and Mountings Complete (includes Sling Strap Assembly, Swivel Assembly, Q. D. (2), Front Swivel Nut, Front Swivel Screws, Rear Swivel Screw)
22020	Firing Pin	54	26381	Stock Assembly, ADL Grade (includes Butt Plate, Butt Plate Screw (2), Front Guard Screw Bushing, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
22040	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)		26401	Stock Assembly, BDL Grade (includes Butt Plate, Butt Plate Screw (2), Fore-end Tip, Fore-end Tip Spacer, Grip Cap, Grip Cap Spacer, Front Swivel Nut, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel) (not shown)
17022	Firing Pin Cross Pin		18186	Stock Reinforcing Screw (not shown)
19800	Floor Plate, BDL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
15291	Floor Plate Latch, BDL Grade	55	26555	Swivel Assembly, BDL Grade (Q. D.)
16451	Floor Plate Latch Pin, BDL Grade	56	15280	Trigger
16452	Floor Plate Latch Spring, BDL Grade	57	17053	Trigger Adjusting Screw
16453	Floor Plate Pivot Pin, BDL Grade		26345	Trigger Assembly (includes Bolt Stop Release, Trigger Housing Assembly, Safety Assembly, Safety Detent Ball, Safety Detent Spring, Safety Pivot Pin, Safety Snap Washer, Sear and Safety Cam Assembly, Sear Spring, Trigger, Trigger Adjusting Screw, Trigger Connector, Trigger Engagement Screw, Trigger Pin, Trigger Spring, Trigger Stop Screw) (not shown)
22035	Front Guard Screw	57	17053	Trigger Engagement Screw
15161	Front Guard Screw Bushing, ADL Grade	58	19461	Trigger Connector
15373	Front Sight	59	15281	Trigger Guard
15719	Front Sight (Low)	60	26376	Trigger Guard, BDL Grade
28510	Front Sight Ramp		26371	Trigger Guard Assembly, BDL Grade (includes Floor Plate, Floor Plate Latch, Floor Plate Latch Pin, Floor Plate Latch Spring, Floor Plate Pivot Pin, Trigger Guard) (not shown)
15635	Front Sight Ramp, BDL Grade	61	26655	Trigger Housing Assembly (includes Trigger Housing Spacer (3), Trigger Side Plate (2))
28505	Front Sight Ramp Screw	62	24477	Trigger Pin
15363	Front Sight Hood, BDL Grade	63	15400	Trigger Spring
15357	Front Swivel Nut, BDL Grade	64	15481	Trigger Stop Screw
15356	Front Swivel Screw, BDL Grade			
15331	Grip Cap, BDL Grade (not shown)			
15332	Grip Cap Spacer, BDL Grade (not shown)			
15284	Magazine, ADL Grade			
16430	Magazine, BDL Grade (not shown)			
17024	Magazine Follower			
15752	Magazine Follower, BDL Grade			
17028	Magazine Spring			
15677	Magazine Spring, BDL Grade			
17029	Main Spring			
26355	Rear Guard Screw			

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REMINGTON
M-700

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)

No.	NAME OF PART	Part No.	NAME OF PART
72	Barrel Assembly, 7mm Rem. Mag.	17891	Magazine Spring, 243 and 308 Win., 6mm Rem., 6.5mm Rem. Mag., 350 Rem. Mag., ADL Grade
74	Barrel Assembly, 6mm Rem. Mag.	15698	Magazine Spring, 22-250 Rem.
73	Barrel Assembly, 264 Win. Mag.	15699	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade
55	Barrel Assembly, 222 Rem.	17058	Main Spring, 222 Rem., 222 Rem. Mag., 223 Rem., 243 Win., 308 Win., 6.5mm Rem. Mag., 350 Rem. Mag.
56	Barrel Assembly, 222 Rem. Mag.	18843	Rear Scope Base, Varmint
57	Barrel Assembly, 243 Win.	24526	Rear Sight Assembly, 7mm Rem. Mag., 264 Win. Mag.
75	Barrel Assembly, 300 Win. Mag.	21387	Recoil Pad, 7mm Rem. Mag., 264 and 300 Win. Mag.
58	Barrel Assembly, 308 Win.	25410	Recoil Pad Screw, 7mm Rem. Mag., 264 and 300 Win. Mag.
59	Barrel Assembly, 270 Win.	18842	Scope Base Screw, Rear, Varmint
78	Barrel Assembly, 22-250 Rem.	16205	Scope Base Screw Front, Varmint
76	Barrel Assembly, 6.5mm Rem. Mag.	26382	Stock Assembly, 7mm Rem. Mag., 264 Win. Mag., ADL Grade (includes Front Guard Screw Bushing, Recoil Pad, Recoil Pad Screw (2), Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
77	Barrel Assembly, 350 Rem. Mag.	26380	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade
70	Barrel Assembly, Varmint, 222 Rem. (includes Barrel, Barrel Bracket, Receiver)	26415	Stock Assembly, 7mm Rem. Mag., 264-300 Win. Mag., BDL Grade (includes Fore-End, Fore-End Spacer, Grip Cap, Grip Cap Spacer, Recoil Pad, Recoil Pad Screw (2), Front Swivel Nut, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
71	Barrel Assembly, Varmint, 22-250 Rem.	26400	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., BDL Grade
72	Barrel Assembly, Varmint, 223 Rem.	29585	Stock Assembly, Varmint, BDL Grade (includes Butt Plate, Butt Plate Screw (2), Fore-End, Fore-End Spacer, Grip Cap, Grip Cap Spacer, Front Swivel Nut, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
73	Barrel Assembly, Varmint, 6mm Rem.	26402	Stock Assembly, 6.5mm Rem. Mag., 350 Rem. Mag. (includes Fore-End Spacer, Fore-End Tip, Front Swivel Nut, Grip Cap, Grip Cap Spacer, Recoil Pad, Recoil Pad Screw (2), Stock)
74	Barrel Assembly, Varmint, 243 Win.	26375	Trigger Guard, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6mm Rem., 22-250 Rem.
28	Bolt Assembly, 7mm Rem. Mag., 264 and 300 Win. 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)
29	Bolt Assembly, 6.5mm Rem. Mag., 350 Rem. Mag.	CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM	
25	Bolt Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.	27265	Barrel Assembly, 375 H&H Mag.
26	Bolt Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	27266	Barrel Assembly, 458 Win. Mag.
18	Bolt Final Assembly, 7mm Rem. Mag., 264 and 300 Win. Mag. (includes same as 30-06)	15709	Extractor
19	Bolt Final Assembly, 6.5mm Rem. Mag., 350 Rem. Mag.	16771	Front Sight, 375 H&H Mag.
15	Bolt Final Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.	23805	Front Sight, 458 Win. Mag.
16	Bolt Final Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used)
52	Ejector, 222 Rem., 223 Rem., 223 Rem. Mag.	DISCONTINUED or SERVICE PARTS	
39	Extractor, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.	26270	Barrel Assembly, 280 Rem.
50	Extractor, 222 Rem., 223 Rem., 222 Rem. Mag.	20467	Extractor, 222 Cal.
41	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.	17639	Ejector, 222 Cal.
42	Extractor Rivet, 222 Rem., 223 Rem., 222 Rem. Mag.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
21	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.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
11	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 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
34	Floor Plate, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6mm Rem., 22-250 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
37	Front Guard Screw, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 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.
34	Front Scope Base, Varmint	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2))
32	Magazine, ADL Grade, 222 Rem., 222 Rem. Mag.		
16	Magazine, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem.		
43	Magazine, ADL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.		
15	Magazine, BDL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.		
56	Magazine, BDL Grade, 6.5mm Rem. Mag., 350 Rem. Mag.		
75	Magazine Follower, 222 Rem.		
73	Magazine Follower, 222 Rem. Mag.		
56	Magazine Follower, 243 and 308 Win., 6mm Rem., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag.		
15	Magazine Spacer, 222 Rem.		
26	Magazine Spacer, 222 Rem., BDL Grade		
16	Magazine Spacer, 222 Rem. Mag., 223 Rem., BDL Grade		
12	Magazine Spacer, 222 Rem. Mag., ADL Grade		
13	Magazine Spring, 222 Rem., 222 Rem. Mag., 223 Rem.		

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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:**
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.
 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.
 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).
 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.
 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.
 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.

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
Ilion, New York 13357

All other inquiries are to be addressed to

REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

1973

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)

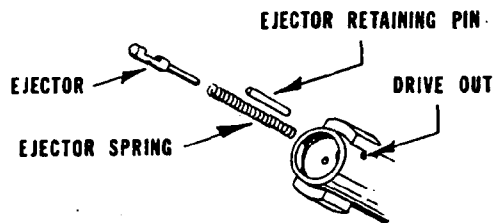


FIG. 1

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.

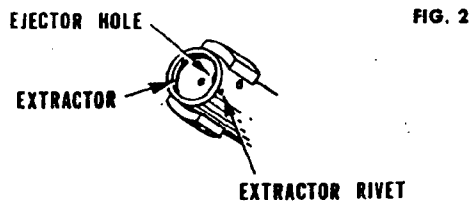


FIG. 2

Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.

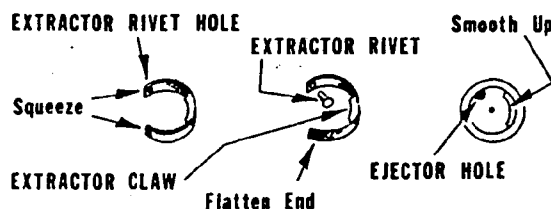


FIG. 3

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.

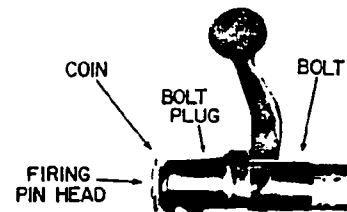
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

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.

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.

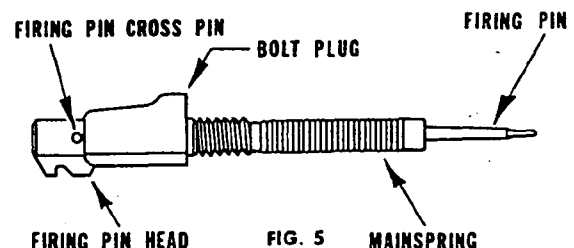


FIG. 5

To Disassemble — (with firing pin assembly removed from bolt).

section. 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

from 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.

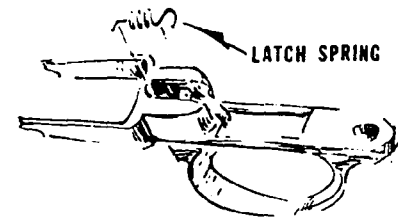


FIG. 6

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.

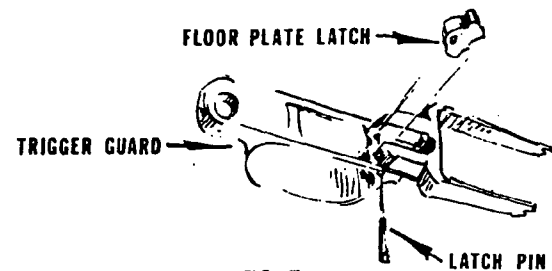


FIG. 7

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

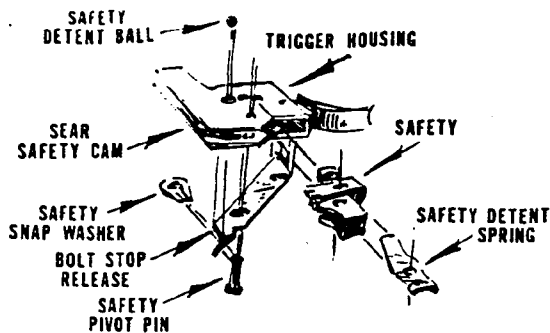


FIG. 8

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

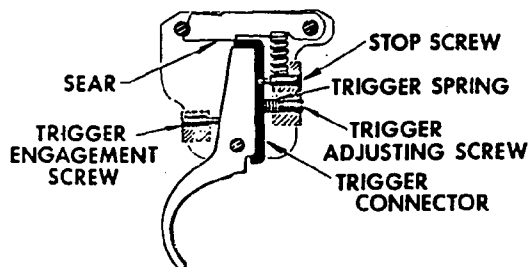


FIG. 9

and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseat 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 (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 $\frac{3}{8}$ " 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.

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 $\frac{1}{4}$ " 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.
 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

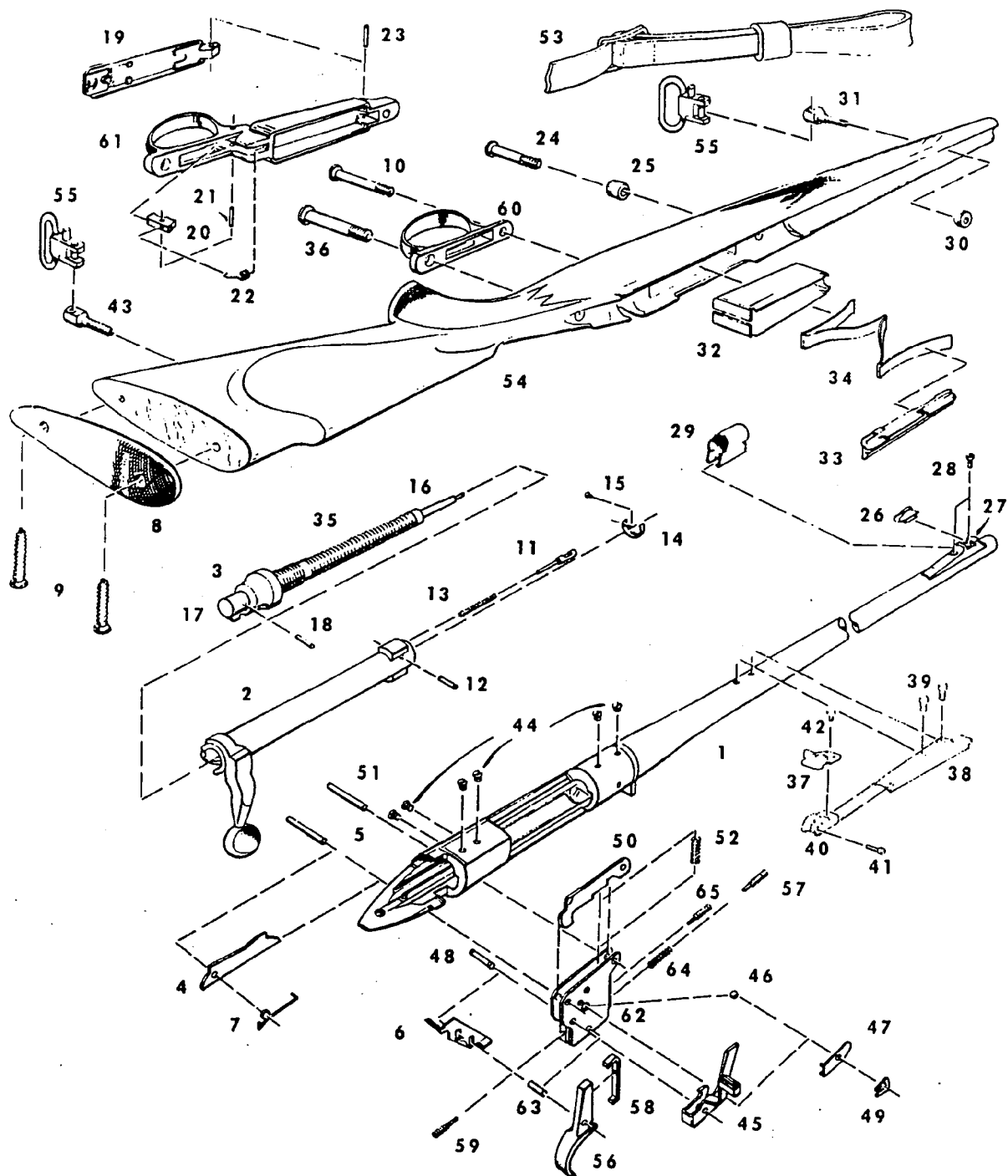
- Cause:**
1. Tight, rough or oversize Chamber.
 2. Extractor broken or damaged.
 3. Not enough Hook space on Extractor.
 4. Height of Claw not correct.
 5. Extractor stuck back.
- Correction:**
1. Ream if tight or rough.
Change Barrel Assembly if oversize.
 2. Fit new Extractor.
 3. Fit new Extractor.
 4. Fit new Extractor.
 5. Replace Extractor.

(Continued on page 8)

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below, See Sectional View for proper identity of parts. See added page for other caliber part listings.					
1		Barrel Assembly	34	15752	Magazine Follower, BDL Grade
2		Bolt Assembly		15940	Magazine Tab Screw (ADL Grade)
		Bolt Final Assembly		17028	Magazine Spring
3	17012	Bolt Plug	35	15677	Magazine Spring, BDL Grade
4	17013	Bolt Stop		17029	Main Spring
5	24475	Bolt Stop Pin	36	26355	Rear Guard Screw
6	15478	Bolt Stop Release	37	32510	Rear Sight Aperture
7	15224	Bolt Stop Spring	38	32500	Rear Sight Base
8	14472	Butt Plate	39	28505	Rear Sight Base Screw (2)
9	25410	Butt Plate Screw	40	90905	Rear Sight Slide
0	15287	Center Guard Screw, ADL Grade	41	90906	Elevation Screw
1	17017	Ejector	42	90904	Windage Screw
2	17676	Ejector Pin	43	15358	Rear Swivel Screw, BDL Grade
3	17019	Ejector Spring	44	17034	Receiver Plug Screw
4	14669	Extractor	45	26585	Safety Assembly
5	27340	Extractor Rivet	46	23222	Safety Detent Ball
	15376	Fastener, Sling Strap	47	15368	Safety Detent Spring
6	22020	Firing Pin	48	17043	Safety Pivot Pin
7	22040	Firing Pin Assembly	49	17044	Safety Snap Washer
8	17022	Firing Pin Cross Pin	50	15666	Sear Safety Cam
9	19800	Floor Plate, BDL Grade	51	24476	Sear Pin
0	15291	Floor Plate Latch, BDL Grade	52	17047	Sear Spring
1	16451	Floor Plate Latch Pin, BDL Grade	53	30855	Sling Strap Assembly, BDL Grade
2	16452	Floor Plate Latch Spring, BDL Grade		26990	Sling Strap Assembly and Mountings Complete
3	16453	Floor Plate Pivot Pin, BDL Grade	54	26381	Stock Assembly, ADL Grade
4	22035	Front Guard Screw		26401	Stock Assembly, BDL Grade
5	15161	Front Guard Screw Bushing, ADL Grade		18186	Stock Reinforcing Screw (not shown)
6	15373	Front Sight	55	16970	Stock Reinforcing Screw Dowel (not shown)
	15719	Front Sight (Low)	56	26555	Swivel Assembly, BDL Grade (Q.D.)
7	28510	Front Sight Ramp	57	15280	Trigger
	15635	Front Sight Ramp, BDL Grade	58	17053	Trigger Adjusting Screw
8	28505	Front Sight Ramp Screw		26345	Trigger Assembly
9	15363	Front Sight Hood, BDL Grade	59	19461	Trigger Connector
0	15357	Front Swivel Nut, BDL Grade	60	17053	Trigger Engagement Screw
1	15356	Front Swivel Screw, BDL Grade	61	15281	Trigger Guard
	15331	Grip Cap, BDL Grade (not shown)		26376	Trigger Guard, BDL Grade
	30505	Grip Cap Spacer, BDL Grade (not shown)		26371	Trigger Guard Assembly, BDL Grade
2	15284	Magazine, ADL Grade	62	26655	Trigger Housing Assembly
	16430	Magazine, BDL Grade (not shown)	63	24477	Trigger Pin
3	17024	Magazine Follower	64	15400	Trigger Spring
			65	15481	Trigger Stop Screw

Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice



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)

Part No.	NAME OF PART	Part No.	NAME OF PART
109	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., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
141	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem., 223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.
142	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.	CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM	
121	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	27265	Barrel Assembly, 375 H&H Mag.
141	Firing Pin Assembly, 222 Rem. 17 Rem. 243 Win., 308 Win., 6mm Rem., 22-250 Rem. 223 Rem.	27266	Barrel Assembly, 458 Win. Mag.
134	Floor Plate, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	15709	Extractor
137	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	16771	Front Sight, 375 H&H Mag.
104	Front Scope Base, Varmint	23805	Front Sight, 458 Win. Mag.
151	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used)
111	Front Sight Ramp, ADL Grade	DISCONTINUED or SERVICE PARTS	
112	Front Sight Ramp, BDL Grade	26270	Barrel Assembly, 280 Rem.
182	Magazine, ADL Grade, 222 Rem.	20467	Extractor, 222 Cal.
116	Magazine, BDL Grade, 222 Rem., 223 Rem., 17 Rem.	17639	Ejector, 222 Cal.
183	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 223 Rem. Mag., 243 Win., ADL Grade
115	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem. 22-250 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 223 Rem. Mag., 243 Win., BDL Grade
156	Magazine, BDL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
118	Magazine Follower, 222 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 223 Rem. Mag., 243 Win.
182	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., 223 Rem. Mag., 243 Win.
185	Magazine Spacer, 222 Rem.	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Step, Rear Sight Washer (2))
126	Magazine Spacer, 222 Rem., BDL Grade		
186	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.		
183	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.		
191	Magazine Spring, 243 & 308 Win., 6mm Rem. ADL Grade		
198	Magazine Spring, 22-250 Rem.		
199	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade		
158	Main Spring, 222 Rem., 223 Rem., 243 Win., 308 Win., 17 Rem.		
143	Rear Scope Base, Varmint		
149	Recoil Pad, 7mm Rem. Mag. 264 & 300 Win. Mag.		
110	Recoil Pad Screw, 7mm Rem. Mag. 264 & 300 Win. Mag.		
142	Scope Base Screw, Rear Varmint		
105	Scope Base Screw, Front Varmint		
180	Stock Assembly, 7mm Rem. Mag., ADL Grade		
165	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade		
185	Stock Assembly, 7mm Rem. Mag. 264-300 Win. Mag., BDL Grade		
170	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., BDL Grade, 17 Rem.		
176	Stock Assembly, Varmint, BDL Grade, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem.		

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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:

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.
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.
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).
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.
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.
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.

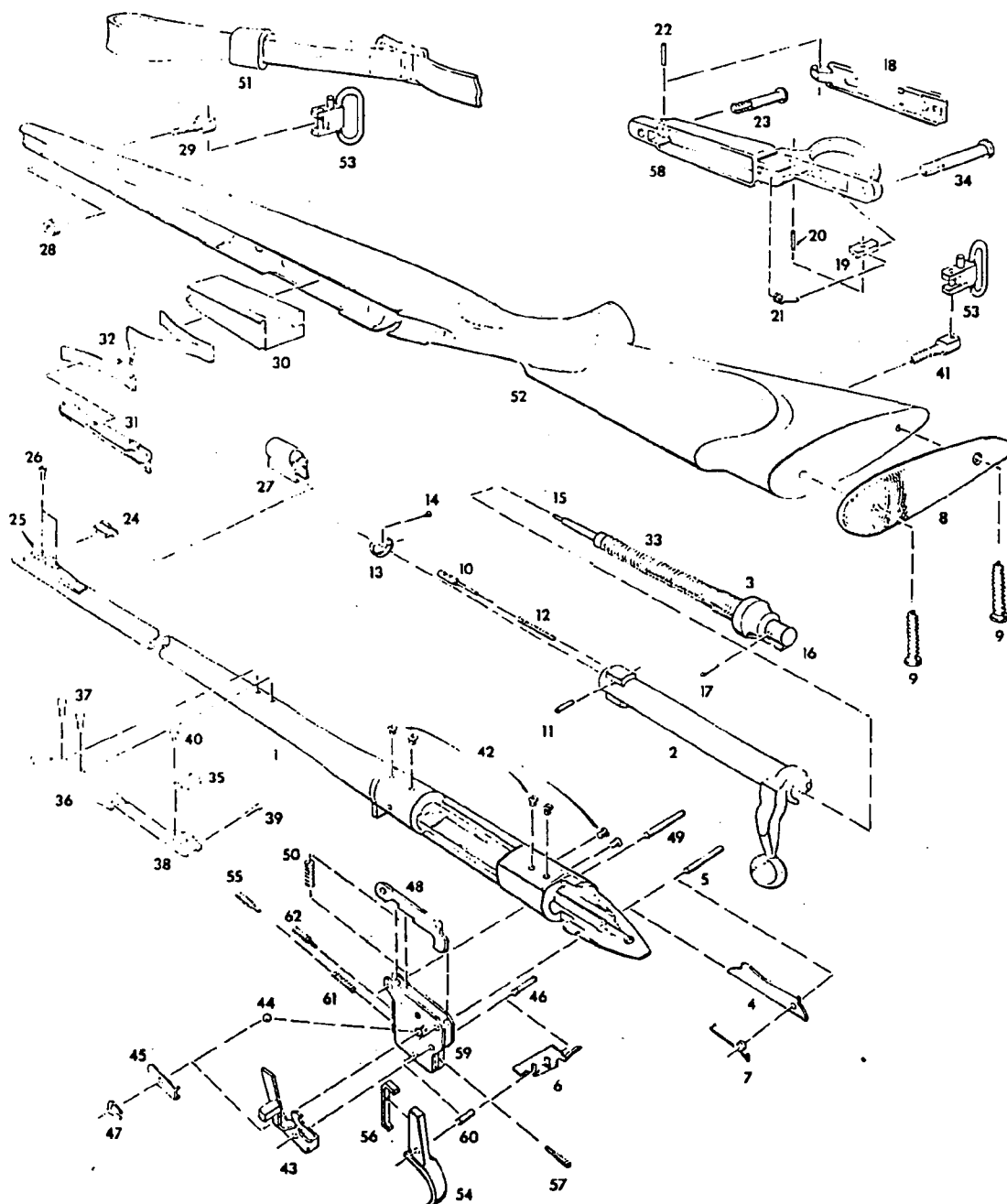
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View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE Basic 30 06 caliber listed below. For other caliber parts and numbers see additional calibers list.			51	30855	Sling Strap Assembly.....
1		Barrel Assembly.....		26990	Sling Strap Assembly and Mountings Complete.....
2		Bolt Assembly.....	52	32890	Stock Assembly.....
		Bolt Final Assembly.....		18186	Stock Reinforcing Screw.....
3	17012	Bolt Plug.....		16970	Stock Reinforcing Screw Dowel.....
4	17013	Bolt Stop.....	53	26555	Swivel Assembly (Q. D.).....
5	24475	Bolt Stop Pin.....	54	15280	Trigger.....
6	90555	Bolt Stop Release.....	55	17053	Trigger Adjusting Screw.....
7	90554	Bolt Stop Spring.....		32895	Trigger Assembly.....
8	14472	Butt Plate.....	56	19461	Trigger Connector.....
9	25410	Butt Plate Screw.....	57	17053	Trigger Engagement Screw.....
10	17017	Ejector.....	58	26376	Trigger Guard.....
11	17676	Ejector Pin.....		26371	Trigger Guard Assembly.....
12	17019	Ejector Spring.....	59	32905	Trigger Housing Assembly.....
13	14669	Extractor.....	60	24477	Trigger Pin.....
14	27340	Extractor Rivet.....	61	15400	Trigger Spring.....
	15376	Fastener, Sling Strap.....	62	15481	Trigger Stop Screw.....
15	27020	Firing Pin.....	ADDITIONAL CALIBERS		
16	27040	Firing Pin Assembly.....	NOTE: Part not listed same as 30-06 Caliber		
17	17072	Firing Pin Cross Pin.....			Barrel Assembly, 7mm Rem. Mag.....
18	19800	Floor Plate.....			Barrel Assembly, 270 Win.....
19	15291	Floor Plate Latch.....	32862		Bolt Assembly, 7mm Rem. Mag.....
20	16451	Floor Plate Latch Pin.....	15709		Extractor, 7mm Rem. Mag.....
21	16452	Floor Plate Latch Spring.....	27341		Extractor Rivet, 7mm Rem. Mag.....
22	16453	Floor Plate Pivot Pin.....	14059		Front Sight, 7mm Rem. Mag.....
23	27035	Front Guard Screw.....	21387		Recoil Pad, 7mm Rem. Mag.....
24	15373	Front Sight.....	25410		Recoil Pad Screw, 7mm Rem. Mag.....
	15719	Front Sight (Low).....	32880		Stock Assembly, 7mm Rem. Mag.....
25	15635	Front Sight Ramp.....			
26	28505	Front Sight Ramp Screw.....			
27	15353	Front Sight Hood.....			
28	15357	Front Swivel Nut.....			
29	15356	Front Swivel Screw.....			
	15331	Grip Cap.....			
	30505	Grip Cap Spacer.....			
30	16430	Magazine.....			
31	15752	Magazine Follower.....			
32	15677	Magazine Spring.....			
33	17029	Main Spring.....			
34	25355	Rear Guard Screw.....			
35	37510	Rear Sight Aperture.....			
36	37500	Rear Sight Base.....			
37	28505	Rear Sight Screw.....			
38	90805	Rear Sight Slide.....			
39	90806	Elevation Screw.....			
40	90804	Windage Screw.....			
41	15358	Rear Swivel Screw.....			
42	17034	Receiver Plug Screw.....			
43	32900	Safety Assembly.....			
44	24272	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.....			

EXPLODED
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700
LEFT HAND MODEL



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.

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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
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Front Sight	#15373	4
Front Sight Hood	#15363	4
Front Sight Ramp	#16717	4
Front Sight Ramp Pin (2)	#24477	4
Front Sight Ramp Screw	#19025	4

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MODEL 700
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Send all guns for factory service and inquiries on
service and parts to

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Arms Service Division
Ilion, New York

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Bridgeport, Connecticut

REMINGTON
FIELD SERVICE MANUAL

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)

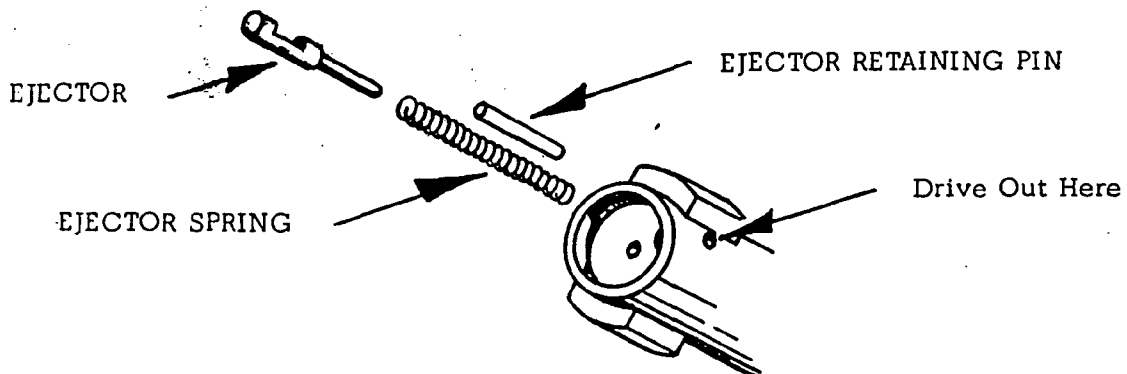
MAGAZINE - is of similar design to the Model 725 and assembled in the same manner.

Caution: 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.

To Disassemble - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

Caution: Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

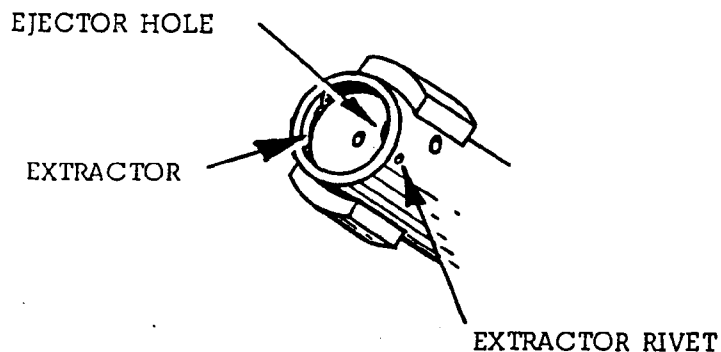


REMINGTON
FIELD SERVICE MANUAL

MODEL 700
Assembly
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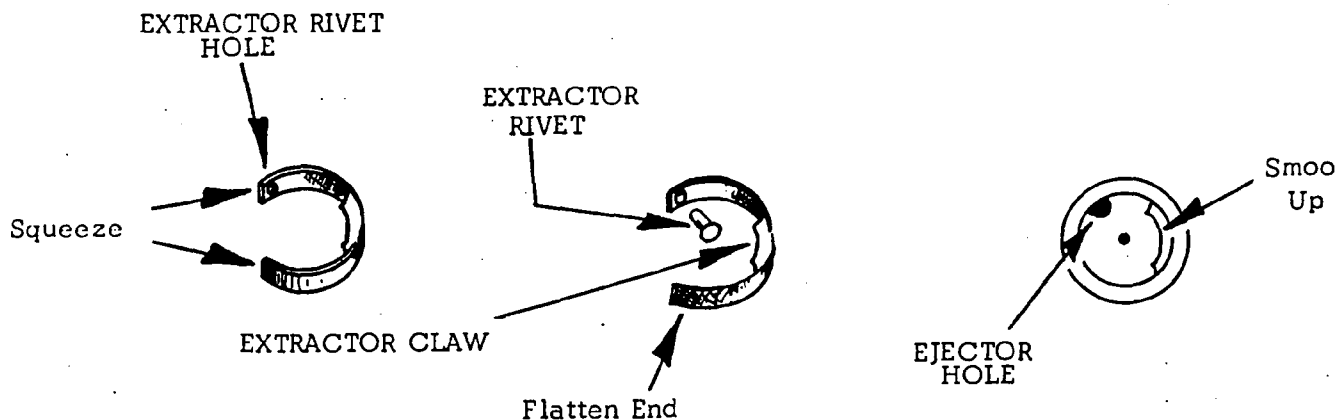
BOLT FINAL ASSEMBLY Continued

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.

To Reassemble - Adjust replacement for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See sketch below)



Straighten tail of extractor. (See sketch above)

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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.

Note: 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)

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)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

To Reassemble - 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

REAR SIGHT ASSEMBLY (See 725 Manual)

FRONT SIGHT COVER (BDL Grade) - 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.

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

To Disassemble - 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)

To Disassemble - Unscrew front sight ramp screw and pry ramp up off ramp pins.

To Replace - Interchangeable - no factory adjustment required.

To Reassemble - 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.

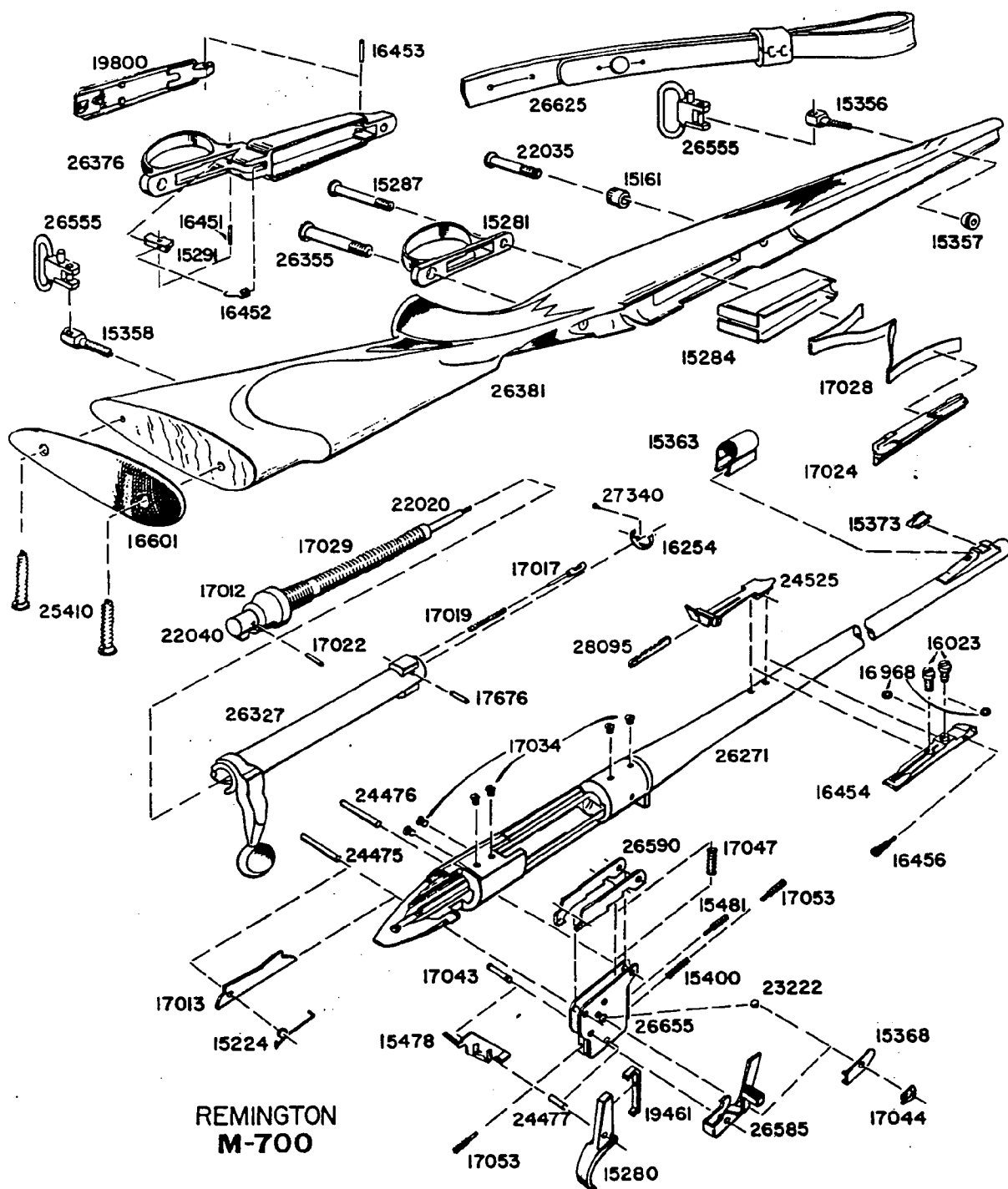
To attach strap to swivels --- insert tongue of strap in rear swivel. Then loop strap back and thru attached rear keeper band. Pull strap to move rear keeper back in tight loop against rear swivel.

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.

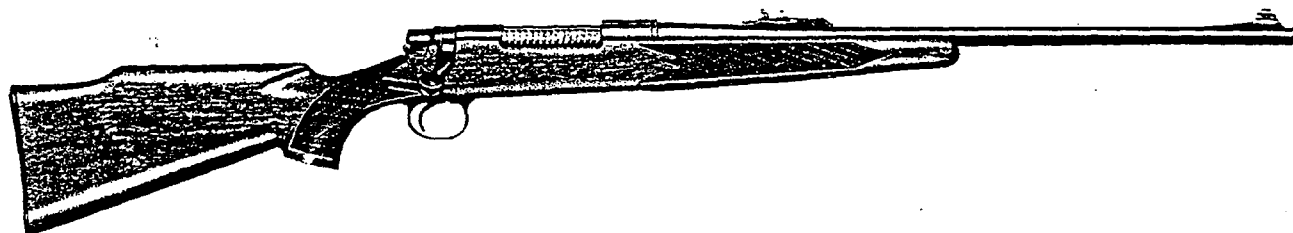
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REMINGTON
FIELD SERVICE MANUAL



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 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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Ilion, New York 13357

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Bridgeport, Connecticut 06602

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.

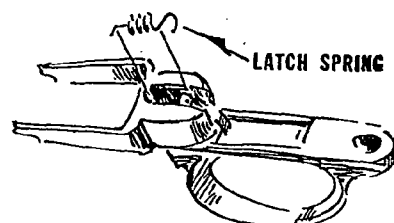


FIG. 6

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)

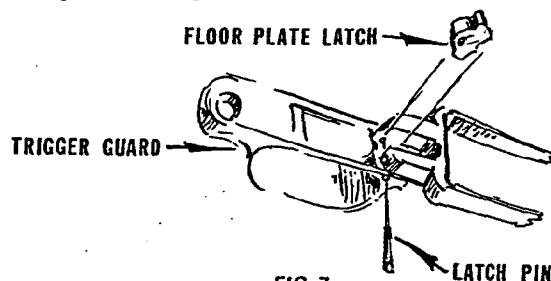


FIG. 7

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 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

- 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

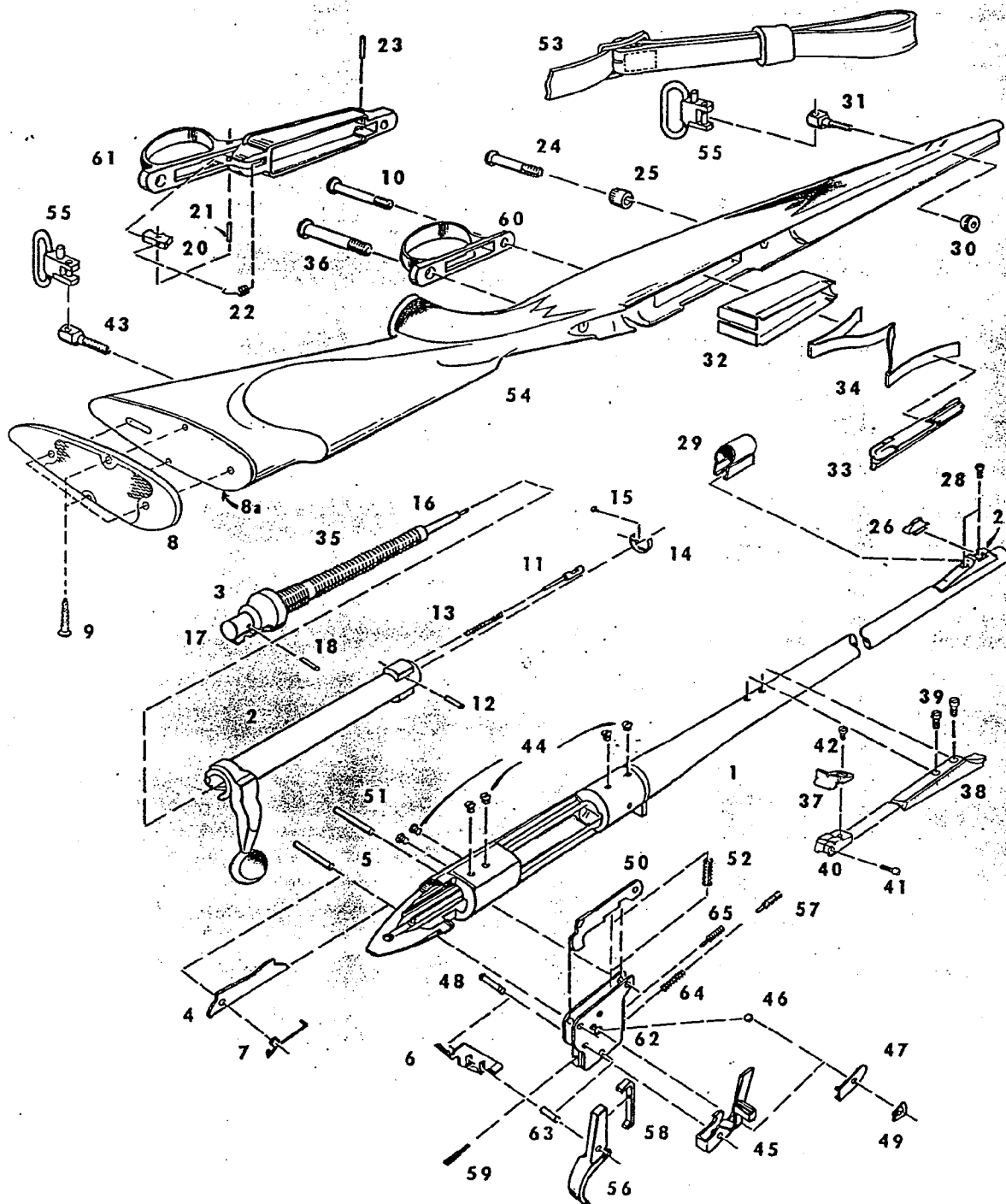
- Cause:**
1. Guard Screws protrude into Bolt track.
 2. Scope Screws protrude into Bolt track.
 3. Bolt Handle interference on Stock.
 4. Step at rear of Bolt Lugs.

- Correction:**
1. File ends of Screws.
 2. File ends of Screws.
 3. Correct Stock or fit new Stock.
 4. File to blend.

SECTIONAL
VIEW

REMINGTON FIELD SERVICE MANUAL

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.
 2. Lead or change Barrel.
 3. Change Barrel.
 4. Correct bedding.
 5. Tighten or replace.

Point of Impact Not Correct

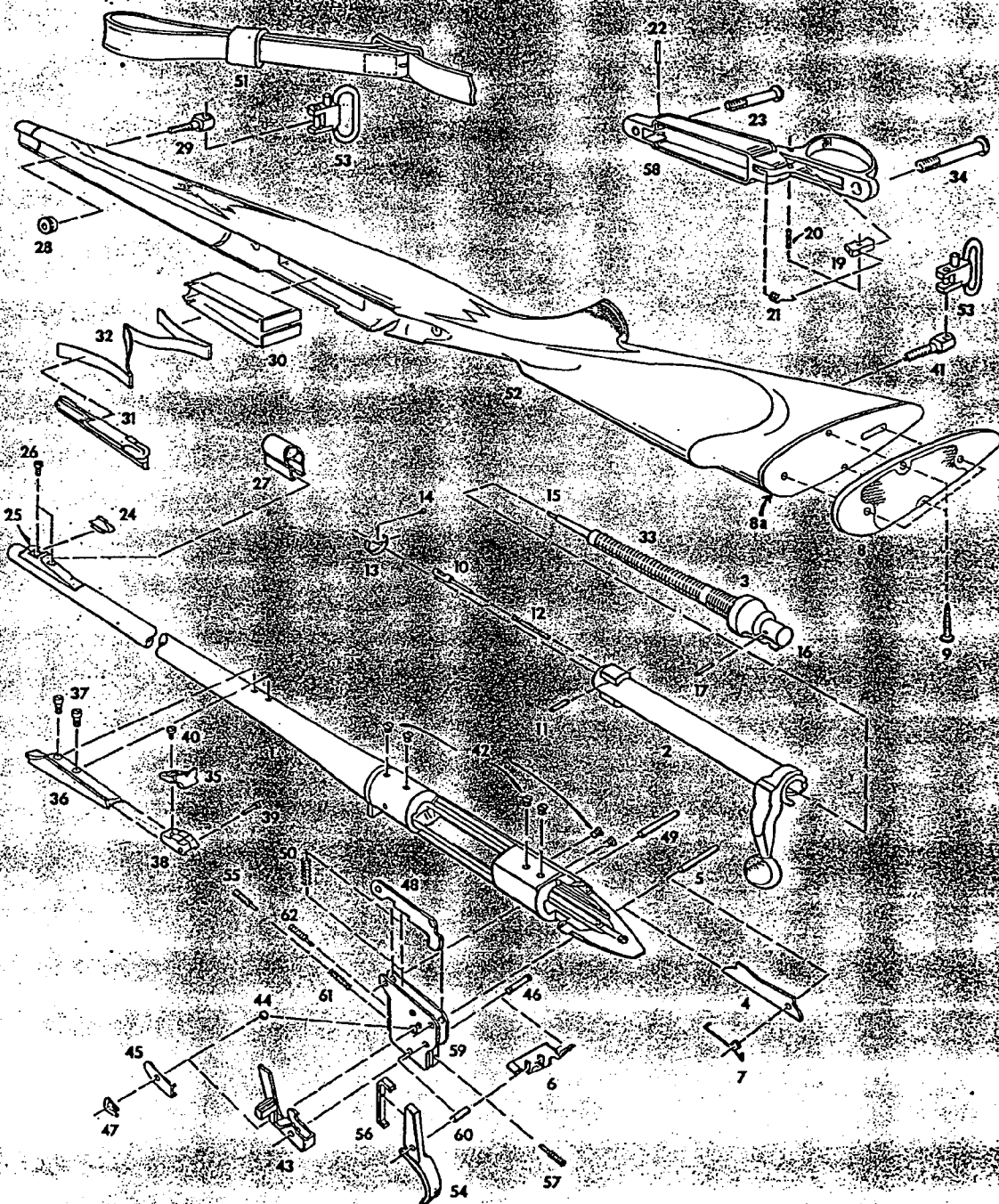
- Cause:**
1. Barrel not straight.
 2. Horns, breaks, etc. in Bore.
 3. Improper or loose Sights.

- Correction:**
1. Straighten.
 2. Correct if possible.
 3. Tighten or change Sights.

EXPLODED
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700
LEFT HAND MODEL



ATTACHMENT "I"

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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FIELD SERVICE MANUAL

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Ejector	#17017	1, 2 & 3
Ejector Pin	#17676	1, 2 & 3
Ejector Spring	#17019	1, 2 & 3
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FIELD SERVICE MANUAL

MODEL 700
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To Reassemble - Follow reverse order.

TRIGGER GUARD ASSEMBLY (BDL GRADE - Hinged Floor Plate)

(See Model 725 Manual)

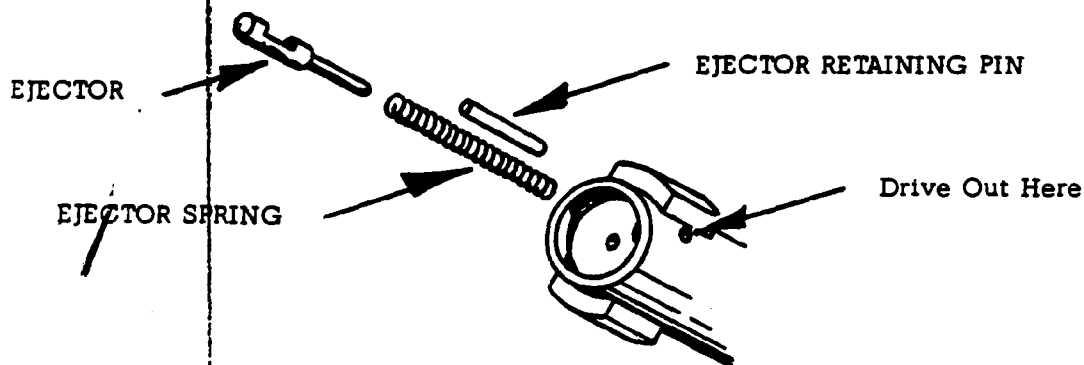
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BOLT FINAL ASSEMBLY - is similar to the Model 725 and assembles in the same manner. The extractor, however, is of a different design and requires a different assembly.

To Disassemble - Disassemble breech bolt from rifle. Drive ejector retaining pin from breech bolt. (See sketch below)

Caution: Hold ejector with forefinger to prevent ejector from springing free of bolt during disassembly.

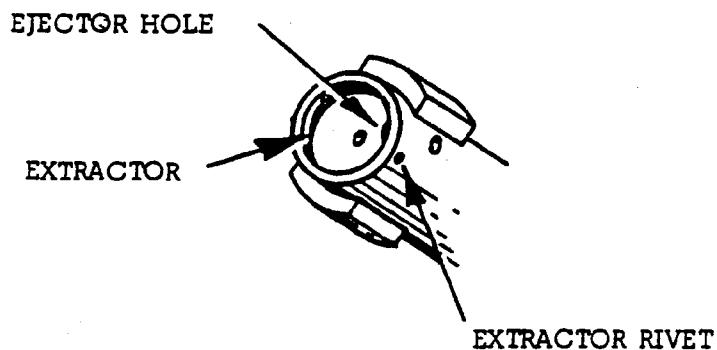


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FIELD SERVICE MANUAL

MODEL 700
Assembly
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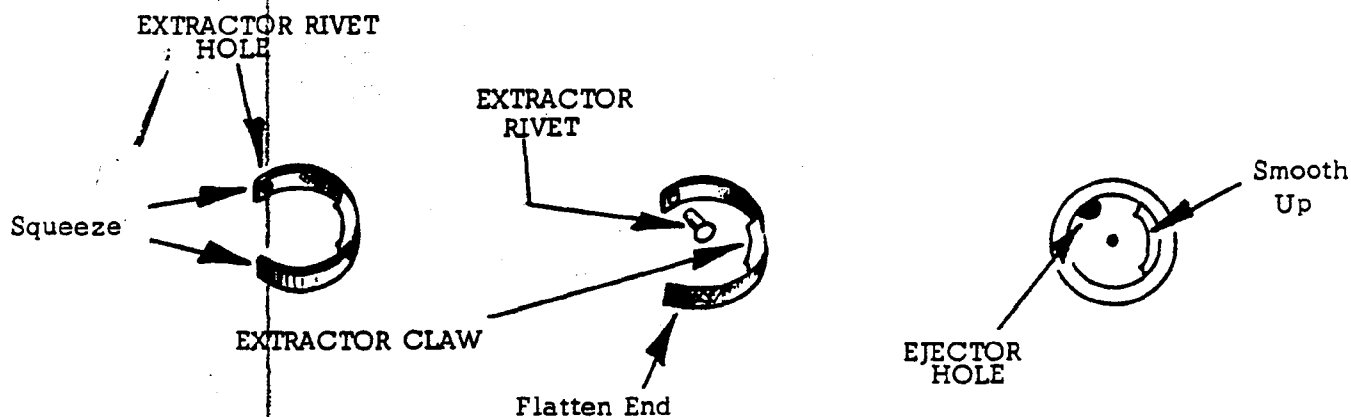
BOLT FINAL ASSEMBLY Continued

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 face of bolt, and disassemble extractor and rivet from bolt.

To Reassemble - Adjust replacement for proper tension before reassembly 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.

Note: 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)

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)

To Disassemble - See Model 725 manual and disassemble in the same manner.

To Replace - Interchangeable with no factory adjustment required.

To Reassemble - 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.

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.

To Disassemble - Spread cover slightly and push forward in cover slots on either side of the ramp.

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

To Disassemble - 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)

To Disassemble - Unscrew front sight ramp screw and pry ramp up off ramp pins.

To Replace - Interchangeable - no factory adjustment required.

To Reassemble - 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.

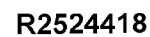
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FIELD SERVICE MANUAL

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.

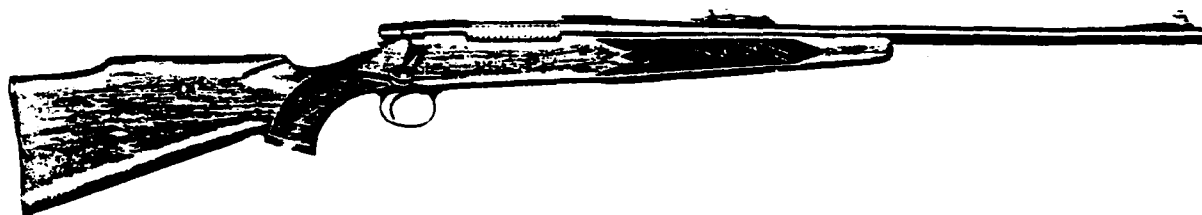
Slide front keeper band on free end of strap. Then insert strap thru front swivel and double strap back and thru attached front keeper. Insert brass fastener thru matching slots to join strap in desired position.

To remove strap from rifle, simply snap quick detachable swivels from stock screws and remove strap.



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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

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)

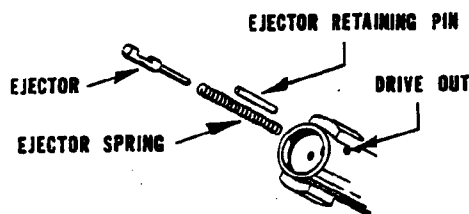


FIG. 1

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.

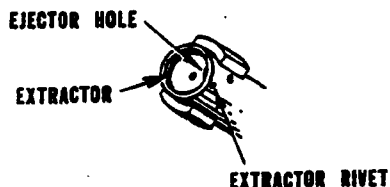


FIG. 2

Drive extractor rivet from bolt. (See Fig. 2). Dislodge and remove loosened extractor from inside bolt rim.

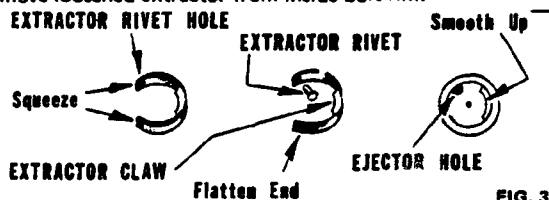


FIG. 3

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.

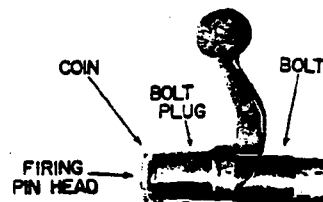
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. (See Fig. 3).

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.

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.

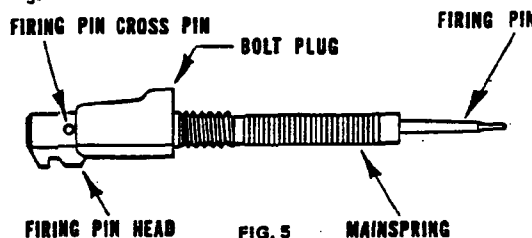


FIG. 5

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.

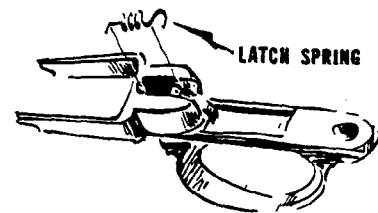


FIG. 6

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)

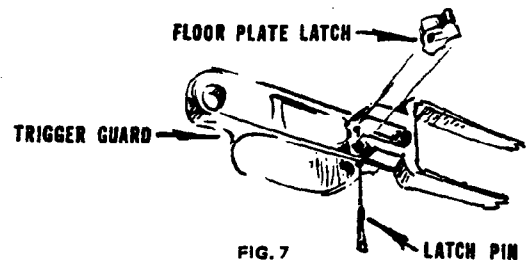


FIG. 7

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.

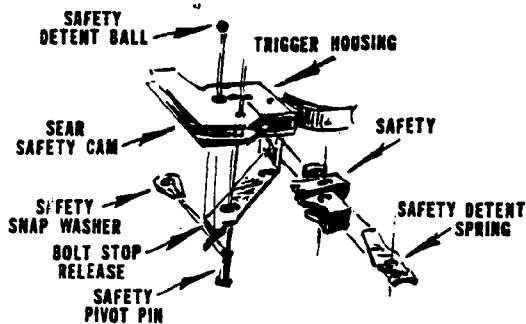


FIG. 8

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

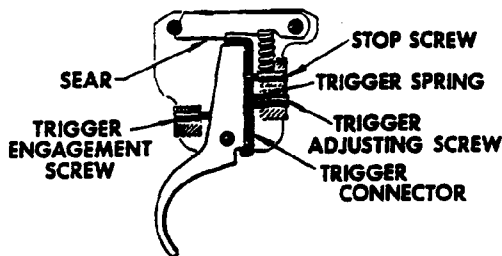


FIG. 9

and 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.

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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 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:**
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.

**MODEL
700**

**REMINGTON
FIELD SERVICE MANUAL**

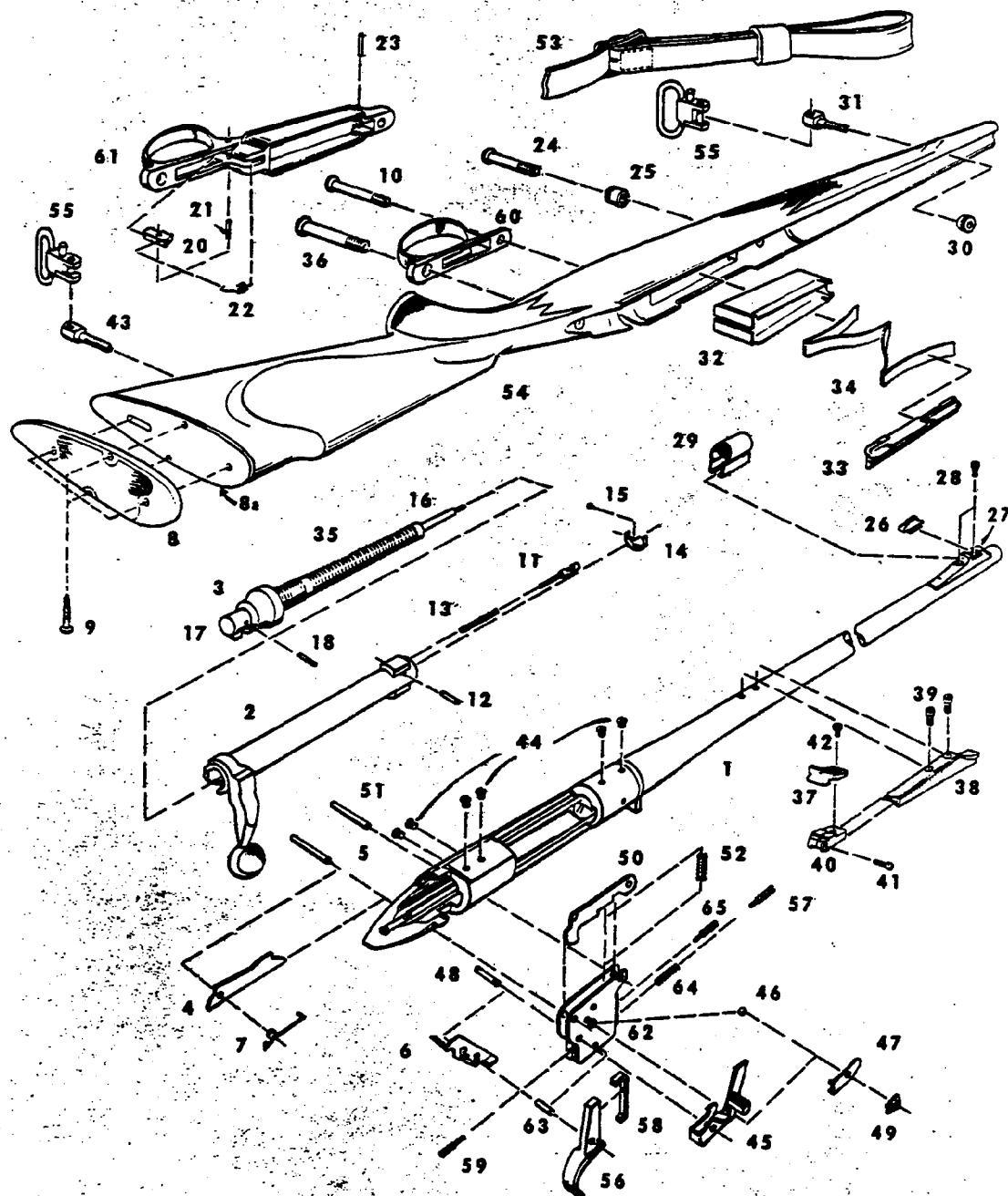
PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.			91017		Magazine Follower, BDL Grade
1		Barrel Assembly	15940		Magazine Tab Screw, ADL Grade
2		Bolt Assembly	34	17028	Magazine Spring
		Bolt Final Assembly		15677	Magazine Spring, BDL Grade
3	17012	Bolt Plug	35	17029	Main Spring
4	17013	Bolt Stop	36	26355	Rear Guard Screw
5	24475	Bolt Stop Pin	37	32510	Rear Sight Aperture
6	15478	Bolt Stop Release	38	32500	Rear Sight Base
7	15224	Bolt Stop Spring	39	28505	Rear Sight Base Screw (2)
8	90953	Butt Plate	40	90905	Rear Sight Slide
8a	90954	Butt Plate Spacer, BDL	41	90906	Elevation Screw
9	25380	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 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
20	15291	Floor Plate Latch, BDL Grade	53	30855	Sling Strap Assembly, BDL Grade
21	16451	Floor Plate Latch Pin, BDL Grade		26990	Sling Strap Assembly and Mountings Complete
22	16452	Floor Plate Latch Spring, BDL Grade	54	33366	Stock Assembly, ADL Grade
23	16453	Floor Plate Pivot Pin, BDL Grade		33371	Stock Assembly, BDL Grade
24	22035	Front Guard Screw		18186	Stock Reinforcing Screw (not shown)
25	15161	Front Guard Screw Bushing, ADL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
26	15373	Front Sight	55	26555	Swivel Assembly, BDL Grade (Q.D.)
	15719	Front Sight (Low)	56	15280	Trigger
27	28510	Front Sight Ramp	57	17053	Trigger Adjusting Screw
	15635	Front Sight Ramp, BDL Grade		26345	Trigger Assembly
28	28505	Front Sight Ramp Screw	58	19461	Trigger Connector
29	15363	Front Sight Hood, BDL Grade	59	91128	Trigger Engagement Screw
30	15357	Front Swivel Nut, BDL Grade	60	15281	Trigger Guard
31	15356	Front Swivel Screw, BDL Grade	61	26376	Trigger Guard, BDL Grade
	90957	Grip Cap, BDL Grade (not shown)		26371	Trigger Guard Assembly, BDL Grade
	25380	Grip Cap Screw	62	26655	Trigger Housing Assembly
	90958	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	90952	Magazine Follower			

SECTIONAL
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700



**MODEL
700**

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:

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.
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.
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).
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.
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.
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.

**MODEL
700
LEFT HAND MODEL**

**REMINGTON
FIELD SERVICE MANUAL**

PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 caliber listed below. For other caliber parts and numbers see additional calibers list.			41	15358	Rear Swivel Screw
1		Barrel Assembly	42	17034	Receiver Plug Screw
2		Bolt Assembly	43	32900	Safety Assembly
		Bolt Final Assembly	44	23222	Safety Detent Ball
3	17012	Bolt Plug	45	90557	Safety Detent Spring
4	17013	Bolt Stop	46	17043	Safety Pivot Pin
5	24475	Bolt Stop Pin	47	17044	Safety Snap Washer
6	90555	Bolt Stop Release	48	15666	Sear Safety Cam
7	90554	Bolt Stop Spring	49	24476	Sear Pin
8	90953	Butt Plate	50	17047	Sear Spring
8a	90954	Butt Plate Spacer	51	30855	Sling Strap Assembly
9	25380	Butt Plate Screw		26990	Sling Strap Assembly and Mountings Complete
10	17017	Ejector	52	33391	Stock Assembly
11	17676	Ejector Pin		18186	Stock Reinforcing Screw
12	17019	Ejector Spring		18970	Stock Reinforcing Screw Dowel
13	14669	Extractor	53	26555	Swivel Assembly (Q.D.)
14	27340	Extractor Rivet	54	15280	Trigger
	15376	Fastener, Sling Strap	55	17053	Trigger Adjusting Screw
15	22020	Firing Pin		32895	Trigger Assembly
16	22040	Firing Pin Assembly	56	19461	Trigger Connector
17	17022	Firing Pin Cross Pin	57	91128	Trigger Engagement Screw
19	15291	Floor Plate Latch	58	26376	Trigger Guard
20	16451	Floor Plate Latch Pin		26371	Trigger Guard Assembly
21	16452	Floor Plate Latch Spring	59	32905	Trigger Housing Assembly
22	16453	Floor Plate Pivot Pin	60	24477	Trigger Pin
23	22035	Front Guard Screw	61	15400	Trigger Spring
24	15373	Front Sight	62	15481	Trigger Stop Screw
	15719	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			
	90957	Grip Cap			
	90958	Grip Cap Spacer			
	25380	Grip Cap Spacer Screw			
30	16430	Magazine			
31	91017	Magazine Follower			
32	15677	Magazine Spring			
33	17029	Main Spring			
34	26355	Rear Guard Screw			
35	23510	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			

ADDITIONAL CALIBERS

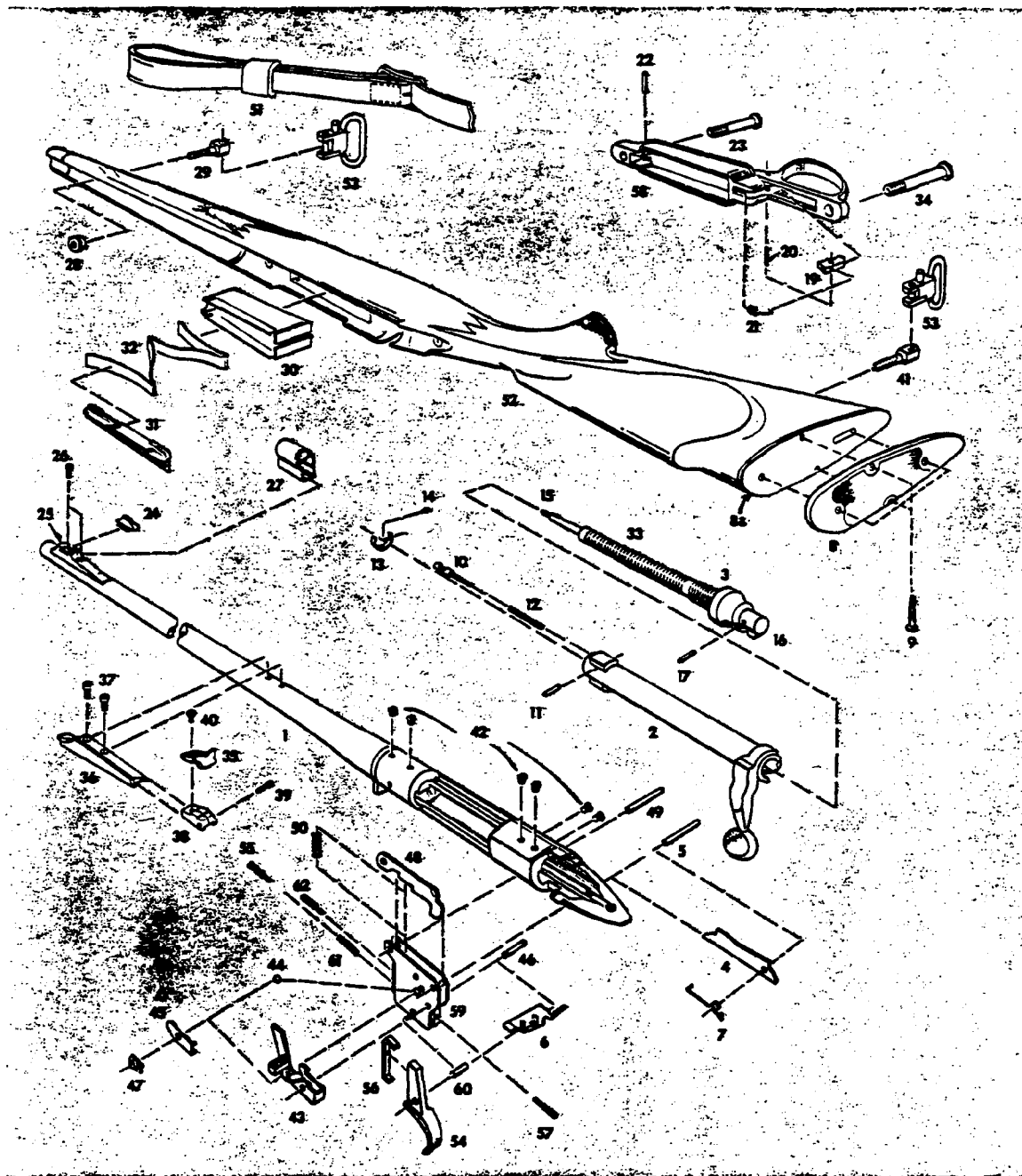
NOTE: Part not listed same as 30-06 Caliber

Barrel Assembly, 7mm Rem. Mag. _____
 Barrel Assembly, 270 Win. _____
 Bolt Assembly, 7mm Rem. Mag. _____
 15709 Extractor, 7mm Rem. Mag. _____
 27341 Extractor Rivet, 7mm Rem. Mag. _____
 14659 Front Sight, 7mm Rem. Mag. _____
 90949 Recoil Pad, 7mm Rem. Mag. _____
 25410 Recoil Pad Screw, 7mm Rem. Mag. _____
 33395 Stock Assembly, 7mm Rem. Mag. _____

EXPLODED
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700
LEFT HAND MODEL



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.

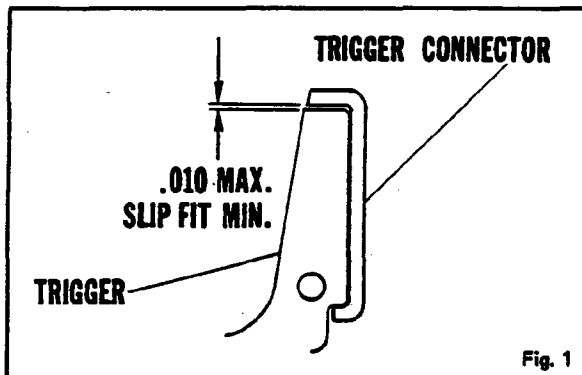


Fig. 1

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).

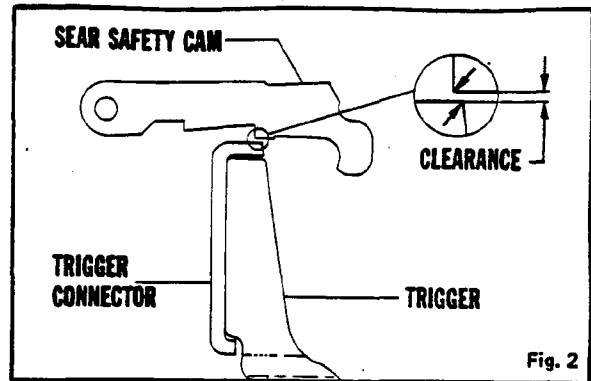


Fig. 2

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).

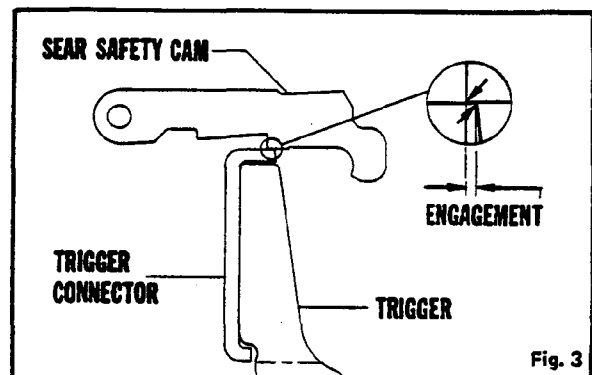


Fig. 3

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

1. **"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.

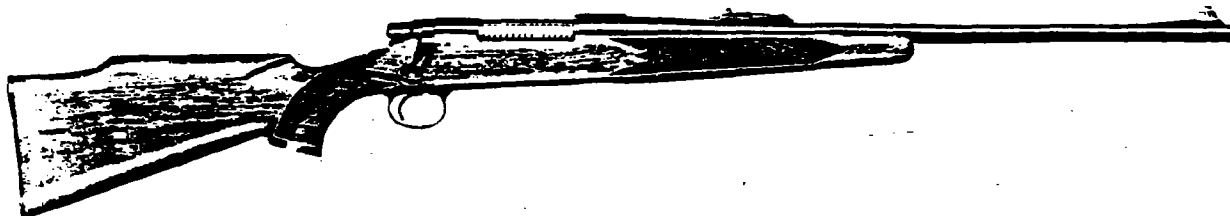
This malfunction may also be caused by improper sear safety cam — trigger connector engagement. Adjust engagement as previously described. (see note B).
3. **"Firing Pin Fails to Fall."** If firing pin fails to fall when trigger is pulled or trigger has to be pulled more than once. See firing pin falls 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.

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
Illion, 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)

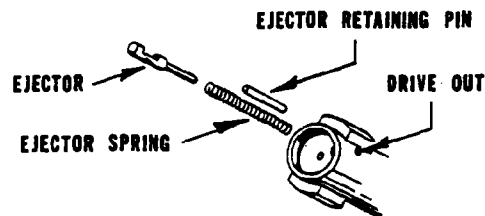


FIG. 1

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.

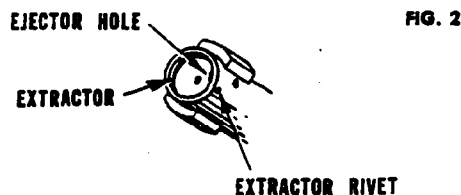


FIG. 2

Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.

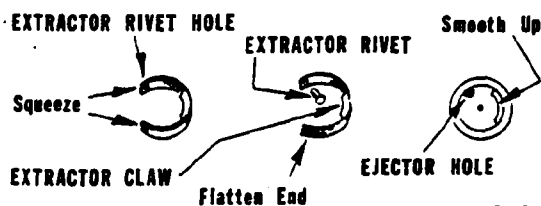


FIG. 3

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.

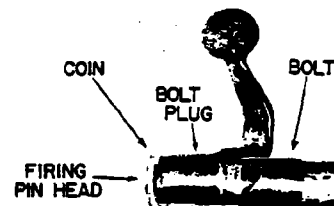
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

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.

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.

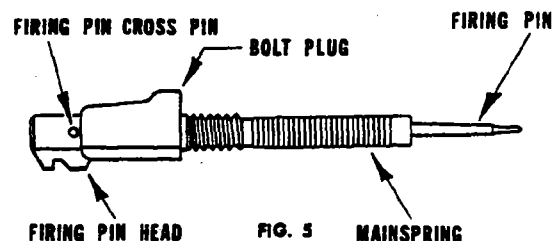


FIG. 5

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 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 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.

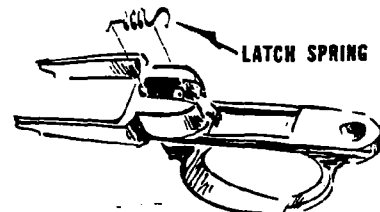


FIG. 6

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.

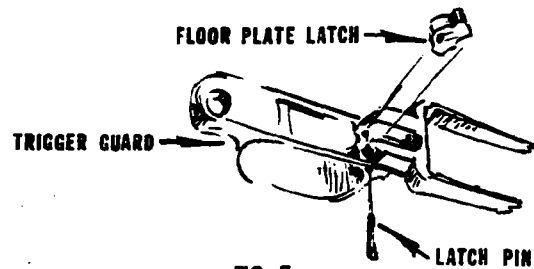


FIG. 7

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

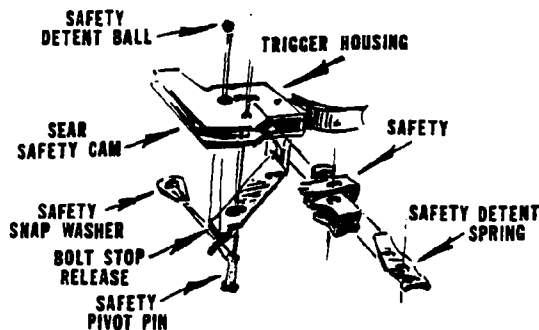


FIG. 8

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

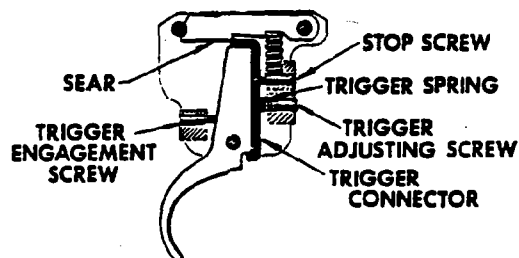


FIG. 9

and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseat 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 (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 3/8" 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.

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 $\frac{1}{8}$ " 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.
 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.

(Continued on page 8)

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FIELD SERVICE MANUAL**

PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below, See Sectional View for proper identity of parts. See added page for other caliber part listings.				15752	Magazine Follower, BDL Grade
				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 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		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			

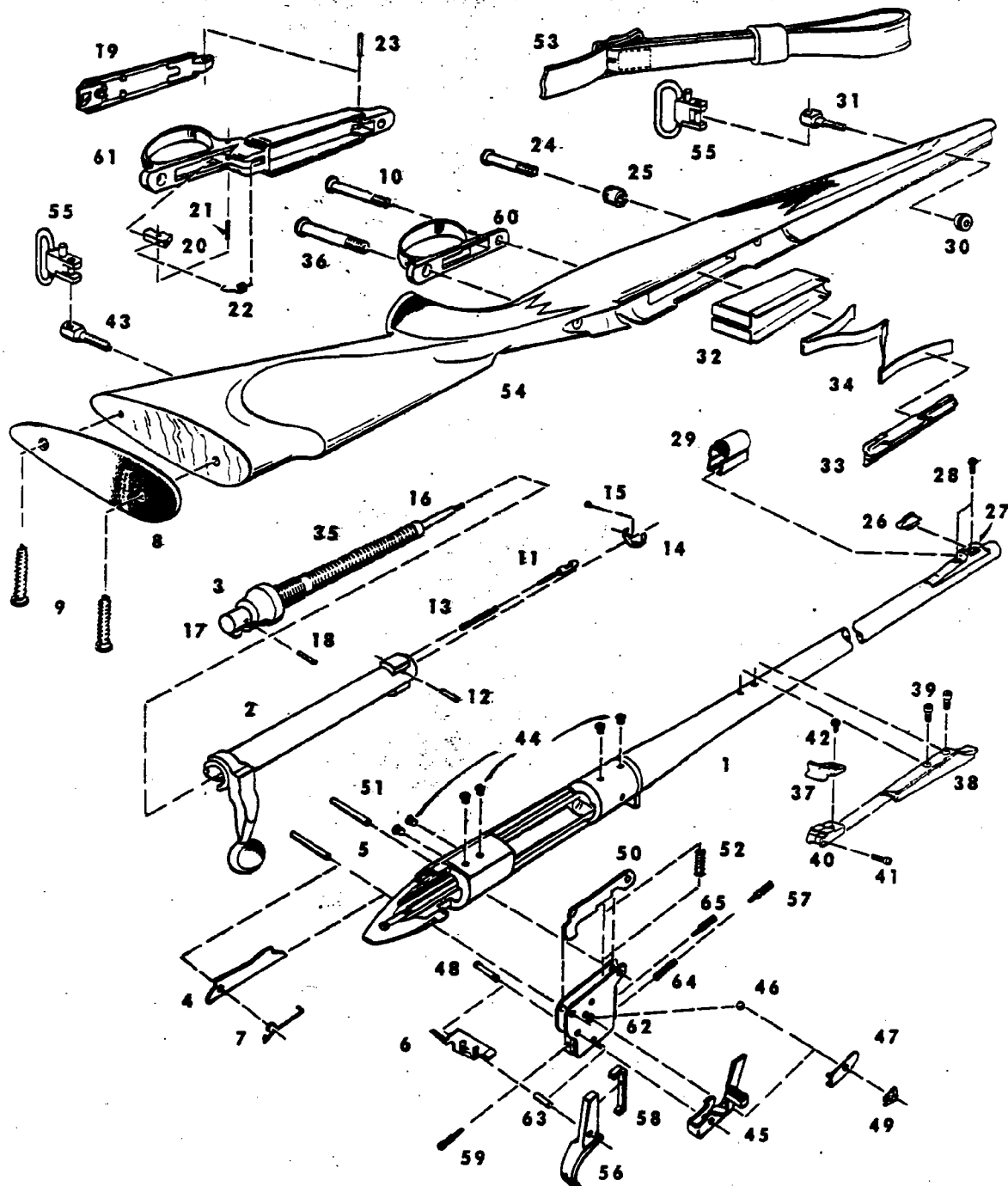
Deliveries are F.O.B. Ilion, New York

Parts Subject to Change Without Notice

SECTIONAL
VIEW

REMINGTON
FIELD SERVICE MANUAL

MODEL
700



ADDITIONAL CALIBERS
(Not Shown in Sectional View)
INCLUDES VARMINT MODEL

REMINGTON
FIELD SERVICE MANUAL

MODEL
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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., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag.	26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem., 223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.
27342	Extractor Rivet, 222 Rem., 223 Rem., 17 Rem.	CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM	
22021	Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.	27265	Barrel Assembly, 375 H&H Mag.
22041	Firing Pin Assembly, 222 Rem., 17 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 223 Rem.	27266	Barrel Assembly, 458 Win. Mag.
16434	Floor Plate, BDL Grade, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	15709	Extractor
22037	Front Guard Screw, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.	16771	Front Sight, 375 H&H Mag.
16204	Front Scope Base, Varmint	23805	Front Sight, 458 Win. Mag.
14659	Front Sight, 7mm Rem. Mag., 264 Win. Mag.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as 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., 17 Rem.	17639	Ejector, 222 Cal.
15283	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem., 22-250 Rem.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
16715	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem., 22-250 Rem.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
14756	Magazine, BDL Grade	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
91018	Magazine Follower, 222 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 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 Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Stop, Rear Sight Washer (2))
16826	Magazine Spacer, 222 Rem., BDL Grade		
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.		
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.		
25410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag.		
18842	Scope Base Screw, Rear Varmint		
16205	Scope Base Screw, Front Varmint		
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		
33370	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:

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:

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.
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.
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).
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.
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.
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.

**MODEL
700
LEFT HAND MODEL**

**REMINGTON
FIELD SERVICE MANUAL**

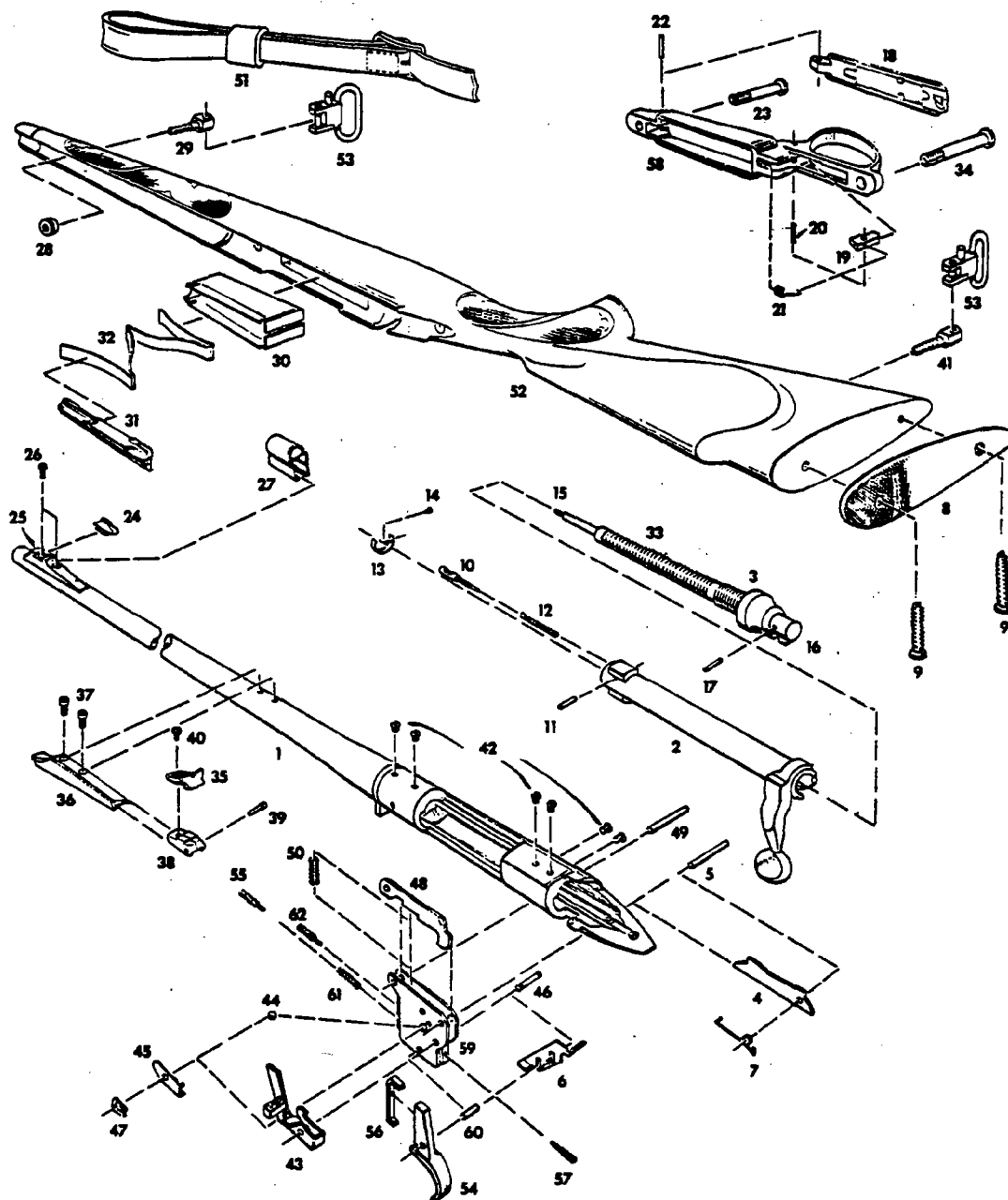
PARTS LIST

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 caliber listed below. For other caliber parts and numbers see additional calibers list.			51	30855	Sling Strap Assembly
1		Barrel Assembly		26990	Sling Strap Assembly and Mountings Complete
2		Bolt Assembly	52	32890	Stock Assembly
		Bolt Final Assembly		18186	Stock Reinforcing Screw
3	17012	Bolt Plug		16970	Stock Reinforcing Screw Dowel
4	17013	Bolt Stop	53	26555	Swivel Assembly (Q. D.)
5	24475	Bolt Stop Pin	54	15280	Trigger
6	90555	Bolt Stop Release	55	17053	Trigger Adjusting Screw
7	90554	Bolt Stop Spring		32895	Trigger Assembly
8	14472	Butt Plate	56	19461	Trigger Connector
9	25410	Butt Plate Screw	57	17053	Trigger Engagement Screw
10	17017	Ejector	58	26376	Trigger Guard
11	17676	Ejector Pin		26371	Trigger Guard Assembly
12	17019	Ejector Spring	59	32905	Trigger Housing Assembly
13	14669	Extractor	60	24477	Trigger Pin
14	27340	Extractor Rivet	61	15400	Trigger Spring
	15376	Fastener, Sling Strap	62	15481	Trigger Stop Screw
15	22020	Firing Pin	ADDITIONAL CALIBERS		
16	22040	Firing Pin Assembly			
17	17022	Firing Pin Cross Pin	NOTE: Part not listed same as 30-06 Caliber		
18	19800	Floor Plate			
19	15291	Floor Plate Latch			
20	16451	Floor Plate Latch Pin			
21	16452	Floor Plate Latch Spring	32862		Barrel Assembly, 7mm Rem. Mag.
22	16453	Floor Plate Pivot Pin	15709		Barrel Assembly, 270 Win.
23	22035	Front Guard Screw	27341		Bolt Assembly, 7mm Rem. Mag.
24	15373	Front Sight	14659		Extractor, 7mm Rem. Mag.
	15719	Front Sight (Low)	21387		Extractor Rivet, 7mm Rem. Mag.
25	15635	Front Sight Ramp	25410		Front Sight, 7mm Rem. Mag.
26	28505	Front Sight Ramp Screw	32880		Recoil Pad, 7mm Rem. Mag.
27	15363	Front Sight Hood			Recoil Pad Screw, 7mm Rem. Mag.
28	15357	Front Swivel Nut			Stock Assembly, 7mm Rem. Mag.
29	15356	Front Swivel Screw			
	15331	Grip Cap			
	30505	Grip Cap Spacer			
30	16430	Magazine			
31	15752	Magazine Follower			
32	15677	Magazine Spring			
33	17029	Main 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			

EXPLODED
VIEW

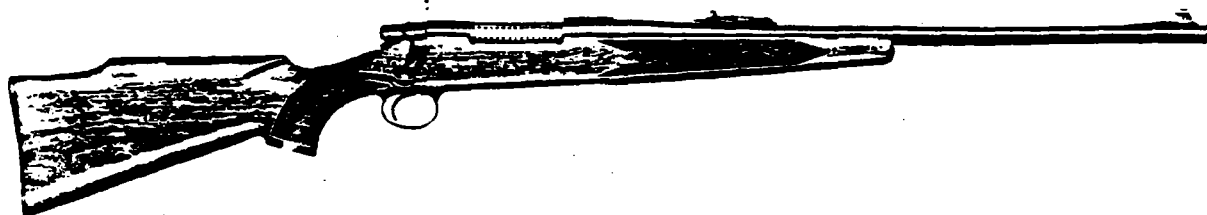
REMINGTON FIELD SERVICE MANUAL

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 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 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)

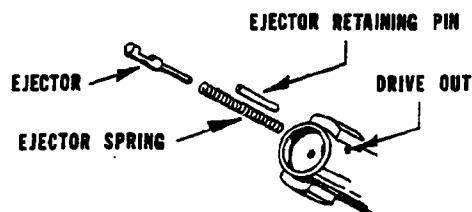


FIG. 1

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.

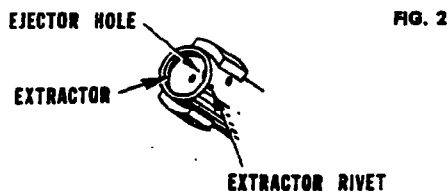


FIG. 2

Drive extractor rivet from bolt. See Fig. 2. Dislodge and remove loosened extractor from inside bolt rim.

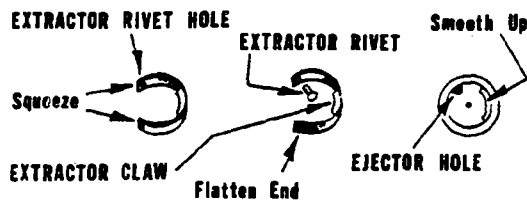


FIG. 3

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 reband extractor as indicated in Fig. 3.

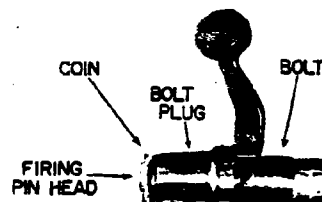
After tension has been adjusted satisfactorily, smooth up incline on extractor to match perfectly to breech bolt rim. See Fig. 3.

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.

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.

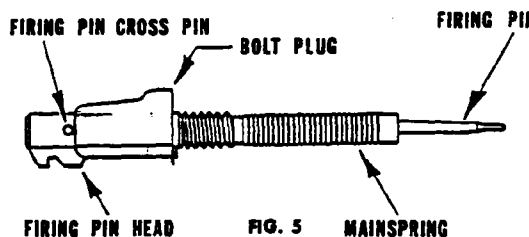


FIG. 5

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 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 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.

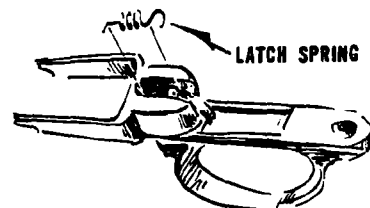


FIG. 6

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.

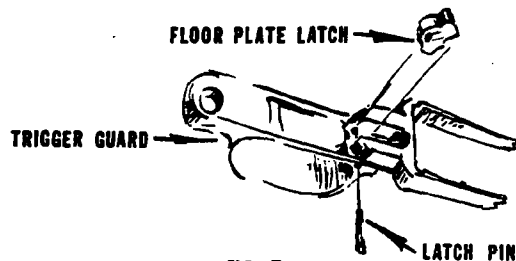


FIG. 7

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

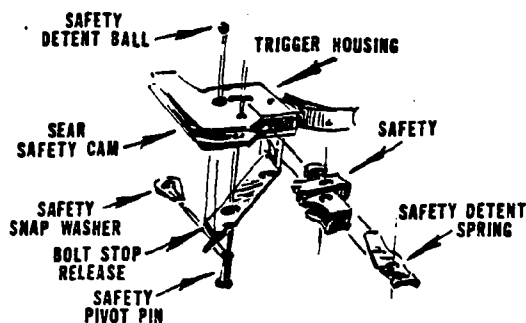


FIG. 8

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

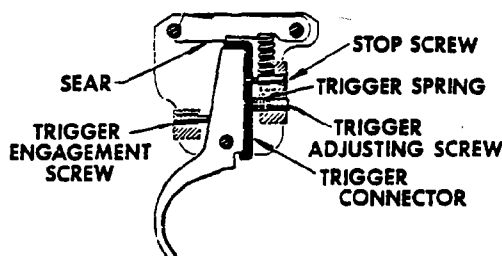


FIG. 9

and sear safety cam, align holes and tap in sear pin. Pin should not protrude into bolt stop slot. Adjust trigger if necessary and reseat 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 (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 3/8" 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.

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 eject 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 $\frac{1}{8}$ " 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.
 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.

(Continued on page 8)

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 30-06 Caliber listed below. See Sectional View for proper identity of parts. See added page for other caliber part listings.			37	24525	Rear Sight Assembly (includes Rear Sight Collar, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw)
1	26271	Barrel Assembly (includes Barrel, Barrel Bracket, Receiver)	38	16454	Rear Sight Base
2	26327	Bolt Assembly (includes Bolt Body Assembly and Bolt Handle)	39	16023	Rear Sight Base Screw
	26317	Bolt Final Assembly (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Extractor Rivet, Firing Pin Assembly)	40	16456	Rear Sight Screw
3	17012	Bolt Plug	41	28095	Rear Sight Stop (Selected Sizes)
4	17013	Bolt Stop	42	16968	Rear Sight Washer
5	24475	Bolt Stop Pin	43	15358	Rear Swivel Screw, BDL Grade
6	15478	Bolt Stop Release	44	17034	Receiver Plug Screw
7	17014	Bolt Stop Spring	45	26585	Safety Assembly (includes Safety, Safety Button)
8	14472	Butt Plate	46	23222	Safety Detent Ball
9	25410	Butt Plate Screw	47	15368	Safety Detent Spring
10	15287	Center Guard Screw, ADL Grade	48	17043	Safety Pivot Pin
11	17017	Ejector	49	17044	Safety Snap Washer
12	17676	Ejector Pin	50	15646	Sear Safety Cam
13	17019	Ejector Spring	51	24476	Sear Pin
14	16254	Extractor	52	17047	Sear Spring
15	27340	Extractor Rivet	53	30855	Sling Strap Assembly, BDL Grade (includes Sling Strap, Fastener, Keeper, Buckle)
	15376	Fastener, Sling Strap		26990	Sling Strap Assembly and Mountings Complete (includes Sling Strap Assembly, Swivel Assembly, Q. D. (2), Front Swivel Nut, Front Swivel Screws, Rear Swivel Screw)
16	22020	Firing Pin	54	26381	Stock Assembly, ADL Grade (includes Butt Plate, Butt Plate Screw (2), Front Guard Screw Bushing, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
17	22040	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)		26401	Stock Assembly, BDL Grade (includes Butt Plate, Butt Plate Screw (2), Fore-end Tip, Fore-end Tip Spacer, Grip Cap, Grip Cap Spacer, Front Swivel Nut, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel) (not shown)
18	17022	Firing Pin Cross Pin		18186	Stock Reinforcing Screw (not shown)
19	19800	Floor Plate, BDL Grade		16970	Stock Reinforcing Screw Dowel (not shown)
20	15291	Floor Plate Latch, BDL Grade	55	26555	Swivel Assembly, BDL Grade (Q. D.)
21	16451	Floor Plate Latch Pin, BDL Grade	56	15280	Trigger
22	16452	Floor Plate Latch Spring, BDL Grade	57	17053	Trigger Adjusting Screw
23	16453	Floor Plate Pivot Pin, BDL Grade		26345	Trigger Assembly (includes Bolt Stop Release, Trigger Housing Assembly, Safety Assembly, Safety Detent Ball, Safety Detent Spring, Safety Pivot Pin, Safety Snap Washer, Sear and Safety Cam Assembly, Sear Spring, Trigger, Trigger Adjusting Screw, Trigger Connector, Trigger Engagement Screw, Trigger Pin, Trigger Spring, Trigger Stop Screw) (not shown)
24	22035	Front Guard Screw	57	17053	Trigger Engagement Screw
25	15161	Front Guard Screw Bushing, ADL Grade	58	19461	Trigger Connector
26	15373	Front Sight	59	15281	Trigger Guard
	15719	Front Sight (Low)	60	26376	Trigger Guard, BDL Grade
27	28510	Front Sight Ramp		26371	Trigger Guard Assembly, BDL Grade (includes Floor Plate, Floor Plate Latch, Floor Plate Latch Pin, Floor Plate Latch Spring, Floor Plate Pivot Pin, Trigger Guard) (not shown)
	15635	Front Sight Ramp, BDL Grade	61	26655	Trigger Housing Assembly (includes Trigger Housing Spacer (3), Trigger Side Plate (2))
28	28505	Front Sight Ramp Screw	62	24477	Trigger Pin
29	15363	Front Sight Hood, BDL Grade	63	15400	Trigger Spring
30	15357	Front Swivel Nut, BDL Grade	64	15481	Trigger Stop Screw
31	15356	Front Swivel Screw, BDL Grade			
	15331	Grip Cap, BDL Grade (not shown)			
	15332	Grip Cap Spacer, BDL Grade (not shown)			
32	15284	Magazine, ADL Grade			
	16430	Magazine, BDL Grade (not shown)			
33	17024	Magazine Follower			
	15752	Magazine Follower, BDL Grade			
34	17028	Magazine Spring			
	15677	Magazine Spring, BDL Grade			
35	17029	Main Spring			
36	26355	Rear Guard Screw			

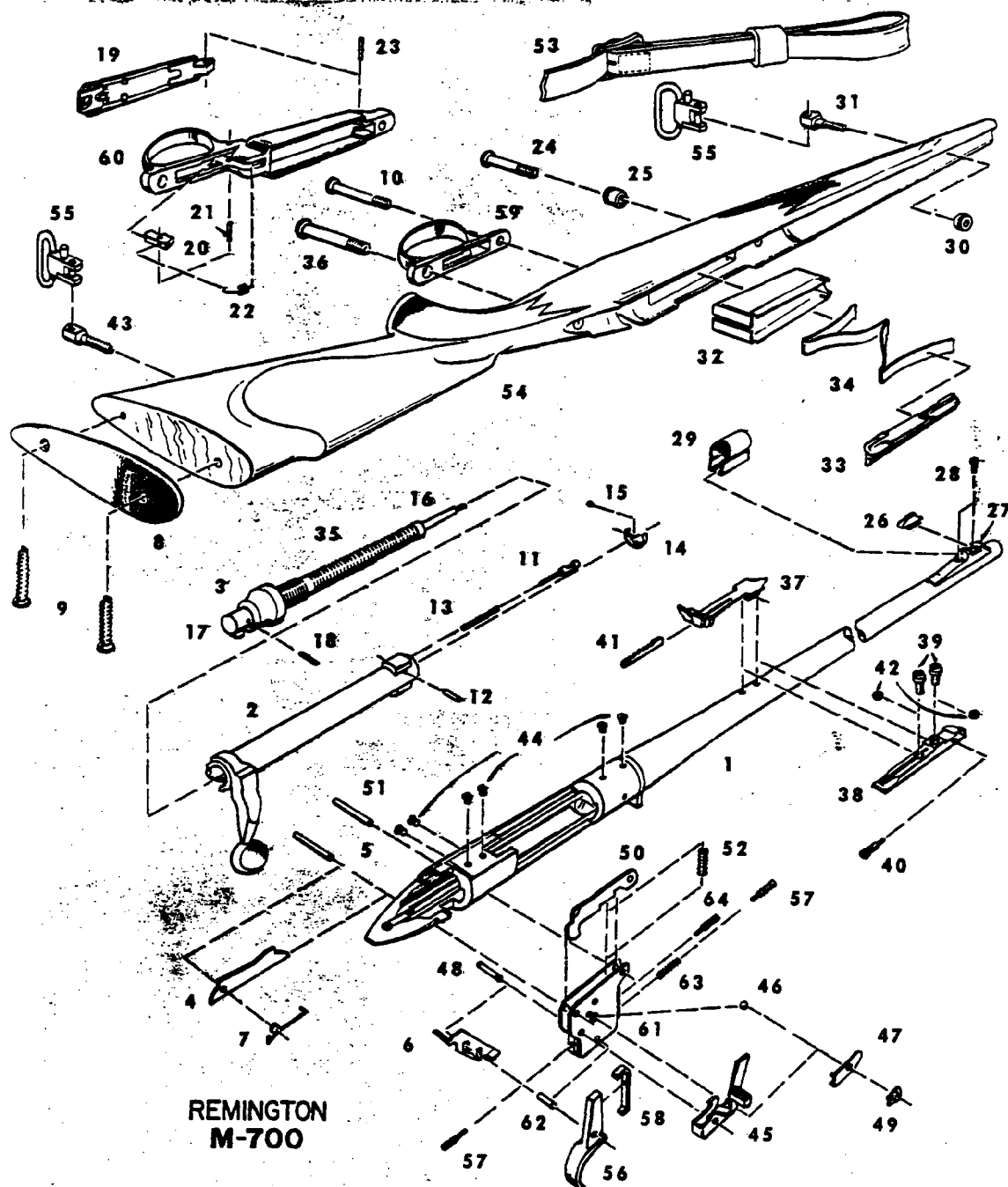
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Parts Subject to Change Without Notice

SECTIONAL
VIEW

REMINGTON FIELD SERVICE MANUAL

MODEL
700



REMINGTON
M-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)

Part No.	NAME OF PART	Part No.	NAME OF PART
26272	Barrel Assembly, 7mm Rem. Mag.	17891	Magazine Spring, 243 and 308 Win., 6mm Rem., 6.5mm Rem. Mag., 350 Rem. Mag., ADL Grade
26274	Barrel Assembly, 6mm Rem. Mag.	15698	Magazine Spring, 22-250 Rem.
26273	Barrel Assembly, 264 Win. Mag.	15699	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade
26265	Barrel Assembly, 222 Rem.	17058	Main Spring, 222 Rem., 222 Rem. Mag., 223 Rem., 243 Win., 308 Win., 6.5mm Rem. Mag., 350 Rem. Mag.
26266	Barrel Assembly, 222 Rem. Mag.	18843	Rear Scope Base, Varmint
26267	Barrel Assembly, 243 Win.	24526	Rear Sight Assembly, 7mm Rem. Mag., 264 Win. Mag.
27675	Barrel Assembly, 300 Win. Mag.	21387	Recoil Pad, 7mm Rem. Mag., 264 and 300 Win. Mag.
26268	Barrel Assembly, 308 Win.	25410	Recoil Pad Screw, 7mm Rem. Mag., 264 and 300 Win. Mag.
26269	Barrel Assembly, 270 Win.	18842	Scope Base Screw, Rear, Varmint
27678	Barrel Assembly, 22-250 Rem.	16205	Scope Base Screw Front, Varmint
27676	Barrel Assembly, 6.5mm Rem. Mag.	26382	Stock Assembly, 7mm Rem. Mag., 264 Win. Mag., ADL Grade (includes Front Guard Screw Bushing, Recoil Pad, Recoil Pad Screw (2), Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
27677	Barrel Assembly, 350 Rem. Mag.	26380	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade
29570	Barrel Assembly, Varmint, 222 Rem. (includes Barrel, Barrel Bracket, Receiver)	26415	Stock Assembly, 7mm Rem. Mag., 264-300 Win. Mag., BDL Grade (includes Fore-End, Fore-End Spacer, Grip Cap, Grip Cap Spacer, Recoil Pad, Recoil Pad Screw (2), Front Swivel Nut, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
29571	Barrel Assembly, Varmint, 22-250 Rem.	26400	Stock Assembly, 222 Rem., 222 Rem. Mag., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., BDL Grade
29572	Barrel Assembly, Varmint, 223 Rem.	29585	Stock Assembly, Varmint, BDL Grade (includes Butt Plate, Butt Plate Screw (2), Fore-End, Fore-End Spacer, Grip Cap, Grip Cap Spacer, Front Swivel Nut, Stock, Stock Reinforcing Screw, Stock Reinforcing Screw Dowel)
29573	Barrel Assembly, Varmint, 6mm Rem.	26402	Stock Assembly, 6.5mm Rem. Mag., 350 Rem. Mag. (includes Fore-End Spacer, Fore-End Tip, Front Swivel Nut, Grip Cap, Grip Cap Spacer, Recoil Pad, Recoil Pad Screw (2), Stock)
29574	Barrel Assembly, Varmint, 243 Win.	26375	Trigger Guard, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6mm Rem., 22-250 Rem.
26328	Bolt Assembly, 7mm Rem. Mag., 264 and 300 Win. 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)
26329	Bolt Assembly, 6.5mm Rem. Mag., 350 Rem. Mag.		CALIBERS: 375 H&H Magnum, 458 WIN. MAGNUM
26325	Bolt Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.	27265	Barrel Assembly, 375 H&H Mag.
26326	Bolt Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	27266	Barrel Assembly, 458 Win. Mag.
26318	Bolt Final Assembly, 7mm Rem. Mag., 264 and 300 Win. Mag. (includes same as 30-06)	15709	Extractor
26319	Bolt Final Assembly, 6.5mm Rem. Mag., 350 Rem. Mag.	16771	Front Sight, 375 H&H Mag.
26315	Bolt Final Assembly, 222 Rem., 223 Rem., 222 Rem. Mag.	23805	Front Sight, 458 Win. Mag.
26316	Bolt Final Assembly, 243 Win., 308 Win., 6mm Rem., 22-250 Rem.	27270	Stock Assembly, 375 H&H Mag., 458 Win. Mag. (includes same as standard Magnum except Stock Bolt (2), Nut (2), Cover (4) used)
15852	Ejector, 222 Rem., 223 Rem., 223 Rem. Mag.		DISCONTINUED or SERVICE PARTS
15709	Extractor, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.	26270	Barrel Assembly, 280 Rem.
15850	Extractor, 222 Rem., 223 Rem., 222 Rem. Mag.	20467	Extractor, 222 Cal.
27341	Extractor Rivet, 7mm Rem. Mag., 264-300 Win. Mag., 6.5mm Rem. Mag., 350 Rem. Mag.	17639	Ejector, 222 Cal.
27342	Extractor Rivet, 222 Rem., 223 Rem., 222 Rem. Mag.	16717	Front Sight Ramp, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., ADL Grade
22021	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.	15361	Front Sight Ramp, 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win., BDL Grade
22041	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 Rem.	24666	Front Sight Ramp, 30-06, 280 Rem., 308 Win., 270 Win., ADL Grade
16434	Floor Plate, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 308 Win., 6mm Rem., 22-250 Rem.	24477	Front Sight Ramp Pin, 6mm Rem., 7mm Rem. Mag., 264 Win. Mag., 222 Rem., 222 Rem. Mag., 243 Win.
22037	Front Guard Screw, 222 Rem., 222 Rem. Mag., 223 Rem., 243 and 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.
16204	Front Scope Base, Varmint	28200	Rear Sight Assembly, Complete (includes Rear Sight Assembly, Rear Sight Base, Rear Sight Base Screw (2), Rear Sight Screw, Rear Sight Stop, Rear Sight Washer (2))
15282	Magazine, ADL Grade, 222 Rem., 222 Rem. Mag.		
16716	Magazine, BDL Grade, 222 Rem., 222 Rem. Mag., 223 Rem.		
15283	Magazine, ADL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.		
16715	Magazine, BDL Grade, 243 and 308 Win., 6mm Rem., 22-250 Rem.		
14756	Magazine, BDL Grade, 6.5mm Rem. Mag., 350 Rem. Mag.		
17975	Magazine Follower, 222 Rem.		
16793	Magazine Follower, 222 Rem. Mag.		
17056	Magazine Follower, 243 and 308 Win., 6mm Rem., 22-250 Rem., 6.5mm Rem. Mag., 350 Rem. Mag.		
15285	Magazine Spacer, 222 Rem.		
16826	Magazine Spacer, 222 Rem., BDL Grade		
15286	Magazine Spacer, 222 Rem. Mag., 223 Rem., BDL Grade		
15742	Magazine Spacer, 222 Rem. Mag., ADL Grade		
17983	Magazine Spring, 222 Rem., 222 Rem. Mag., 223 Rem.		

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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:

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.
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.
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).
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.
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.
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.

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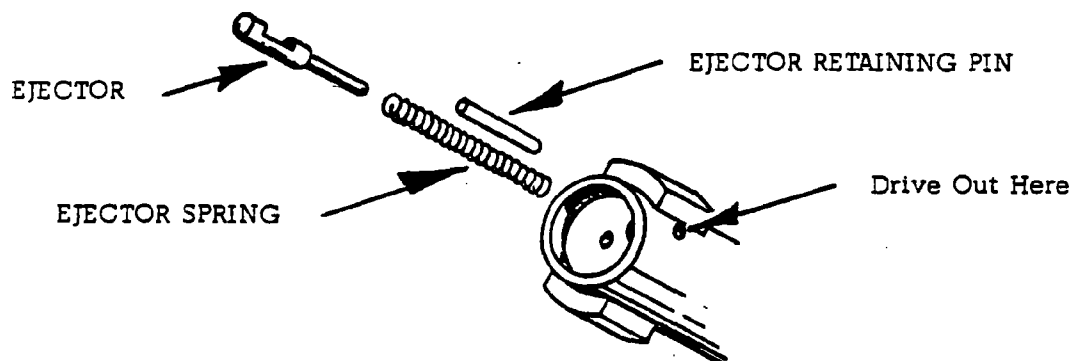
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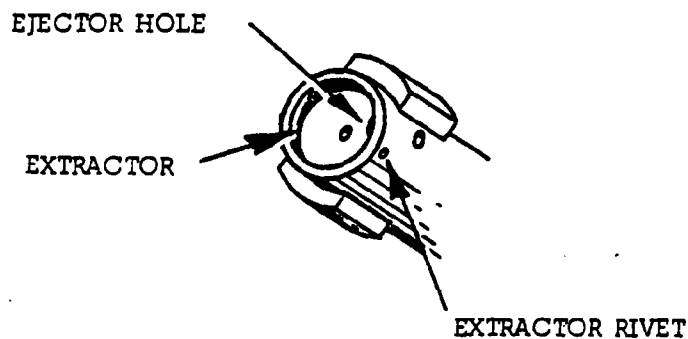


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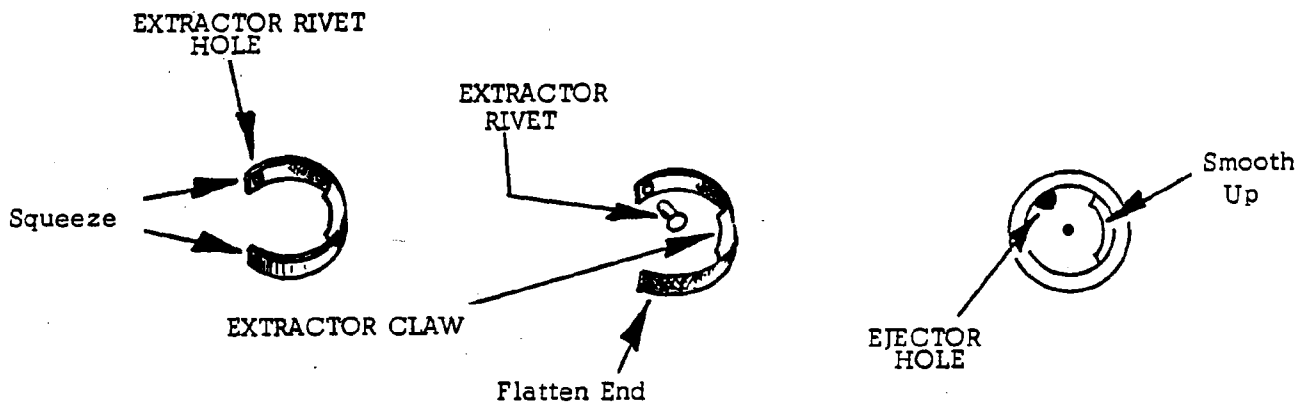
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Pry up extractor from inner rim, on fact of bolt, and disassemble extractor and rivet from bolt.

To Reassemble - Adjust replacement for proper tension before reassembly as follows: Squeeze ends of extractor together slightly. (See sketch below)



Straighten tail of extractor. (See sketch above)

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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.

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Place support inside of bolt rim and against head of rivet. Stake rivet against outside of breech bolt.

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REMINGTON
FIELD SERVICE MANUAL

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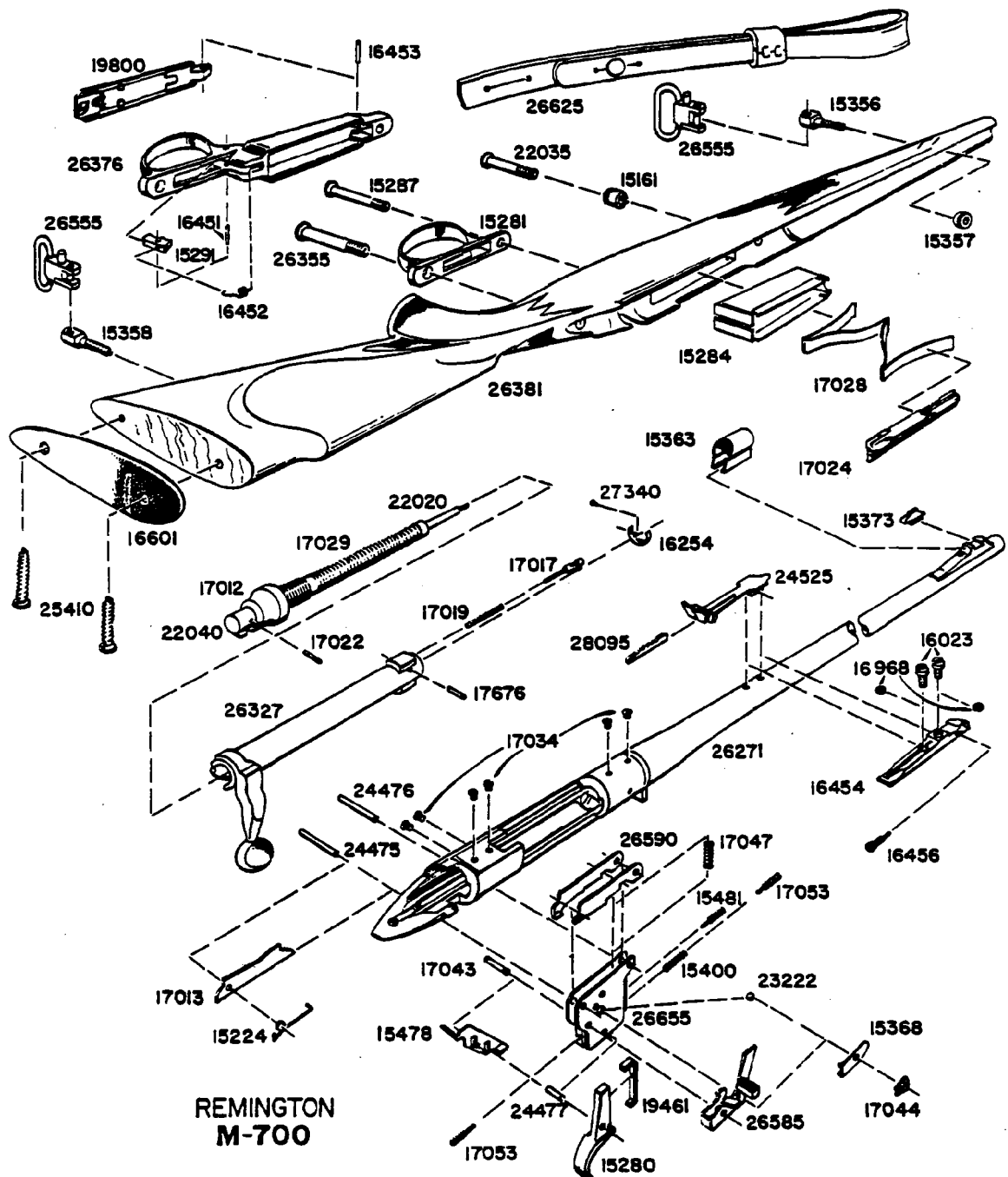
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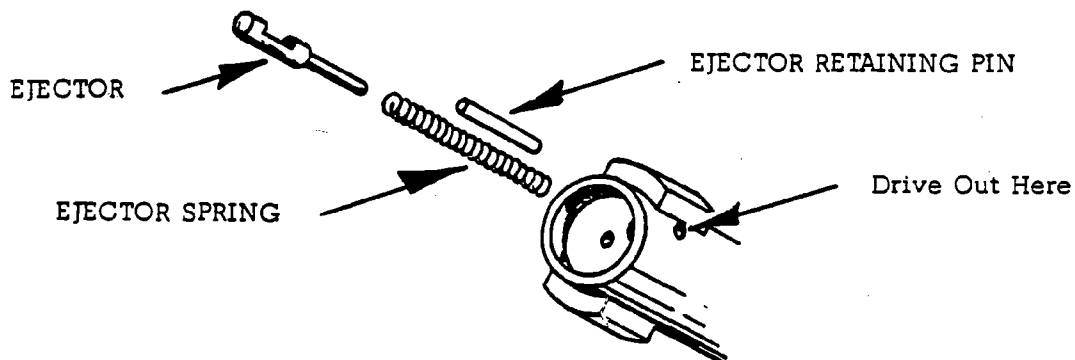
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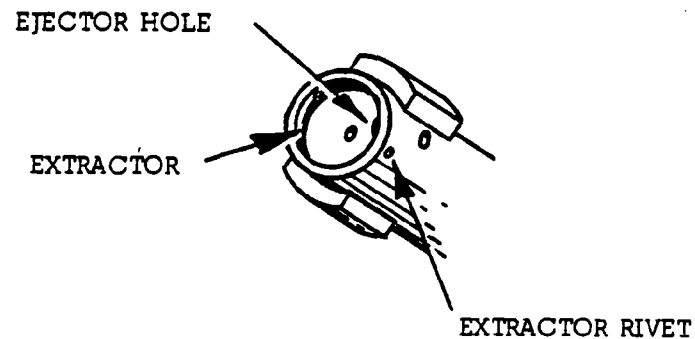


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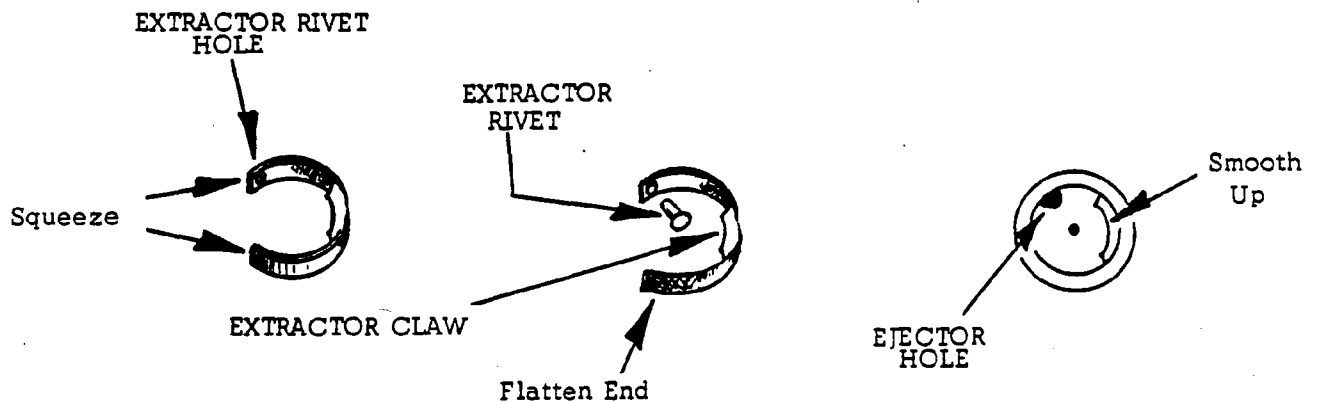
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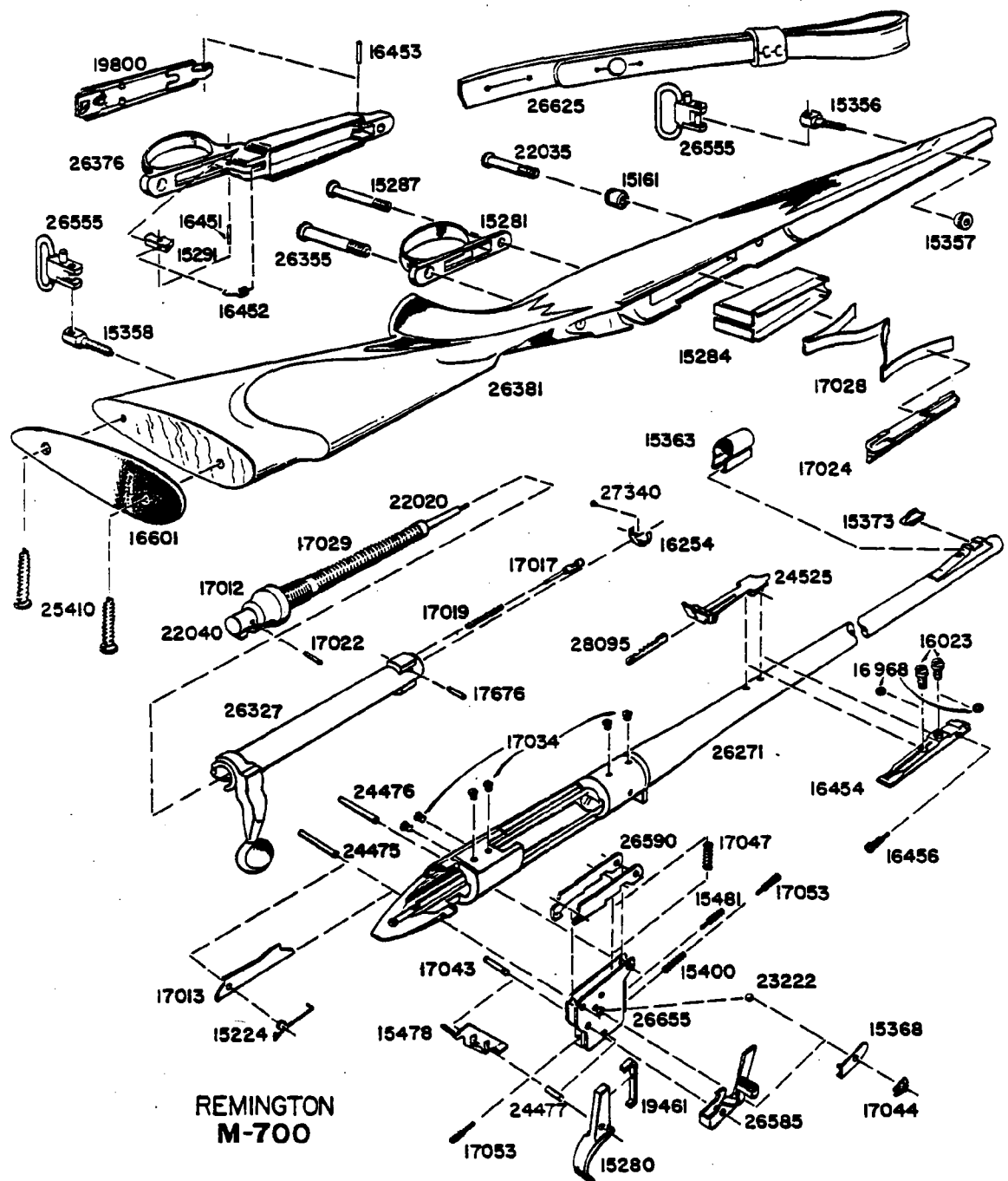
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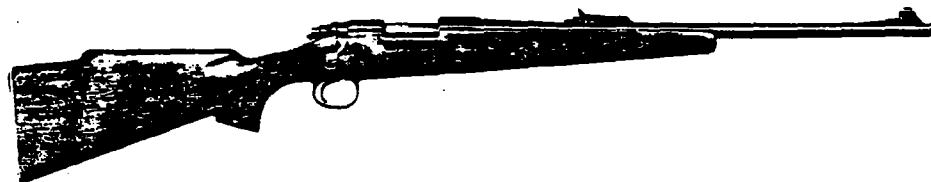
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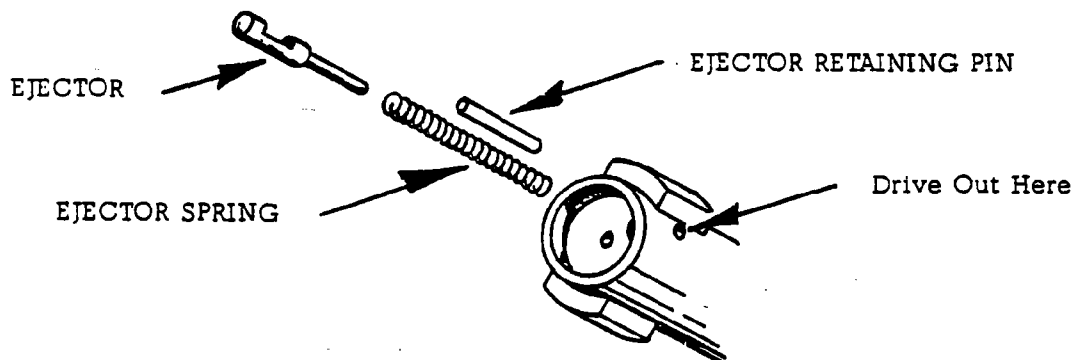
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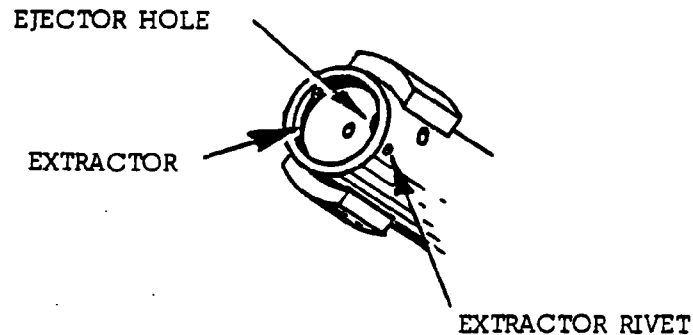


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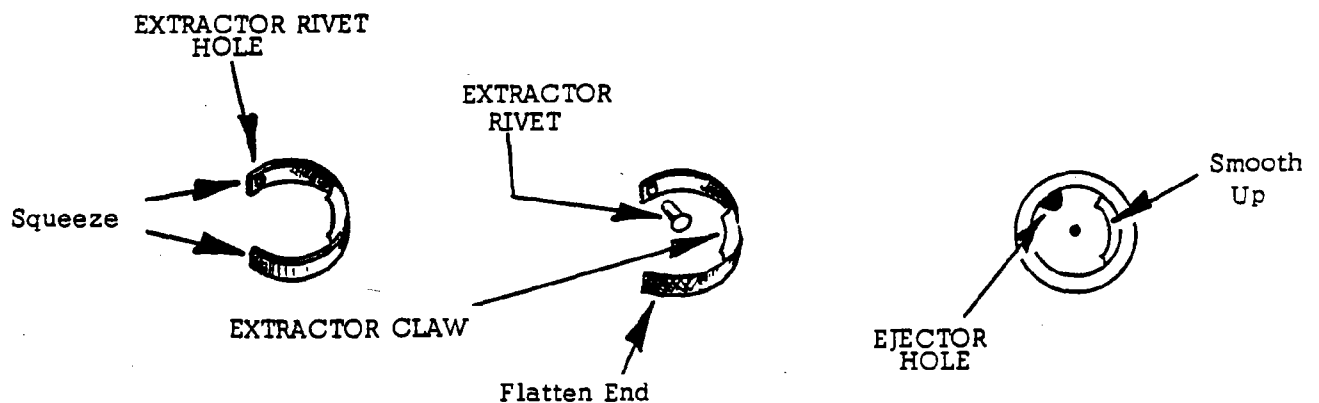
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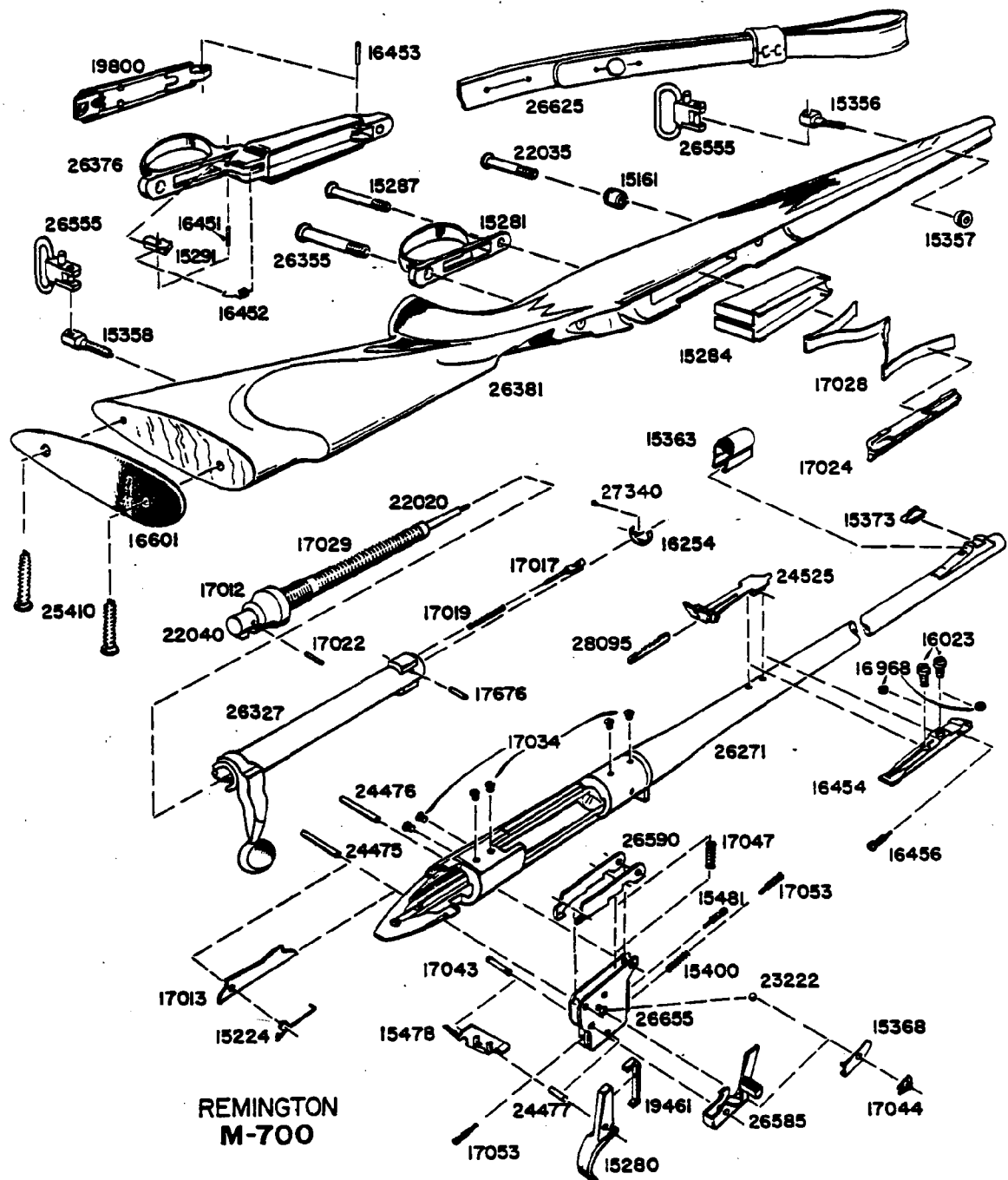
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R&D:FGH

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**FIREARMS SAFETY
DEPENDS ON YOU.**



**MAKE NO
MISTAKE ABOUT IT!**

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 re-emphasizing 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.

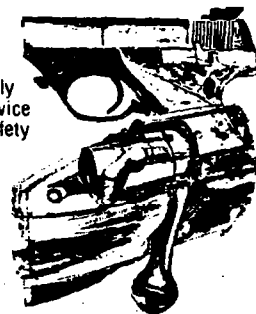
KNOW YOUR GUN—READ YOUR INSTRUCTION MANUAL

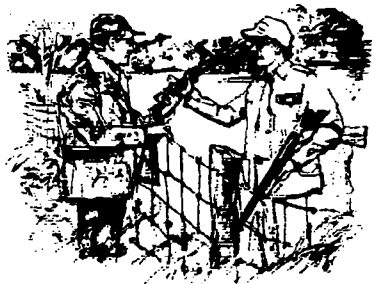
1 Don't Rely on Your Gun's Safety. Treat Every Gun as if It Were Loaded and Ready to Fire

The safety on any gun is a mechanical device that serves as a *part* of 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.





2 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 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 slippery 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 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.

3 Never Load or Carry a Loaded Gun Until You Are Ready To Use It

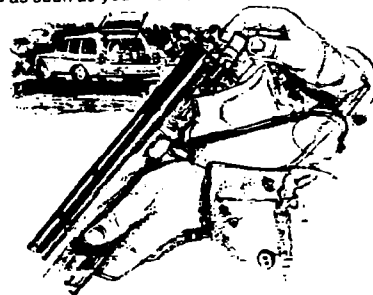
One of the cardinal rules of shooting safety is to load your gun only when ready to use it — and to unload as soon as you are through. A loaded gun has no place in — or near — a car or truck or building. Keep your fingers off the trigger while loading or unloading.

For shotgun shooting, don't load until you've started into the field or 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 safe 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.





4 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.

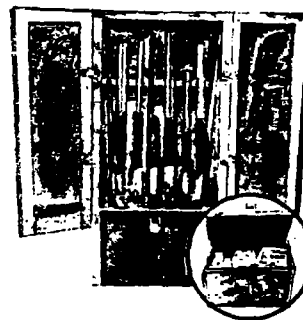
Learn to keep your muzzle always pointed in a safe direction. That may be in the air on some occasions, at the ground on others, but never at anyone or at anything not intended as a target.

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 it 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.

5 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.





6 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.

7 Know the Range of Your Gun. Remember, Even a 22 Rimfire Can Travel Over One Mile

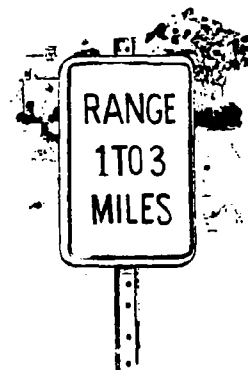
All shooters hope they will hit what they are aiming at when they pull the trigger. Safe shooters also consider where their shot might go if they miss.

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 $1\frac{1}{4}$ 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.





8 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.

9 Always Be Sure the Barrel is Clear of Obstructions. Only Carry Ammunition of the Proper Size for the Gun You Are Using

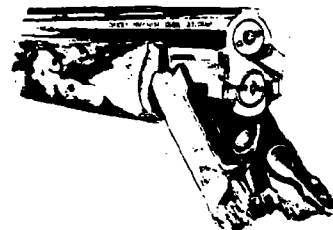
It might be mud, snow or a shotshell wad. It could even be a cleaning patch or the wrong size ammunition placed in your gun's chamber by mistake. All are obstructions that can block a gun barrel and cause serious injury to the shooter if not detected. These obstructions may have become lodged in your 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.

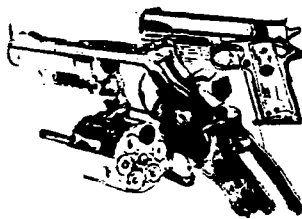
Proper safety procedures require that all gun barrels be checked for obstructions before firing.

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.





10

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.

S A A M I

SPORTING ARMS AND AMMUNITION MANUFACTURERS' INSTITUTE, INC.
Safety Series, 1075 Post Road, Riverside, CT 06878

K-4-19

MODEL 721-722

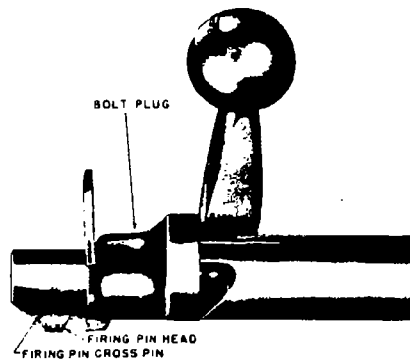
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MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Disassembly1. BOLT AND COMPONENTS:

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Disassembly5. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Assembly1. 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-ACTION6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver,

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Assembly6. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLES

Fitting of New Parts and Adjusting

- | | |
|-----------------------------------|----------------------------------|
| 1. Barrel-Receiver Assembly | 17. Rear Trigger Adjusting Screw |
| 2. Bolt | 18. Safety |
| 3. Bolt Plug | 19. Safety Detent |
| 4. Bolt Stop | 20. Safety Detent Spring |
| 5. Bolt Stop Release | 21. Safety Pivot Pin |
| 6. Bolt Stop Spring | 22. Safety Snap Washer |
| 7. Ejector | 23. Sear-Safety Cam Assembly |
| 8. Ejector Spring | 24. Sear Spring |
| 9. Extractor | 25. Stock |
| 10. Firing Pin | 26. Trigger Assembly |
| 11. Firing Pin Head | 27. Trigger |
| 12. Front Trigger Adjusting Screw | 28. Trigger Connector |
| 13. Main Spring | 29. Trigger Guard |
| 14. Magazine | 30. Trigger Guide Plate |
| 15. Magazine Follower | 31. Trigger Housing |
| 16. Magazine Spring | 32. Trigger Spring |
| | 33. Trigger Stop Screw |

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. 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.

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting5. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting15. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting20. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting25. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting29. 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 RIFLESFailures to Operate

1. Does not cock.
2. Ejection fails.
3. Extraction fails.
4. Fails to feed.
5. Missfires
6. Safety does not operate.

MODELS 721-722 C.F. BOLT ACTION RIFLESFailures to Operate1. 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. Safety does not operate

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.

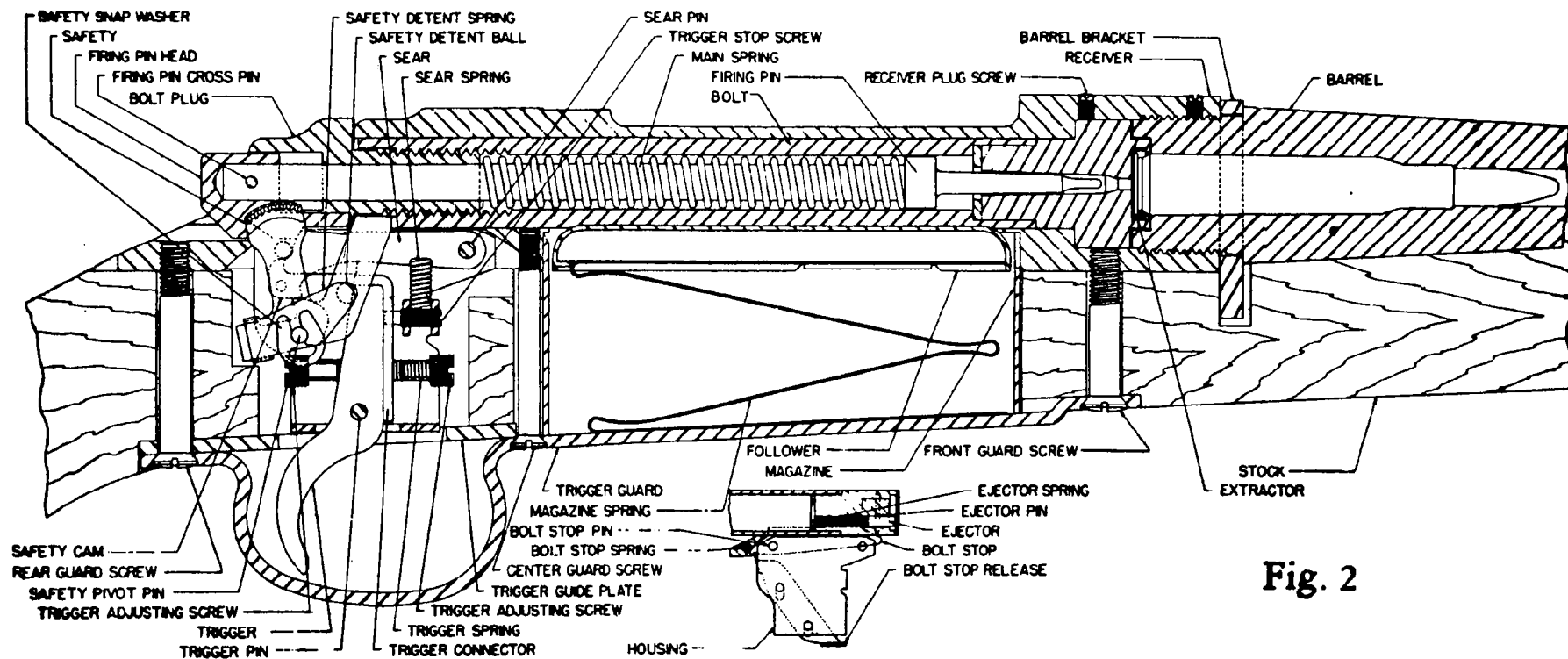


Fig. 2

**REMINGTON
MODEL 721-722**

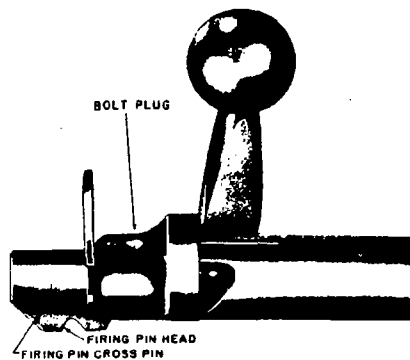
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MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Disassembly1. BOLT AND COMPONENTS:

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Disassembly5. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Assembly1. 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-ACTION6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver,

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting

- | | |
|-----------------------------------|----------------------------------|
| 1. Barrel-Receiver Assembly | 17. Rear Trigger Adjusting Screw |
| 2. Bolt | 18. Safety |
| 3. Bolt Plug | 19. Safety Detent |
| 4. Bolt Stop | 20. Safety Detent Spring |
| 5. Bolt Stop Release | 21. Safety Pivot Pin |
| 6. Bolt Stop Spring | 22. Safety Snap Washer |
| 7. Ejector | 23. Sear-Safety Cam Assembly |
| 8. Ejector Spring | 24. Sear Spring |
| 9. Extractor | 25. Stock |
| 10. Firing Pin | 26. Trigger Assembly |
| 11. Firing Pin Head | 27. Trigger |
| 12. Front Trigger Adjusting Screw | 28. Trigger Connector |
| 13. Main Spring | 29. Trigger Guard |
| 14. Magazine | 30. Trigger Guide Plate |
| 15. Magazine Follower | 31. Trigger Housing |
| 16. Magazine Spring | 32. Trigger Spring |
| | 33. Trigger Stop Screw |

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. 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.

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting5. 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 RIFLESFitting of New Parts and Adjusting10. 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.

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting15. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting20. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting25. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting29. 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 RIFLESFitting 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.

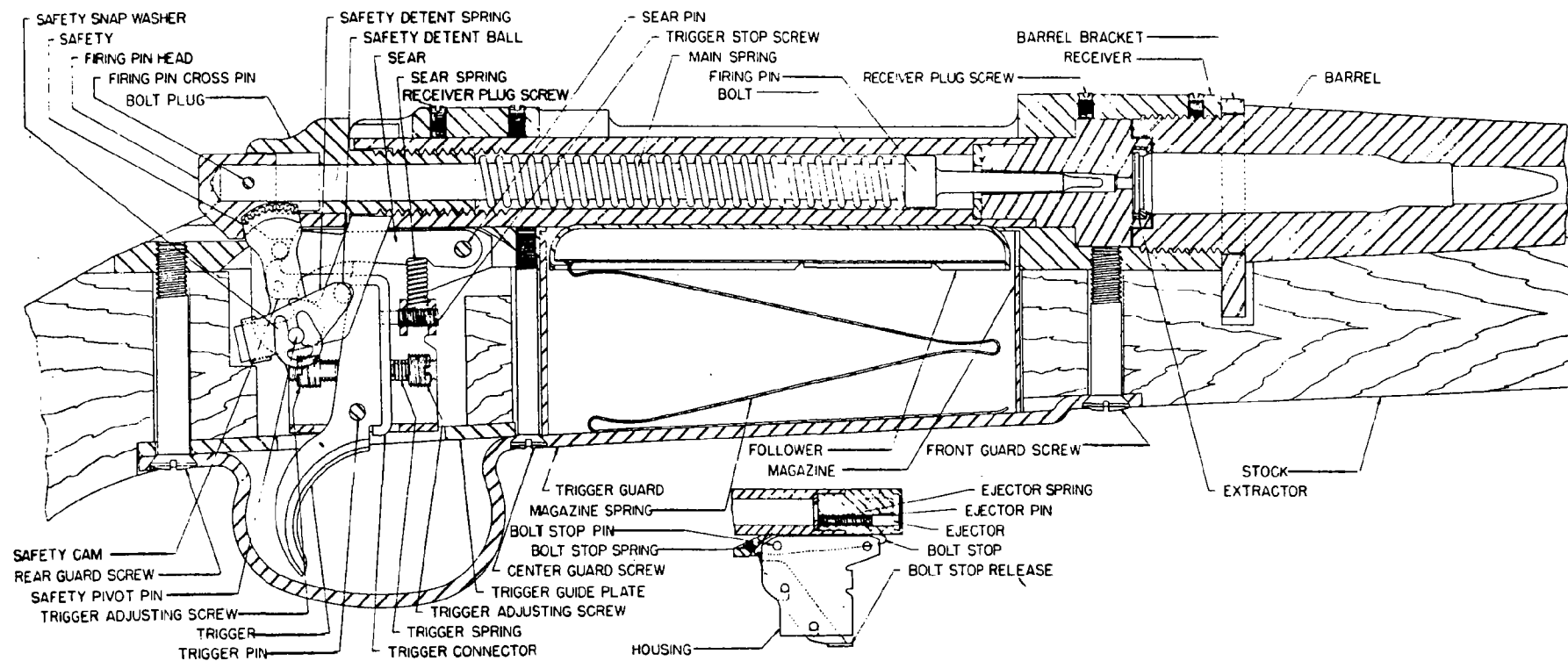
Travel of the Trigger - may be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

Failures to Operate

1. Does not cock.
2. Ejection fails.
3. Extraction fails.
4. Fails to feed.
5. Missfires
6. Safety does not operate.

J.F. Finnegan:emb

August 1956



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**REMINGTON
MODEL 721-722**

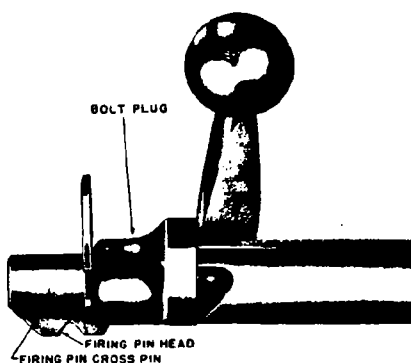
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MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Disassembly1. BOLT AND COMPONENTS:

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.

MODELS 721-722 G.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.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Assembly1. 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-ACTION6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver,

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting

- | | |
|-----------------------------|------------------------------|
| 1. Barrel-Receiver Assembly | 17. Rear Trigger Adjusting |
| 2. Bolt | Screw |
| 3. Bolt Plug | 18. Safety |
| 4. Bolt Stop | 19. Safety Detent |
| 5. Bolt Stop Release | 20. Safety Detent Spring |
| 6. Bolt Stop Spring | 21. 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 | 29. Trigger Guard |
| 14. Magazine | 30. Trigger Guide Plate |
| 15. Magazine Follower | 31. Trigger Housing |
| 16. Magazine Spring | 32. Trigger Spring |
| | 33. Trigger Stop Screw |

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. 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.

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting5. 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 RIFLESFitting of New Parts and Adjusting10. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting15. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLES

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting25. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting29. 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 RIFLESFitting 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.

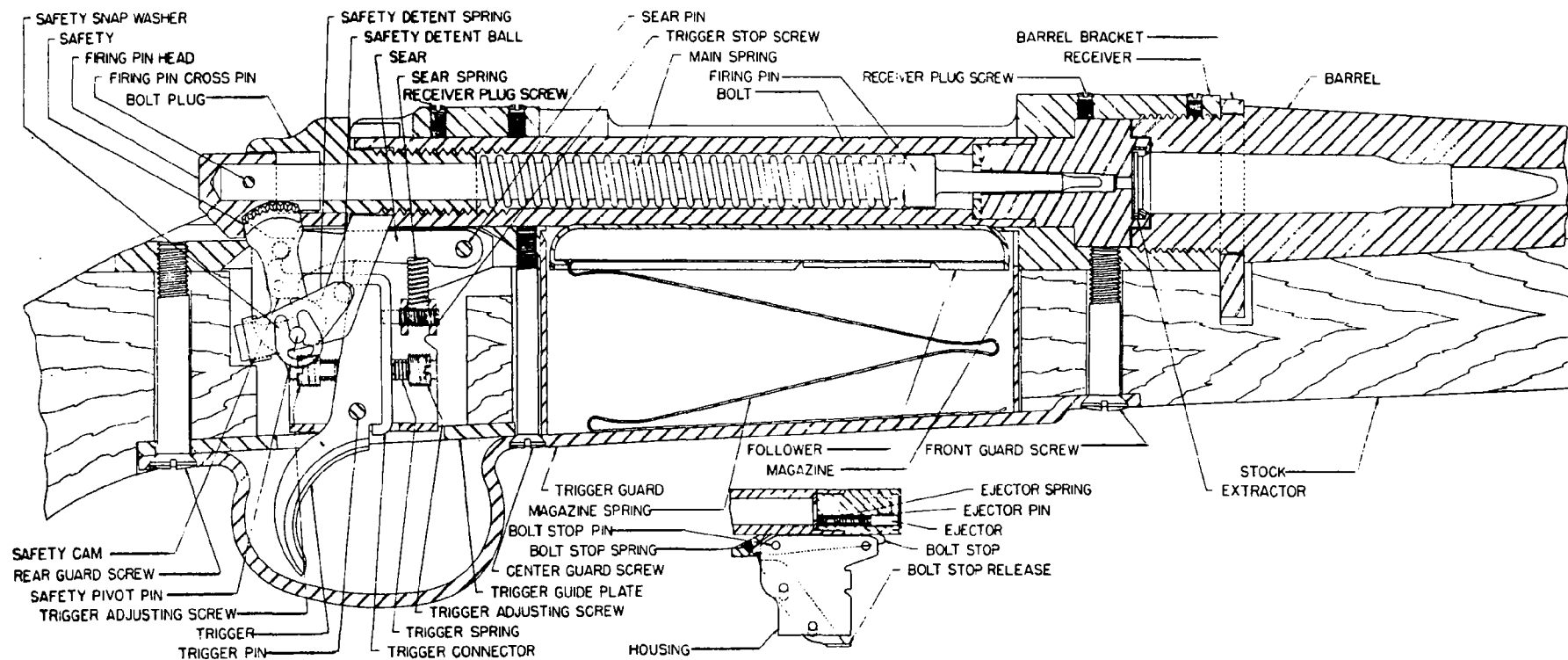
Travel of the Trigger - may be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

Failures to Operate

1. Does not cock.
2. Ejection fails.
3. Extraction fails.
4. Fails to feed.
5. Missfires
6. Safety does not operate.

J.F. Finnegan:emb

August 1956



REMINGTON FIELD SERVICE MANUAL

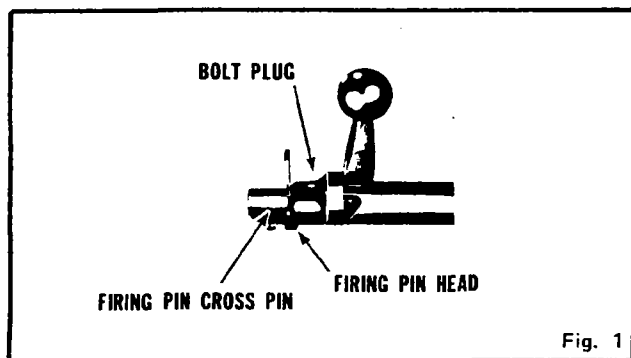
DISASSEMBLY

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.

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.

1973

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.

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

Simultaneously 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.

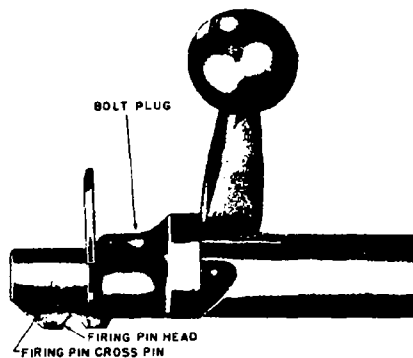
The instructions for Loading and Unloading, with directions for disassembly and care of rifle are contained in the instruction folder supplied with each rifle.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Disassembly1. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESDetails of Assembly1. 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-ACTION6. BOLT STOP:

Assemble trigger housing in receiver with sear pin. Assemble bolt stop spring and bolt stop in receiver,

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting

- | | |
|-----------------------------|------------------------------|
| 1. Barrel-Receiver Assembly | 17. Rear Trigger Adjusting |
| 2. Bolt | Screw |
| 3. Bolt Plug | 18. Safety |
| 4. Bolt Stop | 19. Safety Detent |
| 5. Bolt Stop Release | 20. Safety Detent Spring |
| 6. Bolt Stop Spring | 21. 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 | 29. Trigger Guard |
| 14. Magazine | 30. Trigger Guide Plate |
| 15. Magazine Follower | 31. Trigger Housing |
| 16. Magazine Spring | 32. Trigger Spring |
| | 33. Trigger Stop Screw |

MODELS 721-722 G.F. BOLT ACTION RIFLES

Fitting of New Parts and Adjusting

1. BARREL-RECEIVER ASSEMBLY

When required to disassemble return rifle to factory.

2. 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.

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting5. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting15. 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.

MODELS 721-722 C.F. BOLT ACTION RIFLES

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.

MODELS 721-722 C.F. BOLT ACTION RIFLESFitting of New Parts and Adjusting25. 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.

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 RIFLESFitting 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.

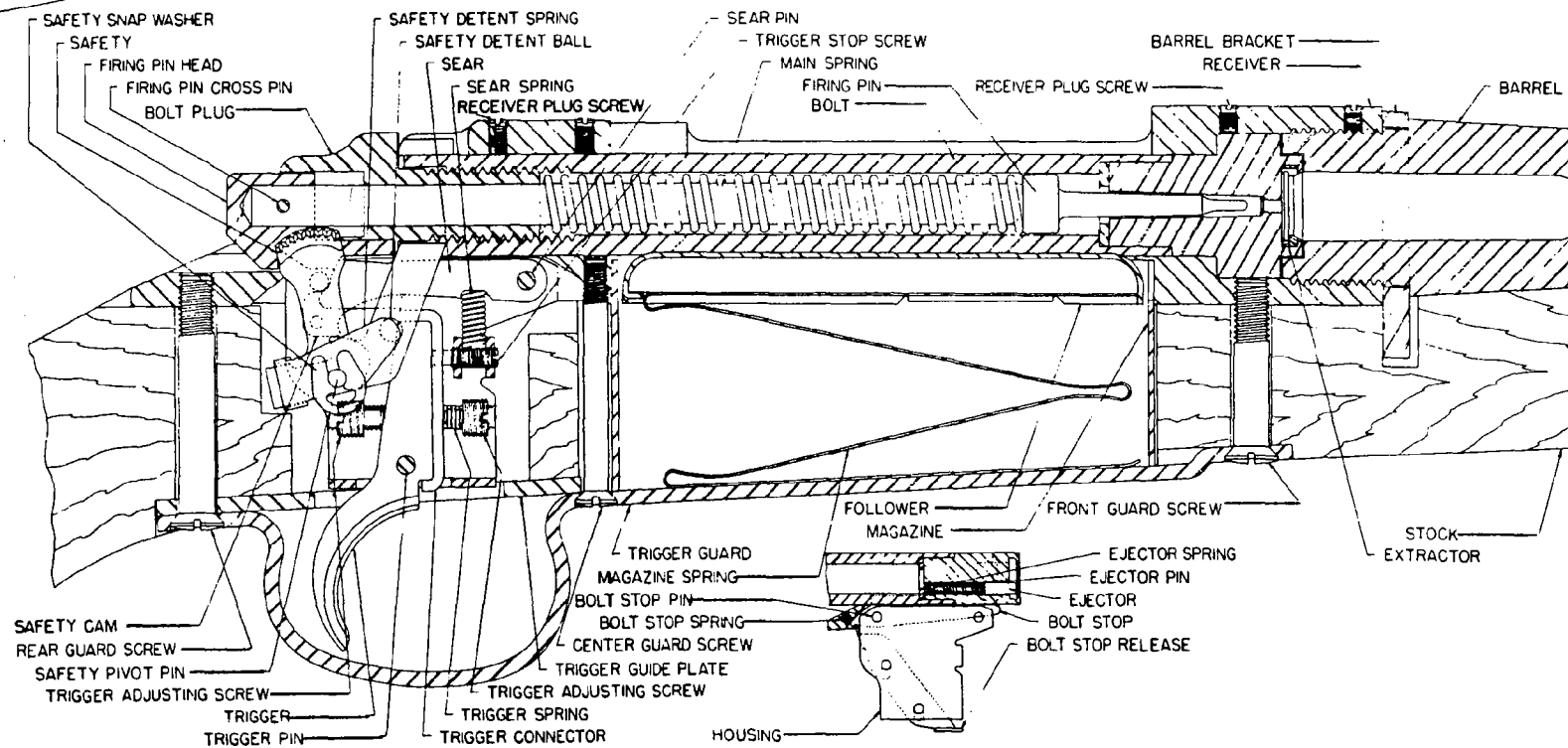
Travel of the Trigger - may be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

Failures to Operate

1. Does not cock.
2. Ejection fails.
3. Extraction fails.
4. Fails to feed.
5. Missfires
6. Safety does not operate.

J.F. Finnegan:emb

August 1956



REMINGTON FIELD SERVICE MANUAL

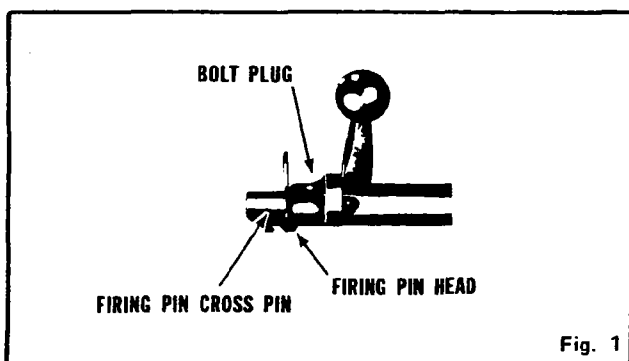
DISASSEMBLY

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

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.

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 of 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.

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.

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.

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 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.

7-4-7

**REMINGTON
MODEL 725**

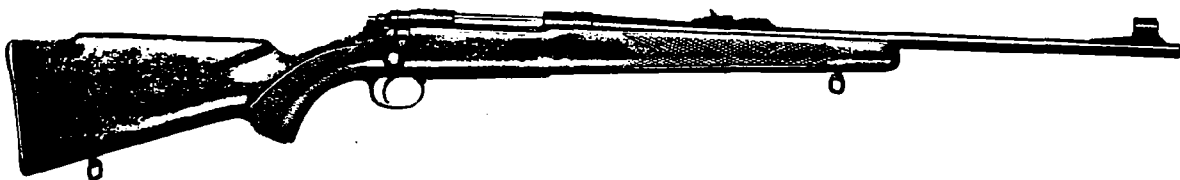
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Remington
FIELD SERVICE MANUAL

Model 725
INTRODUCTION

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

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 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.

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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).

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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 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.

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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 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 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 holes, assemble butt plate screw (2), and turn until butt plate is tight.

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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.

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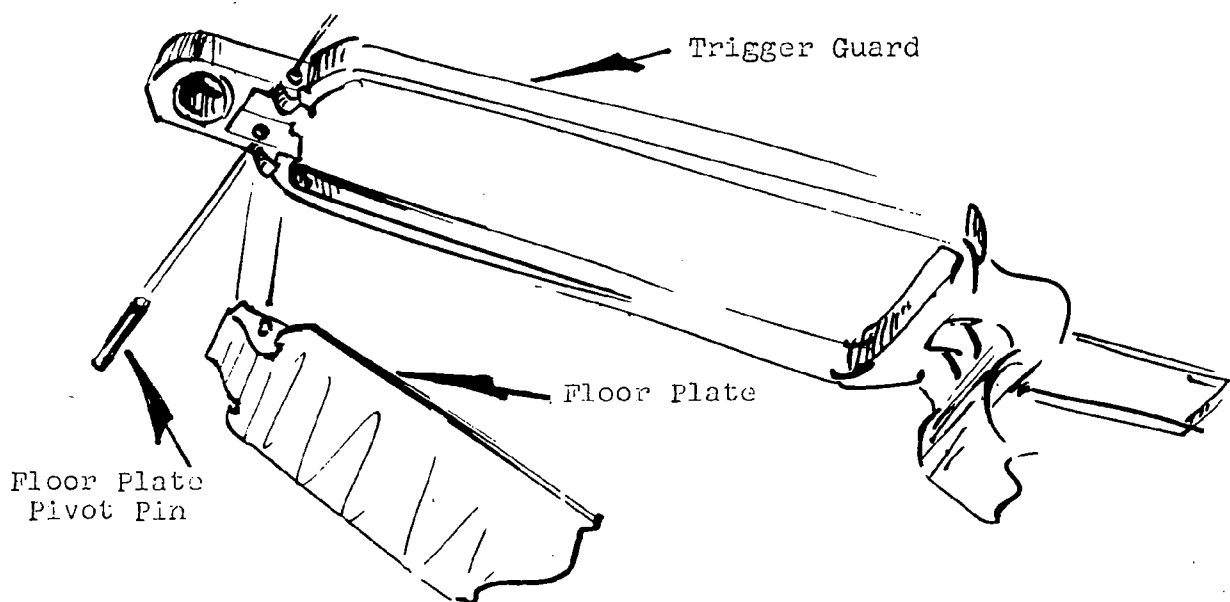
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TRIGGER GUARD ASSEMBLY - COMPONENTS: Remove trigger guard assembly.
Remove magazine follower,
magazine spring from floor
plate.

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,
support trigger guard properly to prevent damage
to guard at front section. See sketch below.



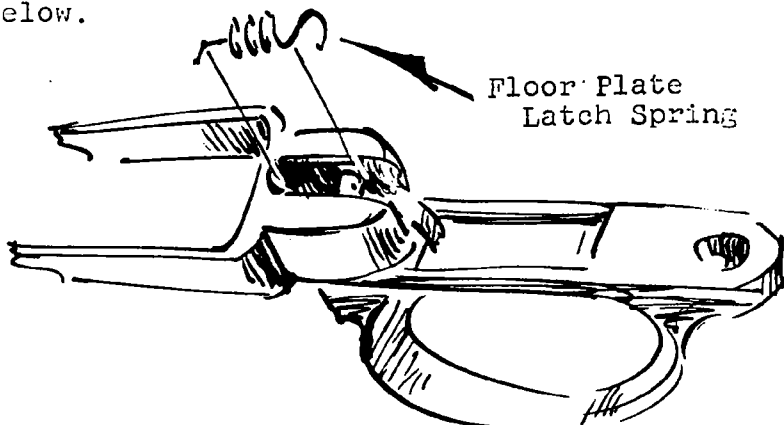
To Replace Interchangeable with no factory adjustment
required.

To Reassemble Follow reverse order. Make certain floor
plate is free swinging and locks into floor plate latch
properly.

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.

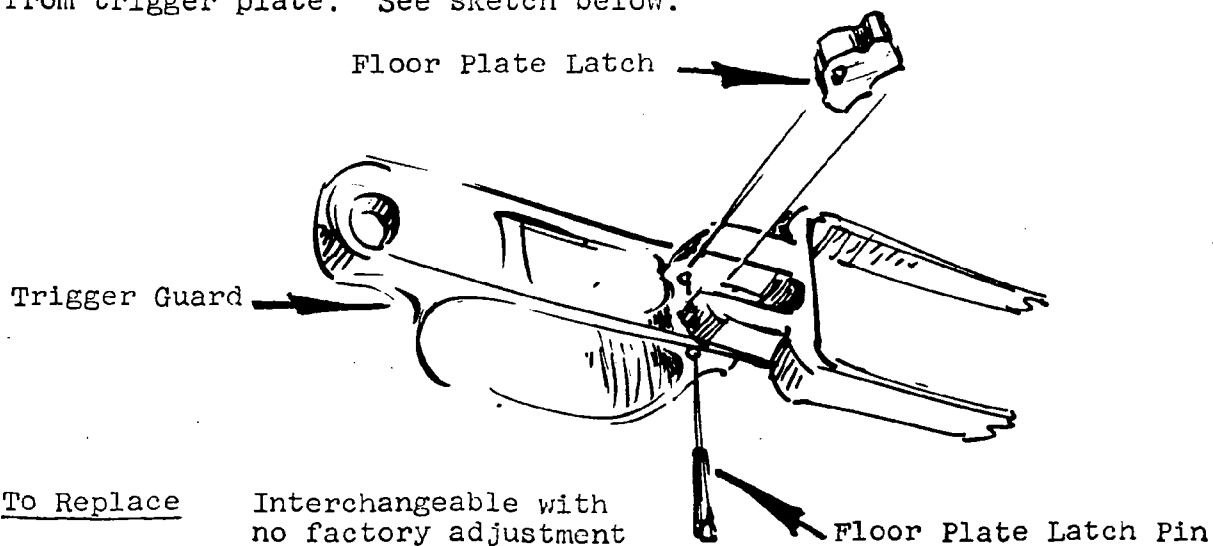


To Replace Interchangeable with no factory adjustment required.

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 floor plate latch pin, left to right. Disassemble floor plate latch from trigger plate. See sketch below.



To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

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Page 8

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.

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 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 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

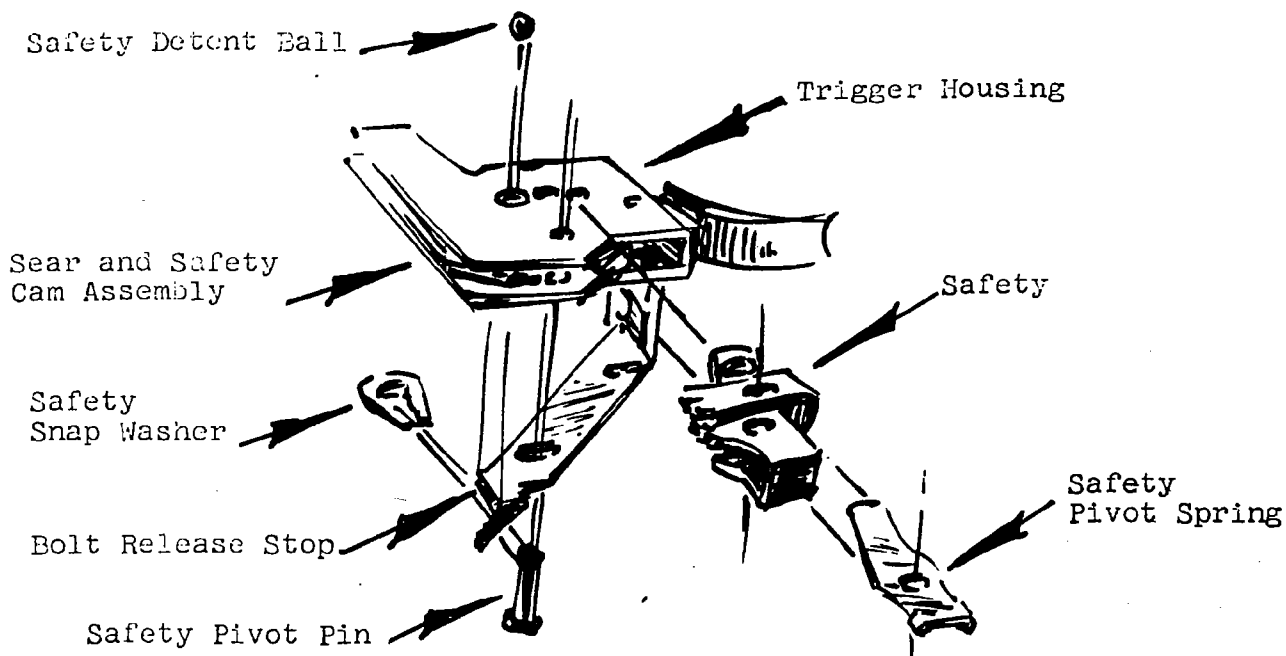
To Replace Interchangeable with no factory adjustment required. Replace safety lock thumbpiece assembly as assembly unit.

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.

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. 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.

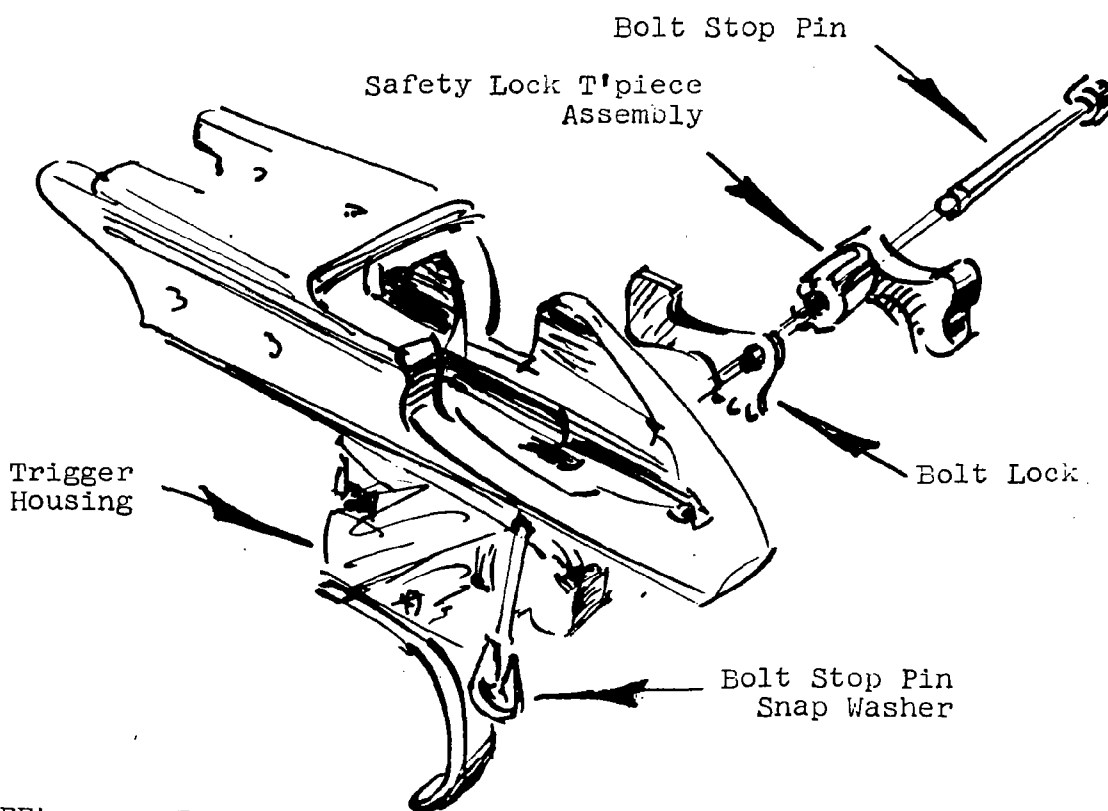
To Reassemble Follow reverse order. Ratchet teeth on safety should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumbpiece assembly for proper operation of three position safety stops.

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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. (See sketch below).



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ACTION CYCLE
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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 Lock

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.

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 bolt which 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.

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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.

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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

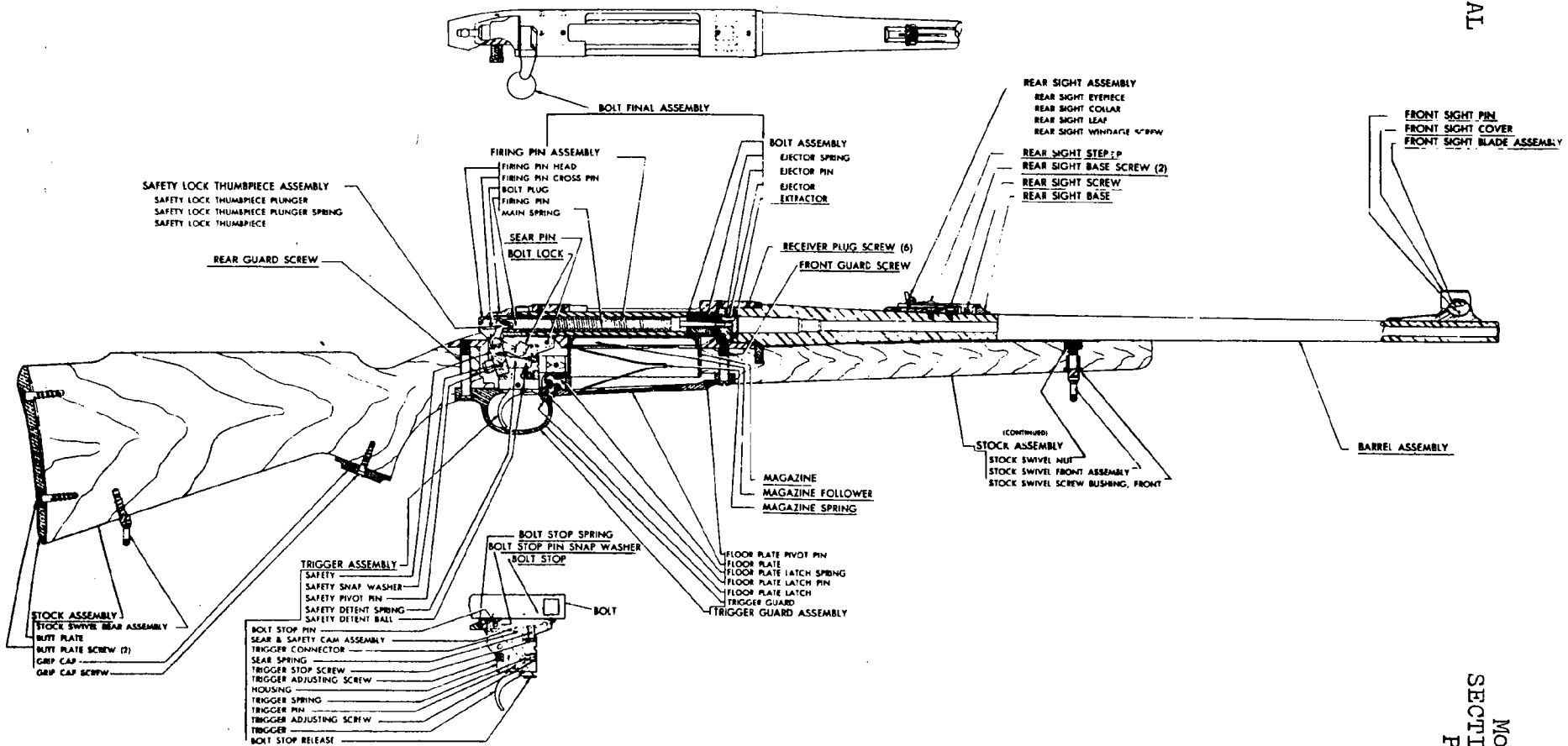
1. Damaged or missing components.

Service: Repair or replace safety lock 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 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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MODEL 725

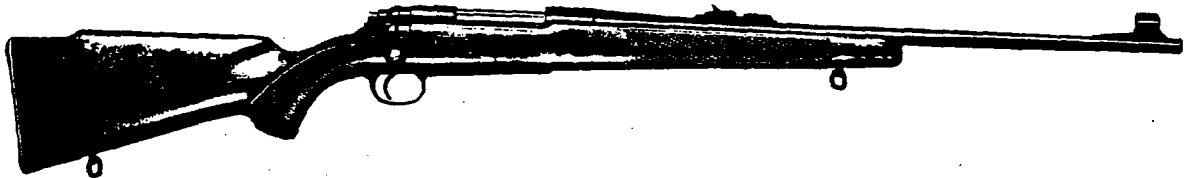
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FIELD SERVICE MANUAL

Model 725
INTRODUCTION

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

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 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.

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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 stop. 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).

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 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.

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Page 4

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 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 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 retread 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 holes, assemble butt plate screw (2), and turn until butt plate is tight.

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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.

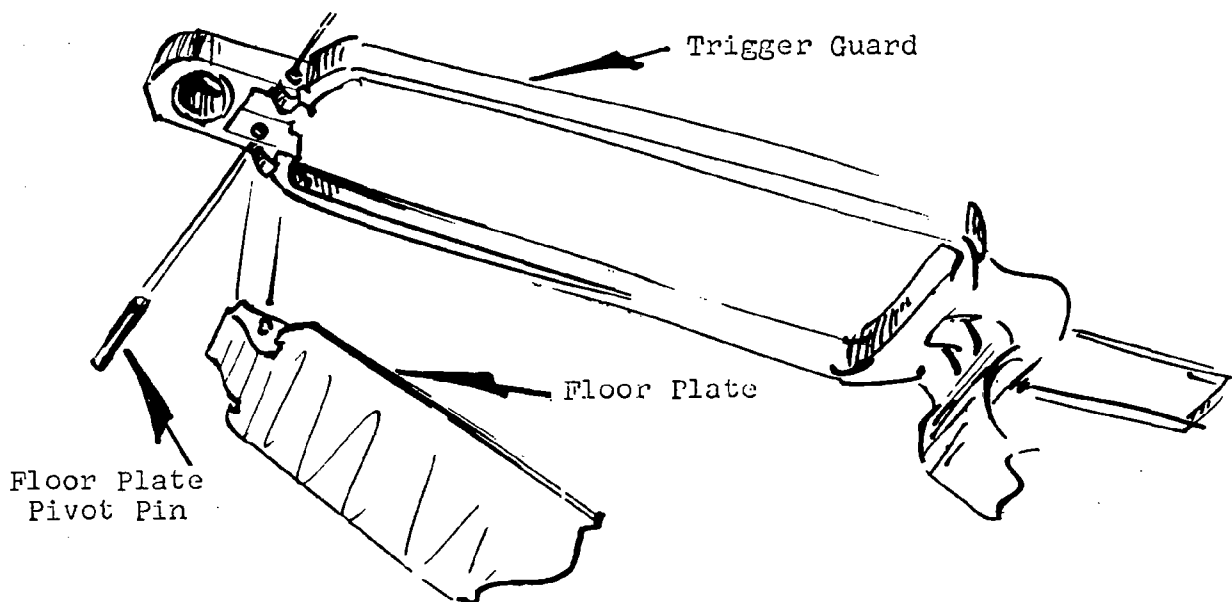
To Reassemble Follow reverse order. Tighten guard screws firmly.

TRIGGER GUARD ASSEMBLY - 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,
support trigger guard properly to prevent damage
to guard at front section. See sketch below.



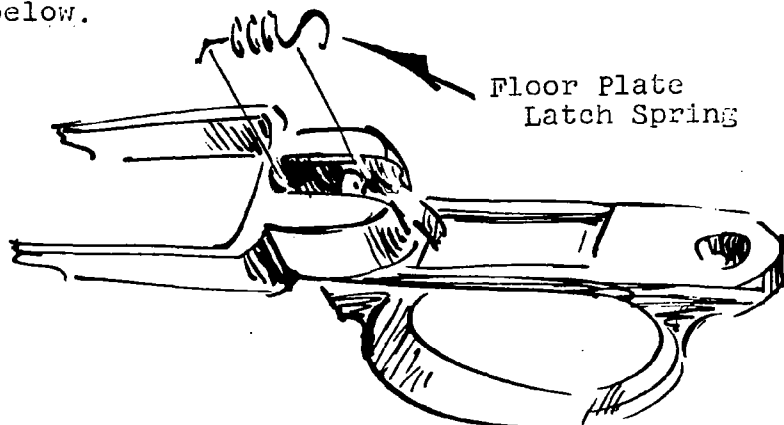
To Replace Interchangeable with no factory adjustment
required.

To Reassemble Follow reverse order. Make certain floor
plate is free swinging and locks into floor plate latch
properly.

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.

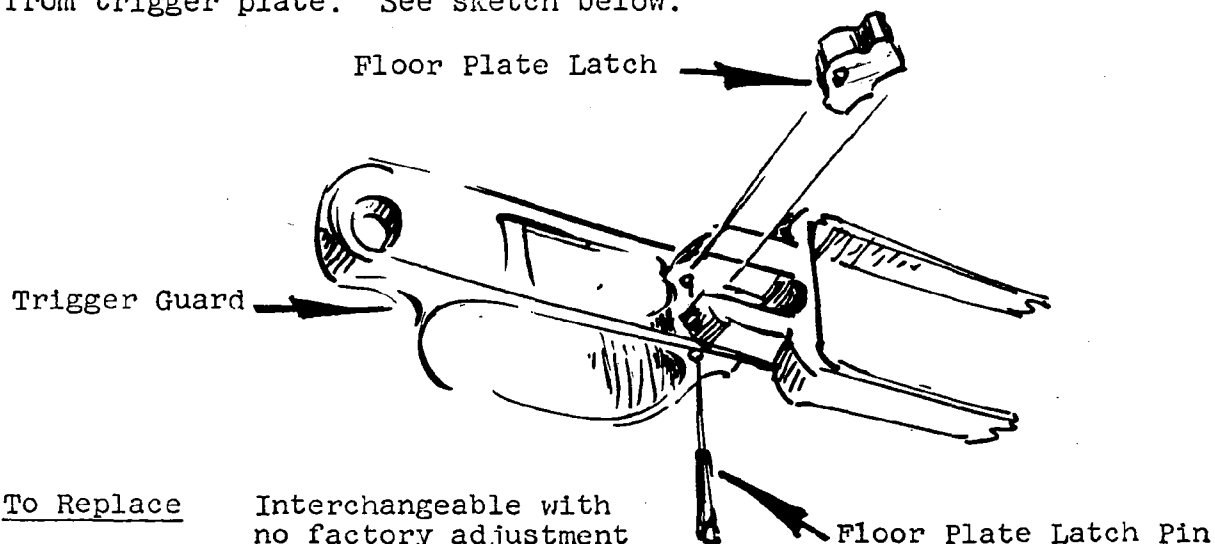


To Replace Interchangeable with no factory adjustment required.

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 floor plate latch pin, left to right. Disassemble floor plate latch from trigger plate. See sketch below.



To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

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.

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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 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 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

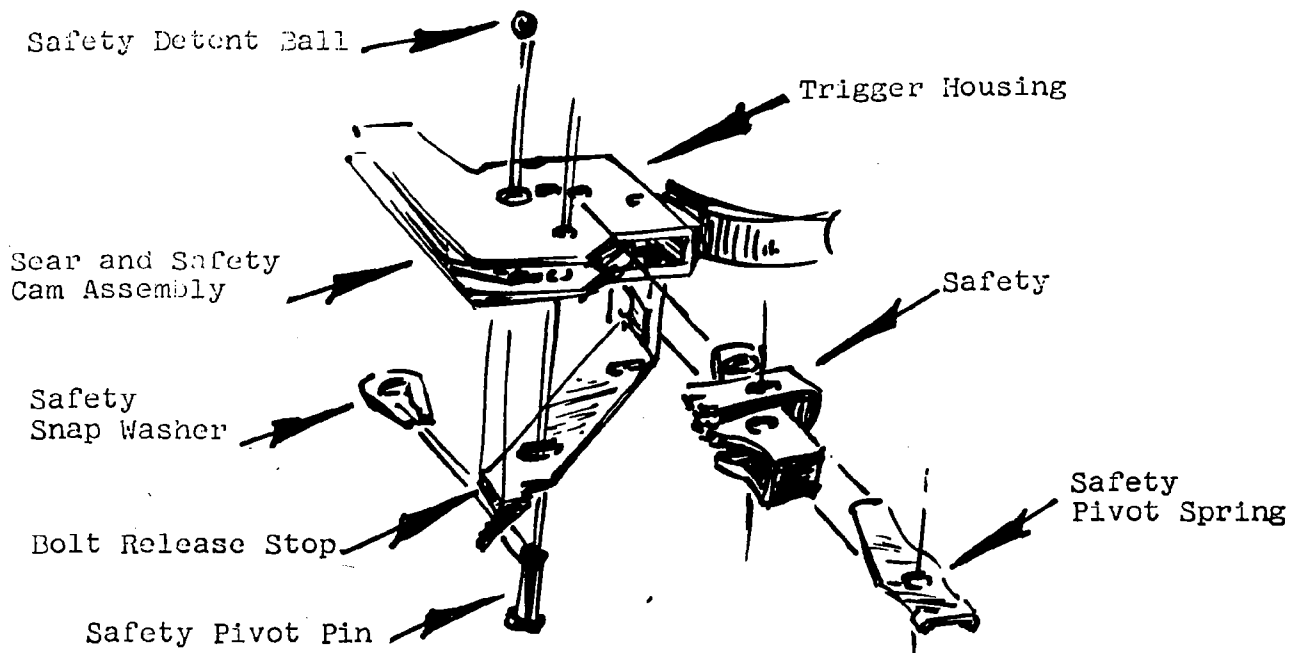
To Replace Interchangeable with no factory adjustment required. Replace safety lock thumbpiece assembly as assembly unit.

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.

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. 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.

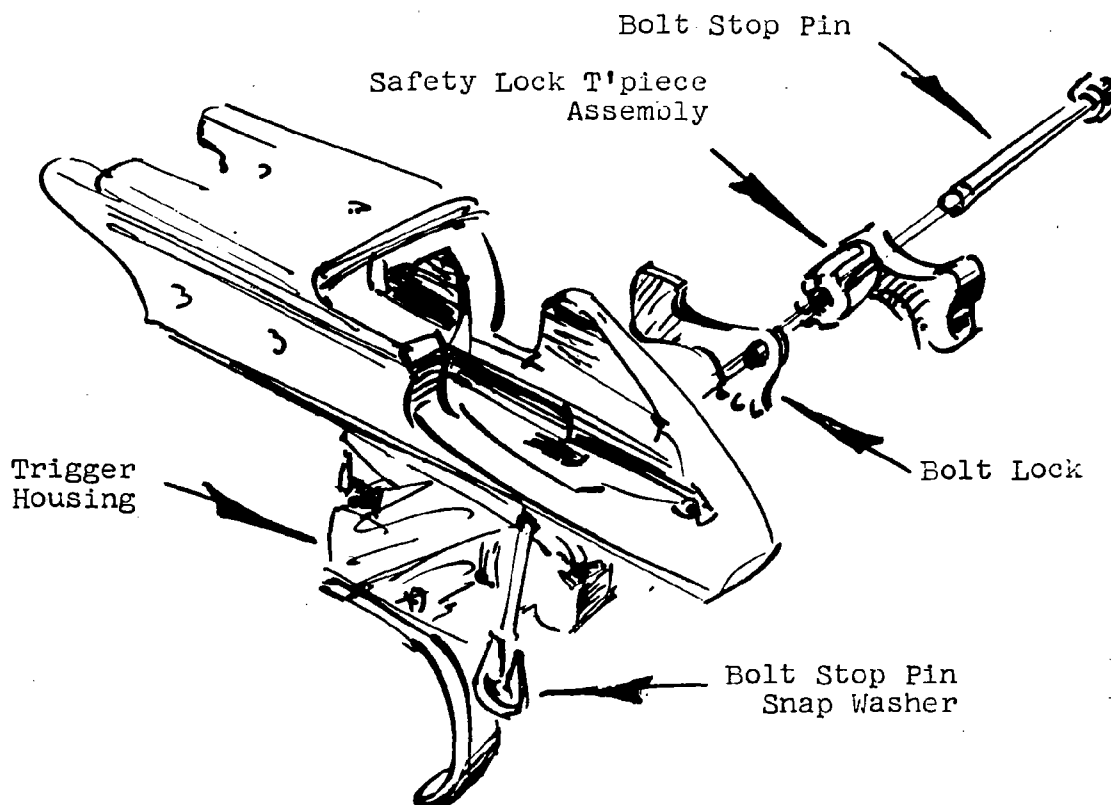
To Reassemble Follow reverse order. Ratchet teeth on safety should assemble properly to ratchet teeth on bolt lock and gear on safety lock thumbpiece assembly for proper operation of three position safety stops.

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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. (See sketch 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 Lock

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.

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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 bolt which 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 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.

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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 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

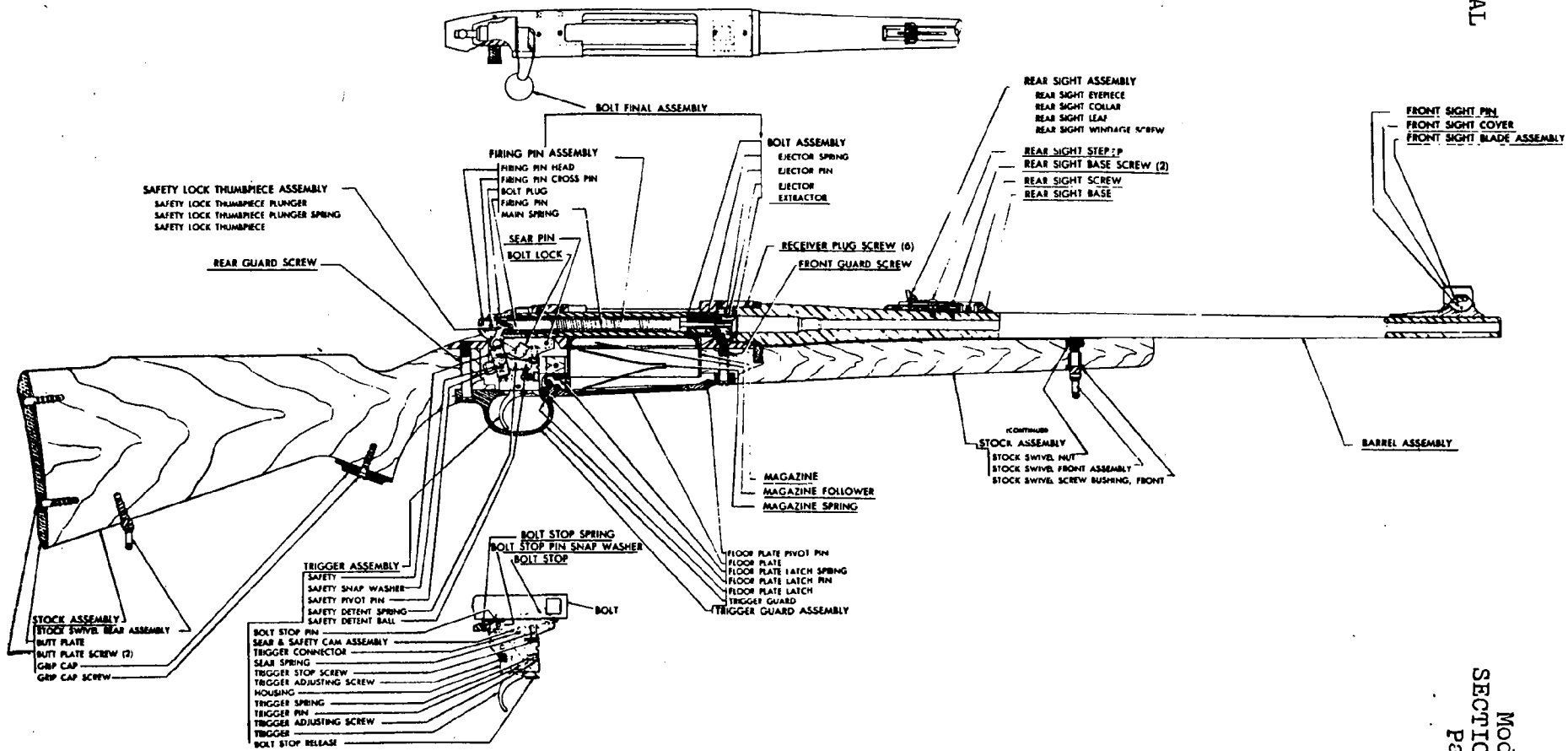
1. Fails to target properly.

Service: a) Adjust or 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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Model 725
INTRODUCTION

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

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 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.

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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).

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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 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.

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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 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 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 holes, assemble butt plate screw (2), and turn until butt plate is tight.

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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.

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FIELD SERVICE MANUAL

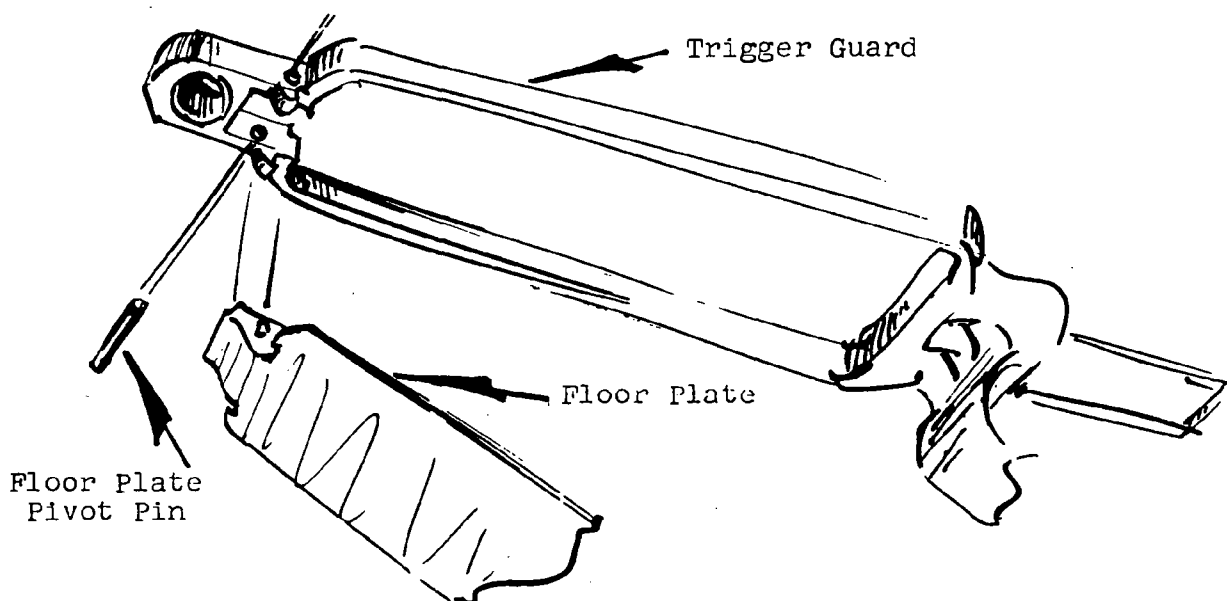
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ASSEMBLY
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TRIGGER GUARD ASSEMBLY - COMPONENTS: Remove trigger guard assembly.
Remove magazine follower,
magazine spring from floor
plate.

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,
support trigger guard properly to prevent damage
to guard at front section. See sketch below.



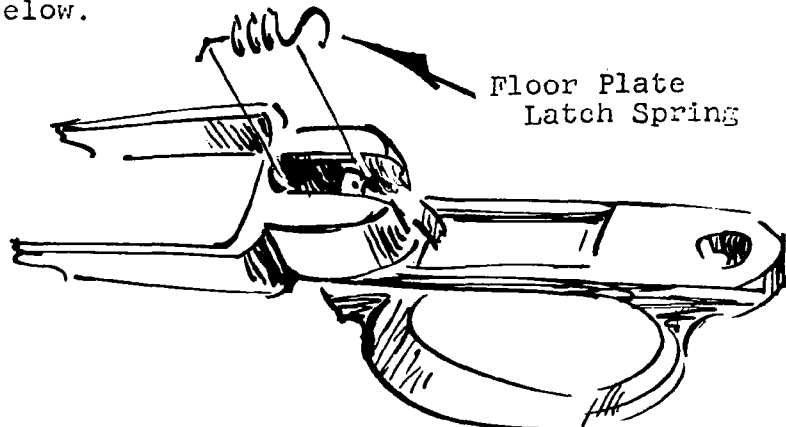
To Replace Interchangeable, with no factory adjustment
required.

To Reassemble Follow reverse order. Make certain floor
plate is free swinging and locks into floor plate latch
properly.

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.

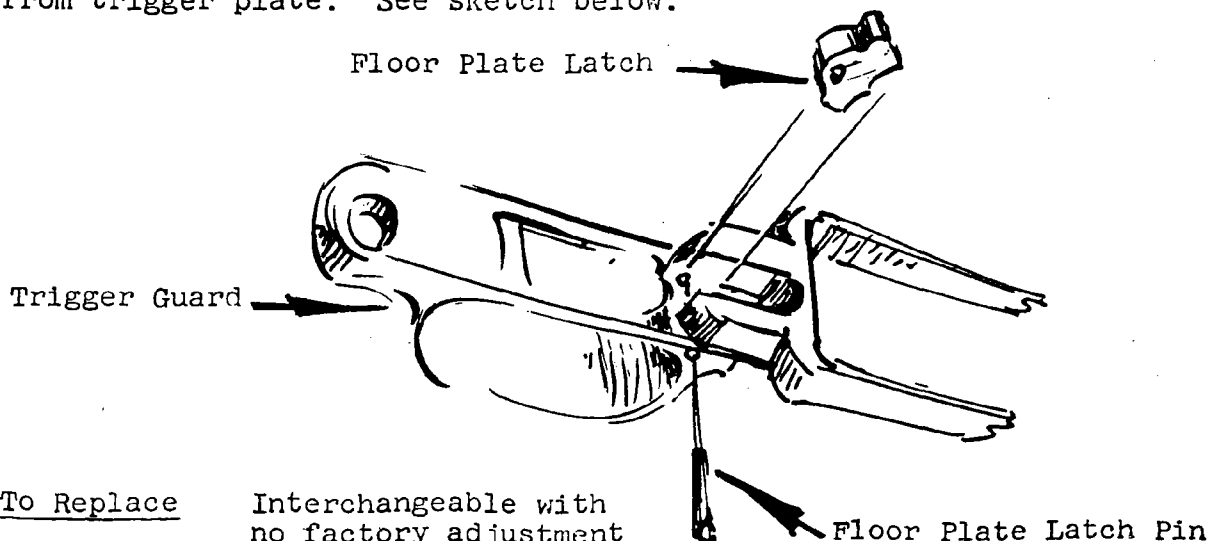


To Replace Interchangeable with no factory adjustment required.

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 floor plate latch pin, left to right. Disassemble floor plate latch from trigger plate. See sketch below.



To Replace Interchangeable with no factory adjustment required.

To Reassemble Follow reverse order.

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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.

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 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 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

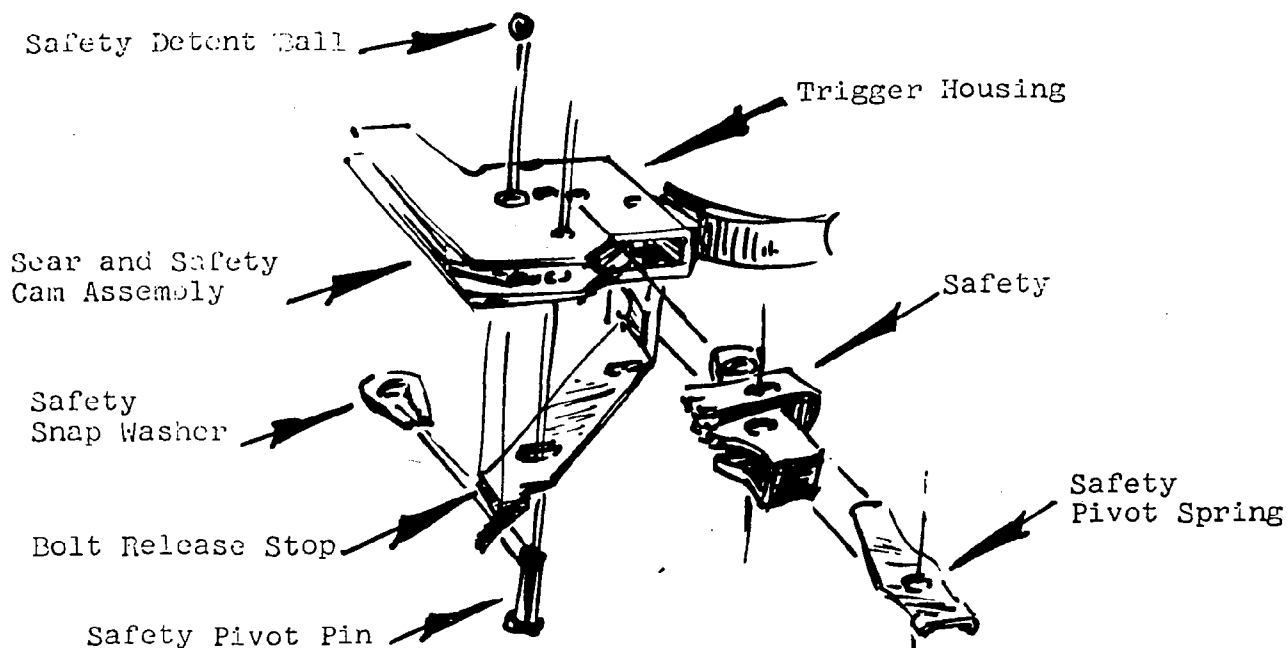
To Replace Interchangeable with no factory adjustment required. Replace safety lock thumbpiece assembly as assembly unit.

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.

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. See sketch below.

Note: Bolt stop release on opposite side of housing will be free when safety pivot pin is removed.



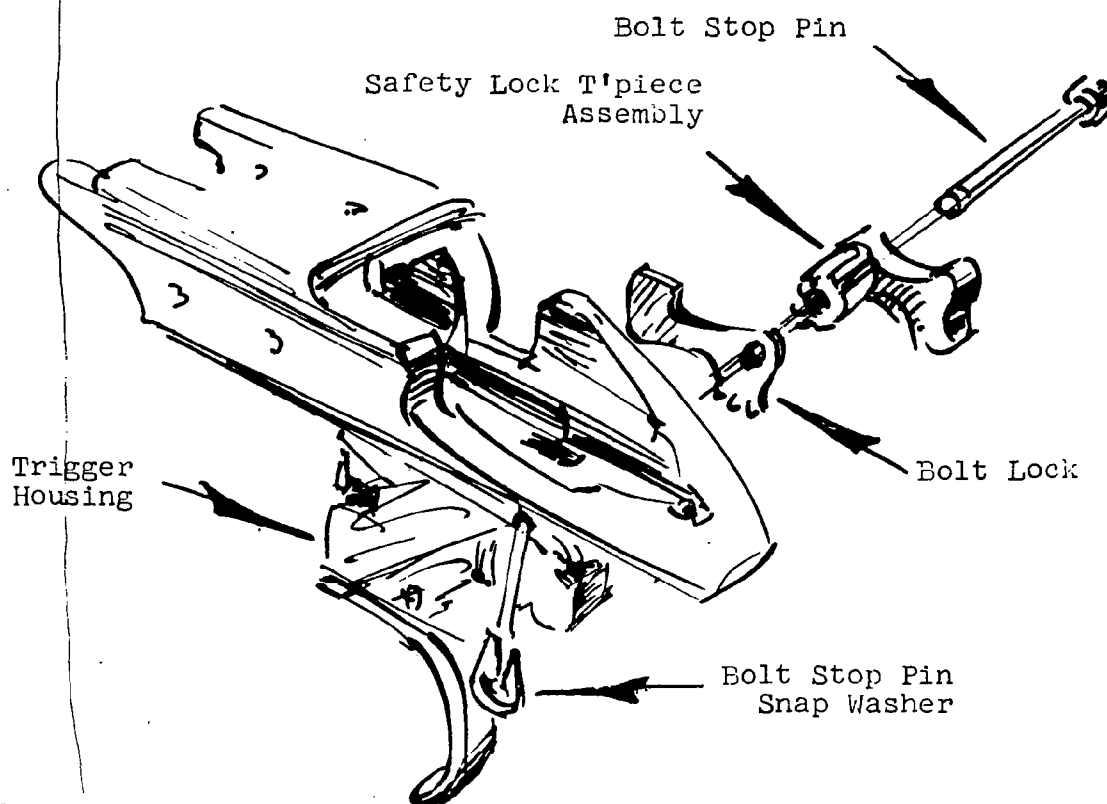
To Replace Interchangeable with no factory adjustment required.

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.

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 Lock

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.

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 bolt which 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.

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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.

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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.

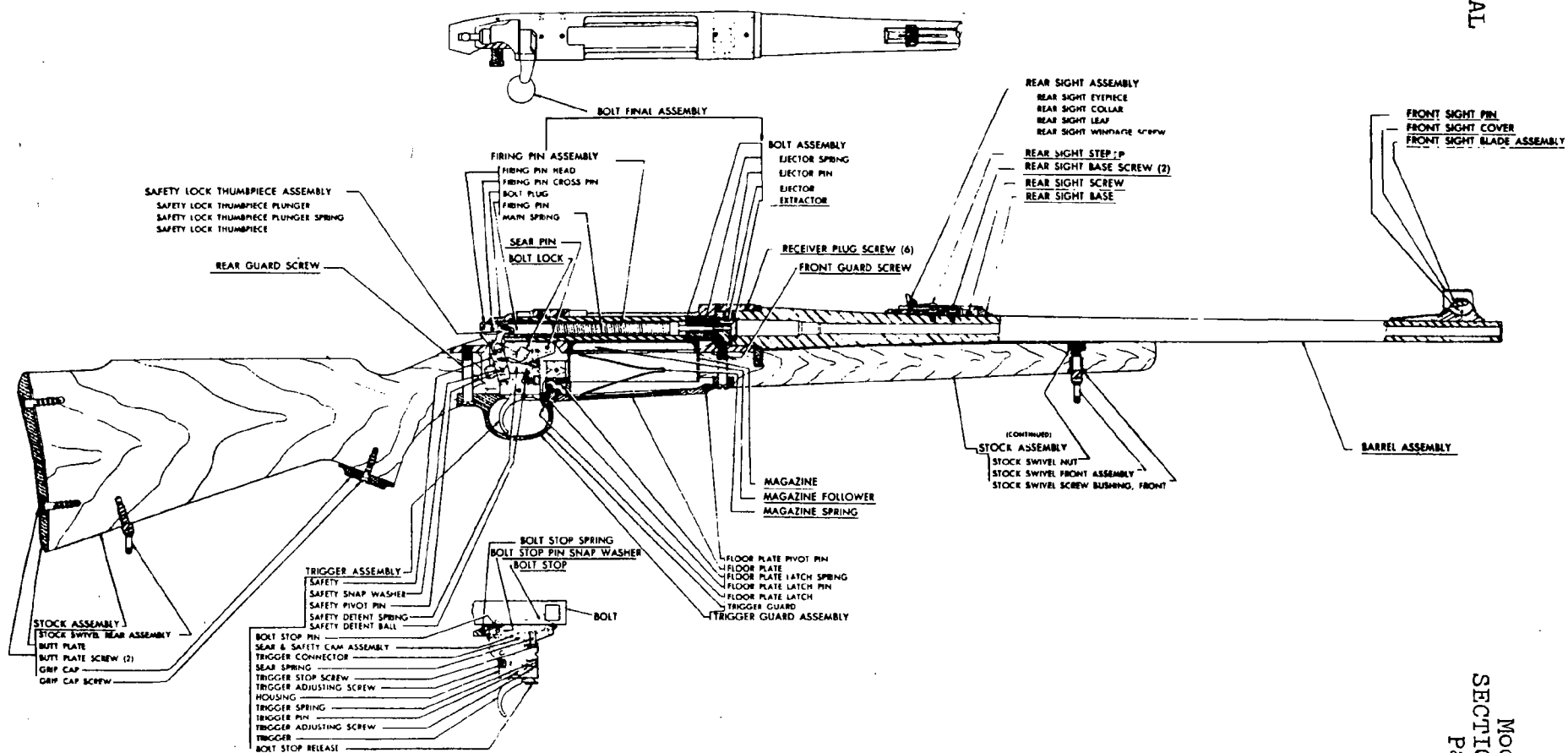
Service: Repair or replace safety lock thumbpiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball, safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety cam assembly.

STOCK ASSEMBLY

1. Fails to target properly.

Service: a) Adjust or 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.

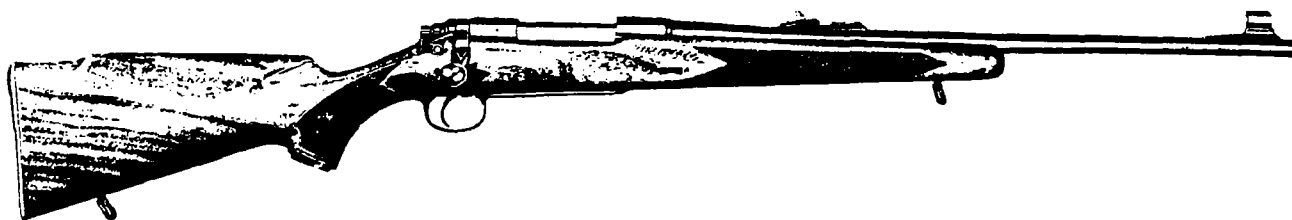
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REMINGTON FIELD SERVICE MANUAL

The Remington Model 725 is a high power, bolt action repeating rifle. The basic operation of the bolt and repeating action is 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. 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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Stock Swivel Nut	1	Trigger Assembly	3
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Butt Plate	2	Malfunctions	5

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

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 factory-assembled 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 com-

ponent 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.

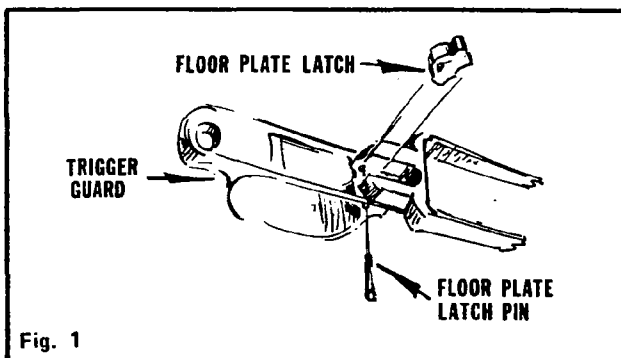
Floor Plate Latch Spring

To Disassemble — Remove 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.

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 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.

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.

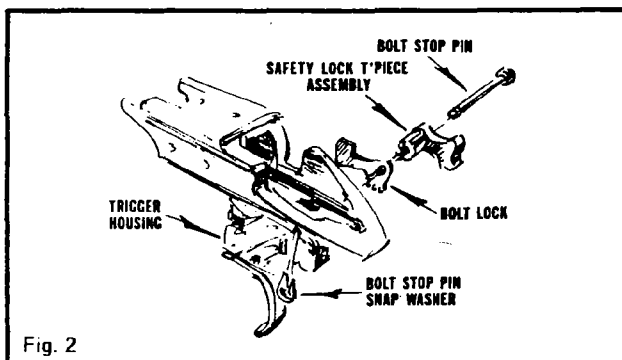


Fig. 2

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 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 re-transfer 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.

MODEL 725

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 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.

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.

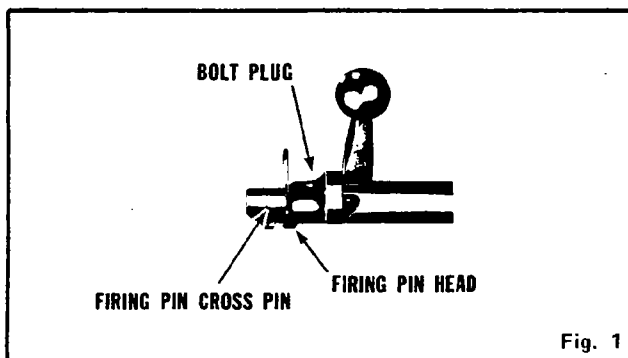


Fig. 1
FIRING PIN

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.

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.

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 of 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

Simultaneously 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.

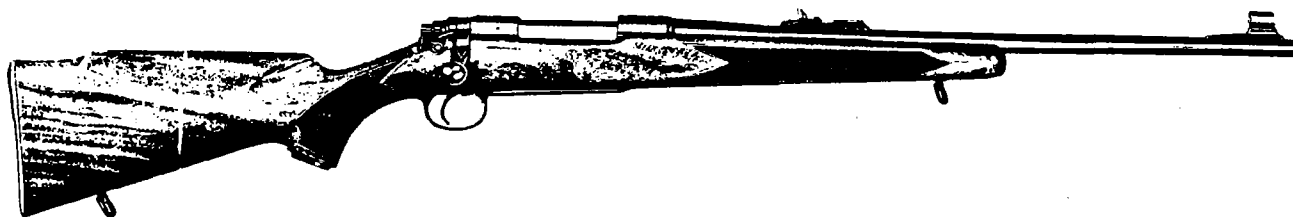
SAFETY

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.

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. 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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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 factory-assembled 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 com-

ponent 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.

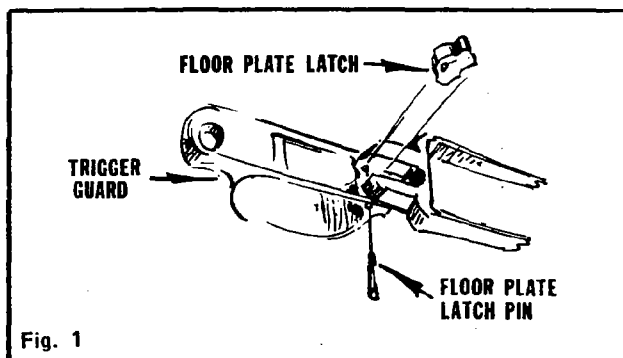
Floor Plate Latch Spring

To Disassemble — Remove 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.

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.

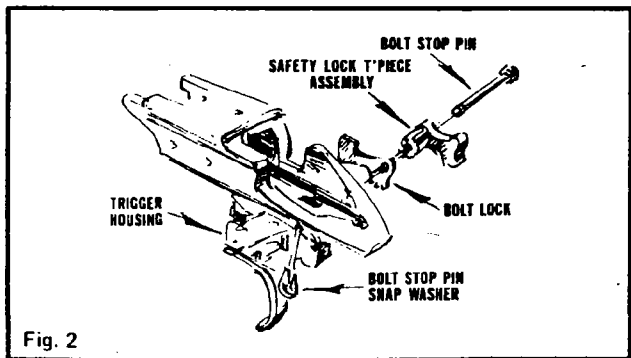
BOLT FINAL ASSEMBLY

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 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.

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 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 re-transfer 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.

MODEL 725

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

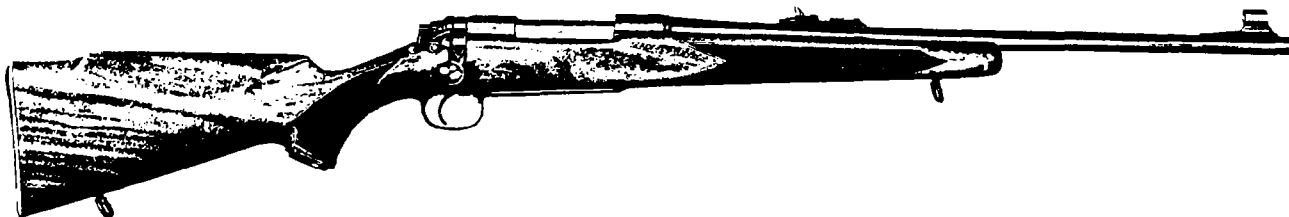
1. Damaged or missing components.
Service: Repair or replace safety lock thumbpiece assembly, bolt stop pin, bolt stop pin snap washer, bolt stop, safety, safety detent ball, safety detent spring, safety snap washer, safety pivot pin, housing, sear and safety cam assembly.

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.

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. 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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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

1982

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 factory-assembled 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 com-

ponent 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.

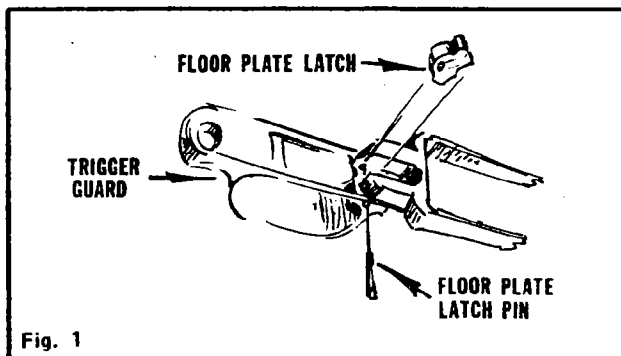
Floor Plate Latch Spring

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 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.

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 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 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 re-transfer 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

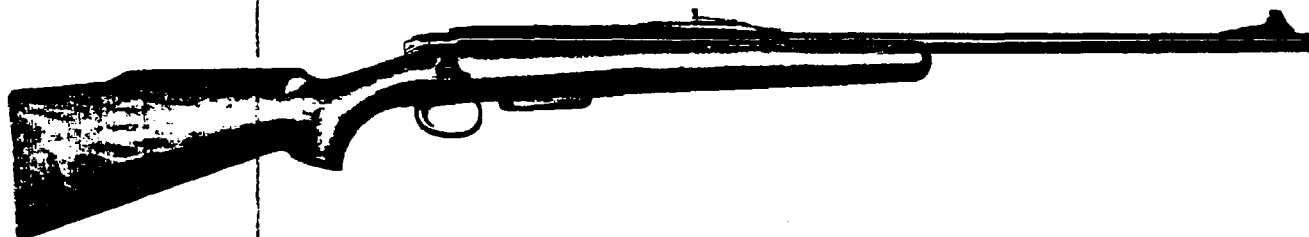
1. Damaged or missing components.
Service: Return the firearm to the factory.

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.

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 rear 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
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

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.

To Reassemble — 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 markings are on side of magazine.

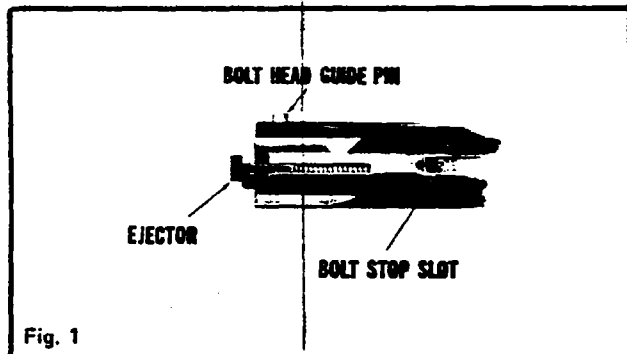
BOLT FINAL ASSEMBLY — is designed to include locking, firing, extracting, and cocking parts of the action and to close action against a chambered cartridge.

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:

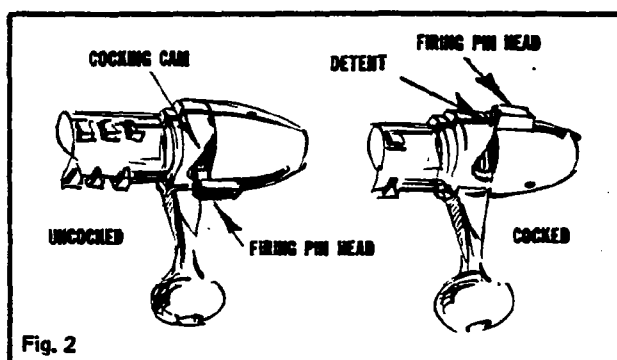
1. Straight line, two piece (rotating head) bolt — used with rimmed caliber cartridges (30-30 and 44 Rem. Mag.).
2. One piece bolt — used with rimless caliber cartridges (222 Rem. and 22/250 Rem. 6mm.308, 243 Win.).

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.



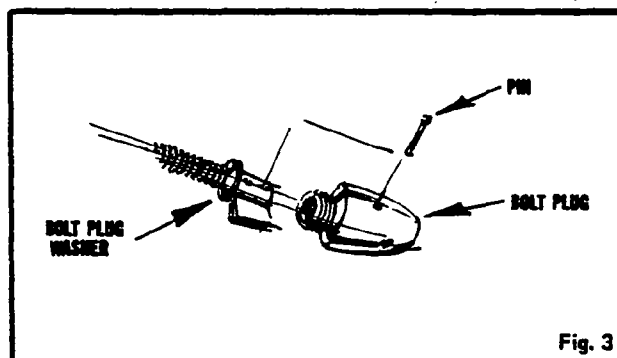
NOTE: Bolt must remain cocked to assemble into rifle. If bolt uncocks, firing pin head will snap forward into cocking cam in rear of bolt. To cock bolt hold firing pin head firmly to prevent movement. Use vise jaws if available. Raise bolt handle. Bolt will cam cocking surface (beneath handle) against 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 rifle.

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.

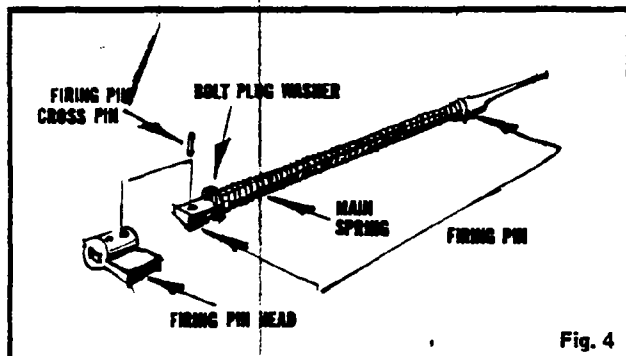
MAINSRING — FIRING PIN HEAD — BOLT PLUG WASHER.

To Disassemble — Drive out firing pin cross pin. Caution: Mainspring is assembled under tension against bolt plug washer

—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. Remove 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)

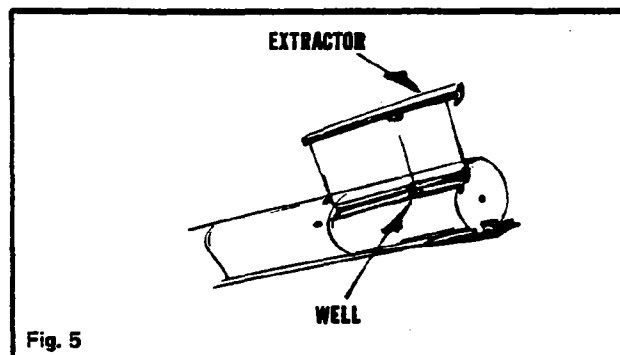
To Disassemble — Drive out ejector pin (small open roll pin). Disassemble ejector and ejector spring from bolt face.

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 cartridge 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

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 varies with cartridge caliber. For rimless cartridge such as 222 Rem. 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 lip 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 bar 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 cycle.

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 bolt completes load cycle, bolt handle can be turned down to lock action closed. With bolt handle down, cartridge is securely locked into cartridge 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.

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.

"F" (FIRE) and "S" (SAFE) markings are provided on 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. Sharp edge-rear end of chamber.
 2. Rough ramp in receiver.
 3. Magazine box loose or out of position.
 4. Magazine spring catches front corner, Box 30-30 Cal.
 5. Front of magazine box tips down.
 6. Magazine removes hard.
- Correction:**
1. Remove sharpness.
 2. Polish ramp.
 3. Adjust.
 4. Clip corners of spring.
 5. Adjust or replace magazine guide bar.
 6. Relieve wood where binding. Line up magazine guide bar.

BOLT CLOSING 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.

MODEL 788

- 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.

FAILS TO EXTRACT

- Cause:**
1. Extractor broken or damaged.
 2. Not enough hook space on extractor.
 3. Height of claw not correct.
 4. Bolt head catches on rim of shell, extracting 30-30, 44 Cal.

- Correction:**
1. Fit new extractor.
 2. Fit new extractor.
 3. Fit new extractor.
 4. Stone slightly more clearance on fingernail cut or replace bolt.

FAILS TO EJECT

- Cause:**
1. Burr at ejector hole in bolt.
 2. Ejector binds or fails to retract far enough.
 3. Not enough hook space 30-30, 44 Cal.
 4. Ejector or extractor broken, 30-30, 44 Cal.

- Correction:**
1. Deburr.
 2. Free up or replace.
 3. File to fit rim or shell with extractor pushed back in bolt.
 4. Replace.

MISFIRES

- Cause:**
1. Short firing pin. (Damaged)
 2. Firing pin binds. (Damaged)
 3. Short firing pin protrusion.
 4. Firing control out of adjustment.
 5. Faulty ammunition.
 6. Sear binds.

- Correction:**
1. Replace.
 2. Free up or replace.
 3. Change firing pin or bolt.
 4. Return firearm to the factory.
 5. Replace ammunition.
 6. Return firearm to the factory.

FOLLOWS DOWN

- Cause:**
1. Poor trigger engagement of sear.
 2. Trigger does not retract.
 3. Corners on sear of trigger rounded.

- Correction:**
1. Return firearm to the factory.
 2. Return firearm to the factory.
 3. Return 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. Blow or set back primer on shell.
 5. Cocking piece binds in bolt plug.
 6. Cam angle on bolt rough.
 7. Firing pin binds in bolt.

- Correction:**
1. See "Fails to Extract".
 2. Smooth up.
 3. Deburr.
 4. Ream chamber if throat is shallow ammunition may be at fault.)
 5. Free up or replace.
 6. Smooth up.
 7. Replace firing pin.

BOLT PULLS OUT

- Cause:**
1. Bolt stop binds.
 2. Bolt stop broken.
 3. Bolt stop slot in bolt upset.

- Correction:**
1. Return firearm to the factory.
 2. Return firearm to the factory.
 3. Return firearm to the factory.

SAFETY SWITCH WORKS TOO HARD OR TOO FREELY

- Cause:**
1. Safety switch binds.
 2. Plunger spring weak or missing (safety switch works too freely).

- Correction:**
1. Return firearm to the factory.
 2. Return firearm to the factory.

FIRES ON SAFE OR SAFETY SWITCH WON'T GO ON

- Cause:**
1. Safety switch plunger missing.
 2. Bent safety switch.

- Correction:**
1. Return firearm to the factory.
 2. Return firearm to the factory.

BULGES OR BLOWS CASES

- Cause:**
1. Oversize chamber.
 2. Max. head space.

- Correction:**
1. Replace barrel assembly.
 2. Fit new bolt.

BOLT BINDS

- Cause:**
1. Scope screws protrude into bolt track.
 2. Bolt handle interference on stock.
 3. Bolt head retaining pins protruding.
 4. Bolt head catches on rim of shell in magazine when extracting 30-30, 44 Cal.
- Correction:**
1. File ends of screws.
 2. Correct stock or fit new stock.
 3. Seat pins; stone slightly more.
 4. Stone slightly more clearance at fingernail cut or replace bolt.

FAILS TO GROUP

- Cause:**
1. Bore damaged at crown.
 2. Leading of bore.
 3. Oversize bore.
 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.
 3. Replace barrel.
 4. Correct bedding.
 5. Tighten or replace.
 6. Shorten screw.

POINT OF IMPACT NOT CORRECT

- Cause:**
1. Barrel not straight.
 2. Horns, breaks, etc., in bore.
 3. Improper or loose sights.
- Correction:**
1. Straighten, if possible, or replace.
 2. Straighten, if possible, or replace.
 3. Tighten or change sights.

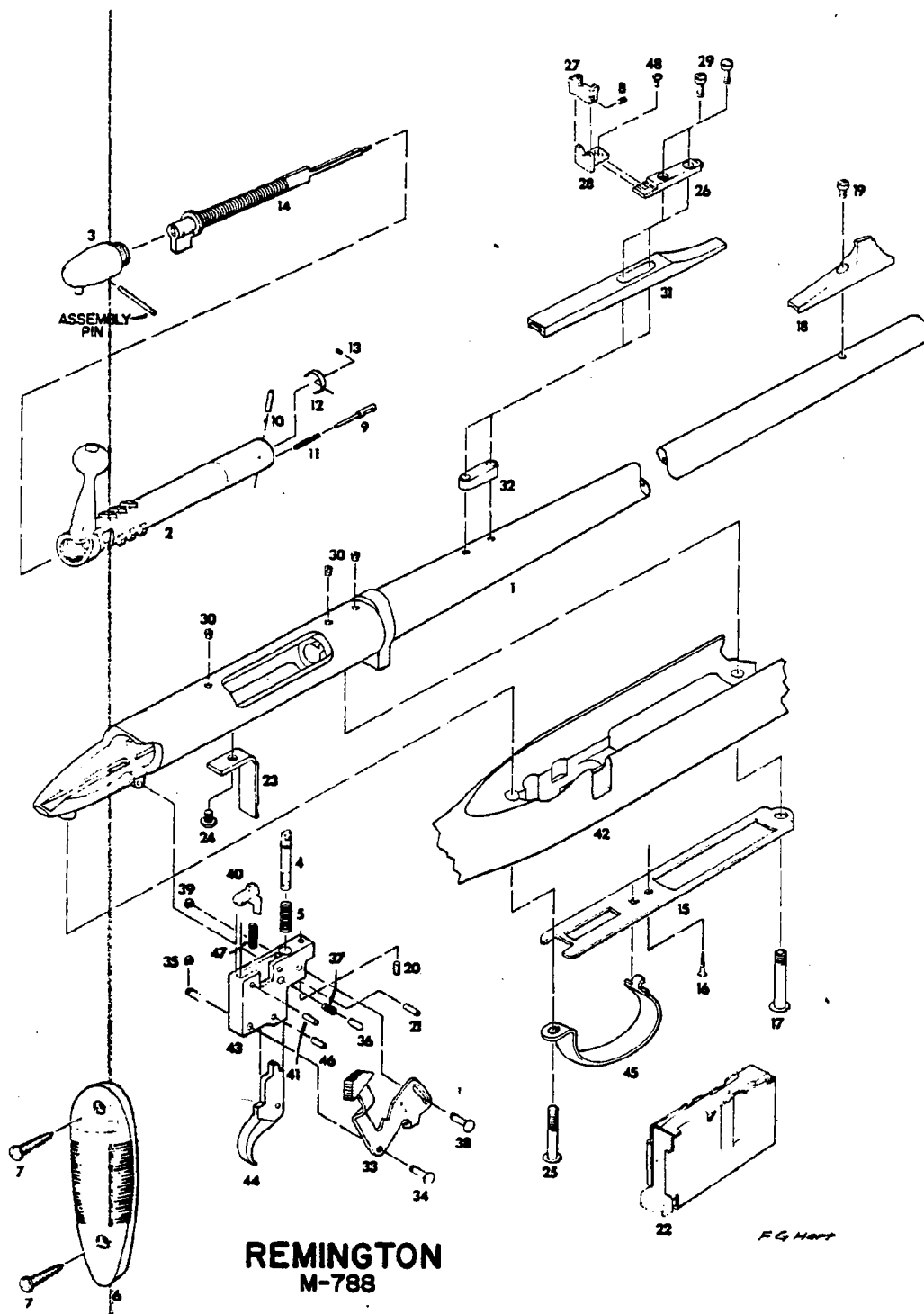
NOTE: When loading 44 Rem. Mag. cartridges, make sure that rim of each cartridge remains forward of rim of each underlying cartridge.

REMINGTON FIELD SERVICE MANUAL

NOTE: The sale of barrels, bolts and receivers is restricted. Special equipment is required for assembly. Return rifle to factory.

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE Basic 308 caliber listed below. For other caliber parts and numbers, see additional calibers list.			29297		Firing Pin Assembly, 44 Rem. Mag.
			29310		Floor Plate, 222 & 223 Rem.
			29311		Floor Plate, 22/250 Rem.
			29312		Floor Plate, 30-30 Win.
			29313		Floor Plate, 44 Rem. Mag.
			29401		Front Sight, 222 & 223 Rem.
			29402		Front Sight, 44 Rem. Mag.
			29535		Magazine Assembly, 222 Rem.
			29542		Magazine Assembly, 223 Rem.
			29536		Magazine Assembly, 22/250 Rem.
			29540		Magazine Assembly, 243 Win.
			29541		Magazine Assembly, 6mm Rem.
			29537		Magazine Assembly, 30-30 Win.
			29538		Magazine Assembly, 44 Rem. Mag.
			29345		Magazine Guide Bar, 222 & 223 Rem.
			29347		Magazine Guide Bar, 30-30 Win. & 44 Rem. Mag.
			29385		Stock Assembly, 222, 223 Rem. & 30-30 Win.
			29386		Stock Assembly, 44 Rem. Mag.
			34885		Stock Assembly, 22/250 Rem.
1		Barrel Assembly	SERVICE PARTS		
		Bolt Assembly	Bolt Assembly, 222 & 223 Rem. (old style)		
		Bolt Final Assembly	Bolt Assembly, 22/250 Rem. (old style)		
11336		Bolt Plug	Bolt Assembly, 308 Win., 243 Win., 6mm Rem. (old style)		
14246		Bolt Stop (Restricted)	Bolt Final Assembly, 222 & 223 Rem. (old style)		
14024		Bolt Stop Spring (Restricted)	Bolt Final Assembly, 22/250 Rem. (old style)		
14245		Butt Plate	Bolt Final Assembly, 308 Win., 243 Win., 6mm Rem. (old style)		
29410		Butt Plate Screw	Bolt Plug (old style)		
14236		Elevation Screw	Firing Pin Assembly, 222, 223 & 22/250 Rem. (old style)		
14211		Ejector	Firing Pin Assembly, 308, 243 Win., 6mm Rem. (old style)		
17676		Ejector Pin	Bolt Assembly, LH (old style)		
14214		Ejector Spring	Bolt Final Assembly, LH (old style)		
14669		Extractor	Bolt Plug, LH (old style)		
27340		Extractor Rivet	Firing Pin Assembly, LH (old style)		
34351		Firing Pin Assembly	LEFT HAND CALIBERS		
29314		Floor Plate	NOTE: Parts not listed same as Standard Caliber		
14099		Floor Plate Screw	Barrel Assembly, 6mm Rem., LH		
14224		Front Guard Screw	Barrel Assembly, 308 Win., LH		
29400		Front Sight (also .22/250 Rem.)	Bolt Assembly, LH		
29396		Front Sight Screw	Bolt Final Assembly, LH		
14250		Front Sight Washer	Bolt Plug, LH		
14027		Housing Lock Screw (Restricted)	Firing Pin Assembly, LH		
14031		Housing Pin (Restricted)	ACCESSORY		
29539		Magazine Assembly	25571 Sling Strap Assembly and Mountings, Complete		
29346		Magazine Guide Bar			
14234		Magazine Guide Bar Screw			
14235		Rear Guard Screw			
29350		Rear Sight Assembly			
14237		Rear Sight Base			
14238		Rear Sight Eyepiece			
15728		Rear Sight Leaf			
29395		Rear Sight Screw			
14242		Receiver Plug Screw			
91041		Rib (Rear Sight)			
14244		Rib Spacer (Rear Sight)			
29370		Safety Switch Assembly (Restricted)			
14015		Safety Switch Pivot Pin (Restricted)			
14044		Safety Switch Pivot Pin Retaining Washer (Restricted)			
14497		Safety Switch Detent (Restricted)			
14498		Safety Switch Detent Spring (Restricted)			
91370		Safety Switch Retainer Pin (Restricted)			
14044		Safety Switch Retainer Pin Retaining Washer (Restricted)			
14503		Sear (Restricted)			
24477		Sear Pin (Restricted)			
34891		Stock Assembly			
29365		Trigger Housing Assembly (Restricted)			
14026		Trigger Housing (Restricted)			
14033		Trigger (Restricted)			
14971		Trigger Guard			
14031		Trigger Pin (Restricted)			
14045		Trigger Spring (Restricted)			
14240		Windage Screw			
ADDITIONAL CALIBERS					
NOTE: Parts not listed same as 308 caliber.					
Barrel Assembly					
Bolt Assembly					
Bolt Final Assembly					
14225		Bolt Assembly Pin, 30-30 & 44 Rem. Mag.			
29290		Bolt Head Assembly, 30-30 Win. & 44 Rem. Mag.			
14210		Ejector, 222 & 223 Rem.			
14212		Ejector, 30-30 Win. & 44 Rem. Mag.			
14213		Ejector Pin, 30-30 Win. & 44 Rem.			
14215		Ejector Spring, 30-30 Win. & 44 Rem.			
15850		Extractor, 222 & 223 Rem.			
14216		Extractor, 30-30 Win. & 44 Rem. Mag.			
27342		Extractor Rivet, 222 & 223 Rem.			
34350		Firing Pin Assembly, 222, 223 & 22/250 Rem.			
29266		Firing Pin Assembly, 30-30 Win.			

REMINGTON FIELD SERVICE MANUAL



Remington

PLAINTIFF'S
EXHIBIT
D-11

MODEL 788

INCLUDES LEFT HAND MODEL

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 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 position. Push bolt forward into rifle.

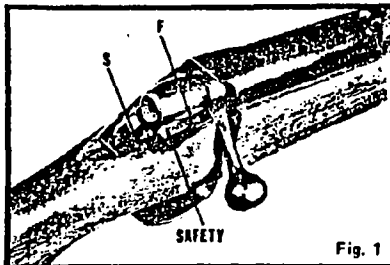


Fig. 1

TO COCK BOLT — Bolt must remain cocked to put 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 (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 then cocked and ready for re-entry to rifle.

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 muzzle is pointed in a safe direction.

SAFETY (Fig. 1) — Close bolt and push safety to rear stop position, marked "S" on 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 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 rifle.

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 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 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 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, 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

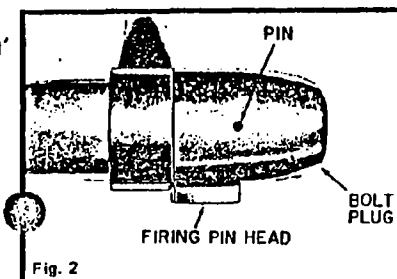


Fig. 2

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 five 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 low, rear sight should be raised. If rifle shoots

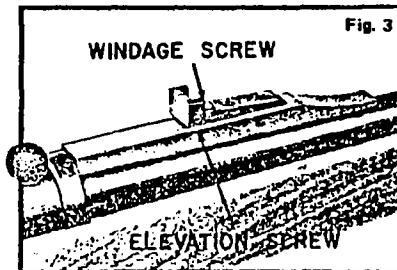


Fig. 3

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 leaf). 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 clean from breech to muzzle. Scrub barrel bore with cartridge chamber with a good bore solvent, if 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 out of floor plate. Lift stock away from action barrel. Clean bolt and action in solvent and wipe clean. Reverse procedure to reassemble.

TO DISASSEMBLE BOLT PARTS — Before assembly may be cleaned and oiled as a unit. Should disassembly be required, proceed as follows: With bolt cocked (handle down), insert firing pin (close fitting through holes in both sides of bolt plug (Fig. 2). Lift handle and remove bolt from rifle. Unscrew and remove bolt plug — firing pin assembly. To reassemble, screw assembly into bolt until firing pin head contacts rear of bolt. Back off (counter-clockwise) until firing pin head snaps into detent on rear edge of 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 on bolt to prevent wear. Wash action and bolt parts with a good grade of petroleum solvent; dry and re-oil very lightly. After handling, wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed. After using in wet weather, dry and wipe steel parts with oil to prevent rusting. 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 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.

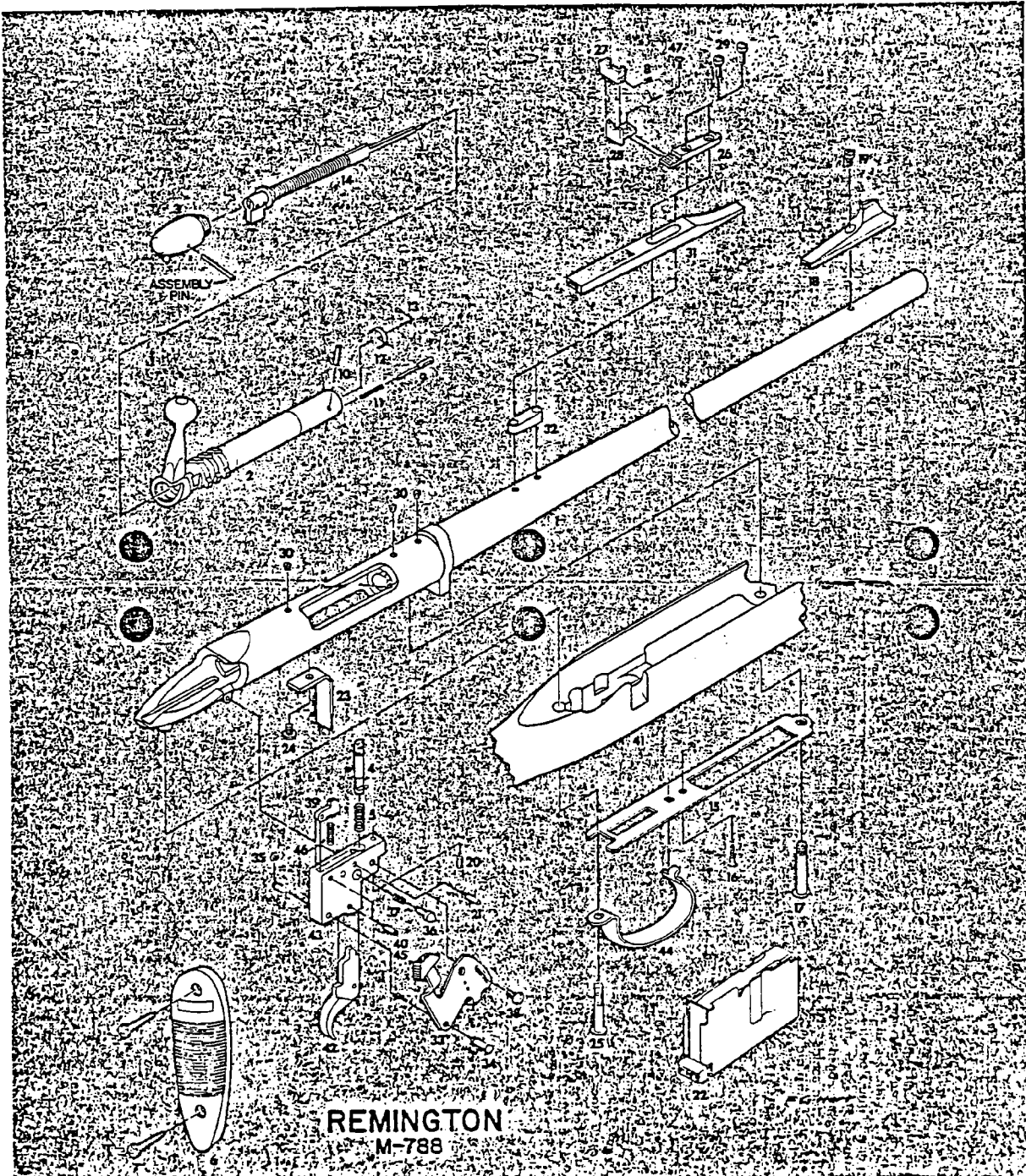
IMPORTANT — Remington firearms are designed, manufactured and proof tested to standards based on factory loaded ammunition. Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

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 made by Remington factory personnel, nor the replacement 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 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



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 788

BOLT ACTION
HIGH POWER RIFLE

PARTS LIST

NOTE: Prices for barrels and bolts will be quoted upon application. Factory assembly required.

SEE INSTRUCTIONS FOR ORDERING PARTS

View No.	Part No.	NAME OF PART	List Price	View No.	Part No.	NAME OF PART	List Price
NOTE: Base .308 caliber listed below. For other caliber parts and numbers see additional calibers list.				ADDITIONAL CALIBERS			
1		Barrel Assembly				NOTE: Part Not Listed Same as .308 Caliber	
2		Bolt Assembly				Barrel Assembly, 222 Rem.	
		Bolt Final Assembly				Barrel Assembly, 223 Rem.	
3	14217	Bolt Plug	\$ 1.30			Barrel Assembly, 22/250 Rem.	
4	14246	Bolt Stop	.90			Barrel Assembly, 243 Win.	
5	14024	Bolt Stop Spring	.35			Barrel Assembly, 6mm Rem.	
6	14245	Bolt Plate	.50			Bolt Assembly, 222/223 Rem.	
7	25410	Bolt Plate Screw	.35			Bolt Assembly, 22/250 Rem.	
8	14236	Elevation Screw	.35			Bolt Final Assembly, 222/223 Rem.	
9	14211	Ejector	.50	14210		Bolt Final Assembly, 22/250 Rem.	
10	17676	Ejector Pin	.35			Ejector, 222/223 Rem.	\$.50
11	14214	Ejector Spring	.35	15850		Extractor, 222/223 Rem.	1.90
12	14669	Extractor	1.90	27342		Extractor Rivet, 222/223 Rem.	.35
13	27340	Extractor Rivet	.35	29295		Firing Pin Assembly, 222/223 - 22/250 Rem.	5.20
14	29298	Firing Pin Assembly	5.20	29310		Floor Plate, 222/223 Rem.	1.15
15	29314	Floor Plate	1.15	29311		Floor Plate, 22/250 Rem.	1.15
16	14099	Floor Plate Screw	.35	29402		Front Sight, 222/223 Rem.	.90
17	14224	Front Guard Screw	.35	29535		Magazine Assembly, 222 Rem.	5.20
18	29400	Front Sight (also 22/250 Rem)	.90	29542		Magazine Assembly, 223 Rem.	5.20
19	29396	Front Sight Screw	.35	29536		Magazine Assembly, 22/250 Rem.	5.20
	14250	Front Sight Washer	.35	29540		Magazine Assembly, 243 Win.	5.20
20	14027	Housing Lock Screw	.35	29541		Magazine Assembly, 6mm Rem.	5.20
				29345		Magazine Guide Bar, 222/223 Rem.	.65
				29385		Stock Assembly, 222/223 Rem.	34.50
				29387		Stock Assembly, 22/250 Rem.	34.50
21	14031	Housing	.35	LEFT HAND CALIBER			
22	29539	Magazine Assembly	5.20			NOTE: Part Not Listed Same as .308 Caliber	
23	29346	Magazine Guide Bar	.65			Barrel Assembly, 6mm Rem. L.H.	
24	14234	Magazine Guide Bar Screw	.35			Barrel Assembly, 308 Win. L.H.	
25	14235	Rear Guard Screw	.35			Bolt Assembly, L.H.	
	29350	Rear Sight Assembly	2.55			Bolt Final Assembly, L.H.	
26	14237	Rear Sight Base	.90			Bolt Plug, L.H.	\$ 1.30
27	14238	Rear Sight Eyepiece	1.30	14467		Firing Pin Final Assembly, L.H.	5.20
28	15728	Rear Sight Leaf	.50	29971		Stock Assembly, L.H.	34.50
29	29395	Rear Sight Screw	.35	30482		Trigger Housing Assembly, L.H.	6.25
30	14242	Receiver Plug Screw	.35	30330		Safety Assembly, L.H.	1.30
31	14243	Rib (Rear Sight)	.65	29370			
32	14244	Rib Spacer (Rear Sight)	.50			ACCESSORY	
33	29370	Safety Assembly	1.30				
34	14015	Safety Pivot Pin	.35				
35	14044	Safety Pivot Pin Retaining Washer	.35				
36	14032	Safety Plunger	.35	25571		Sling Strap Assembly and Mounting, Complete	\$ 6.25
37	14029	Safety Plunger Spring	.35				
38	14254	Safety Retaining Screw	.35				
39	14503	Sear					
40	91126	Sear Pin	.35				
41	29388	Stock Assembly	34.50				
	29365	Trigger Housing Assembly	6.25				
42	14033	Trigger					
43	14026	Trigger Housing					
	29010	Trigger Housing Sub Assembly	3.35				
44	14248	Trigger Guard	1.15				
45	14031	Trigger Pin	.35				
46	14045	Trigger Spring	.35				
47	14240	Windage Screw	.35				

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE

DELIVERIES ARE F.O.B. UNION, N.Y.

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 require slight adjustment or fitting to assure proper 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 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.

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.

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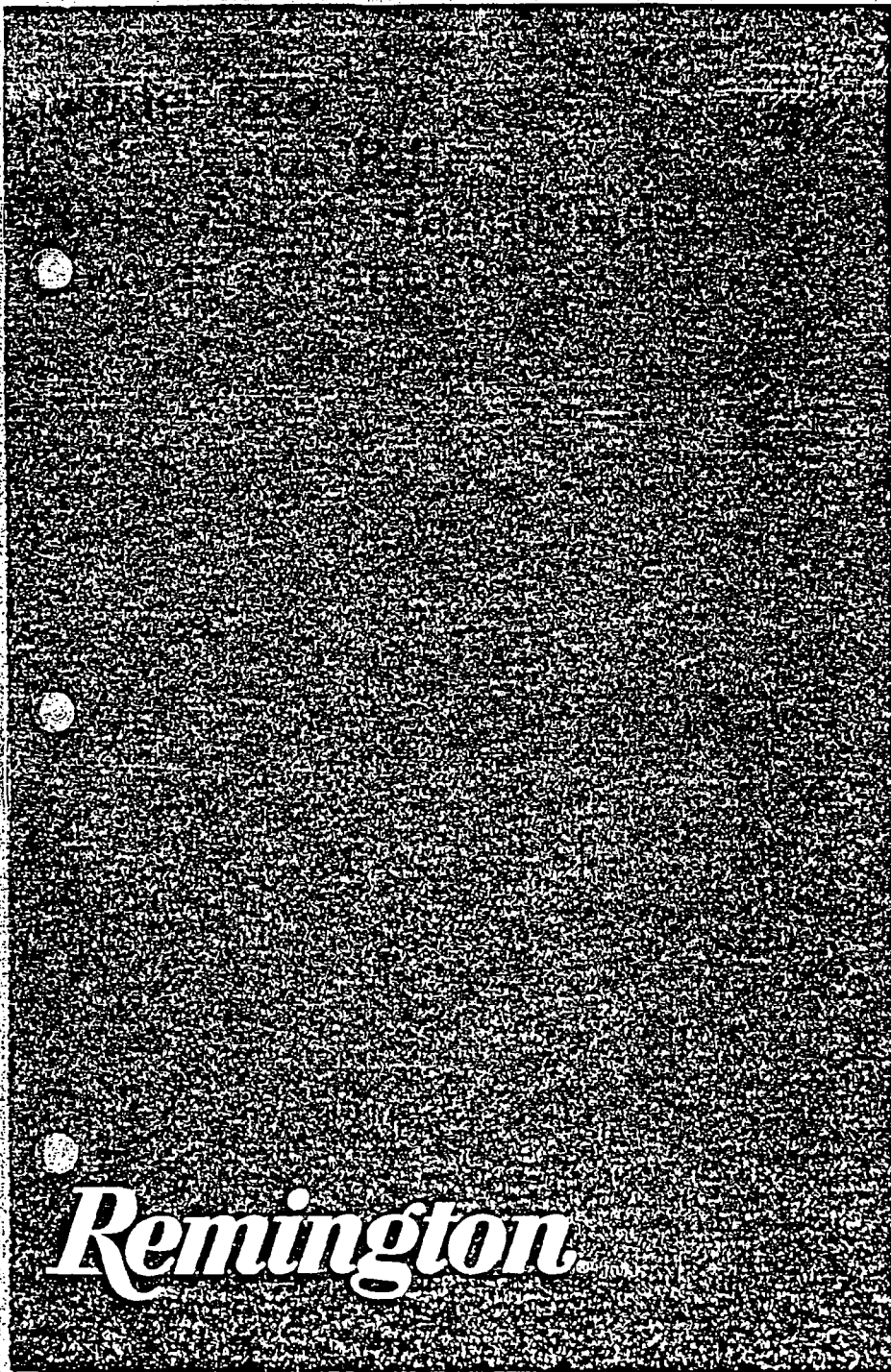
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If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail. Please send repairs direct to:

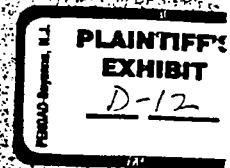
REMINGTON ARMS COMPANY, INC.
ARMS SERVICE DIVISION
Ilion, New York 13357

Printed in U.S.A.

Form RD 5558
Rev. 275



Remington



6/75

MODEL 788

INCLUDES LEFT HAND MODEL

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 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 position.

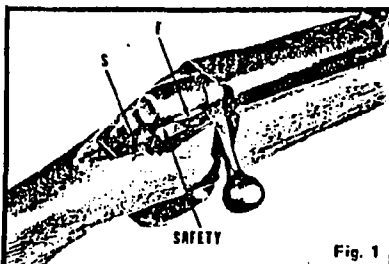


Fig. 1

Push bolt forward into rifle. Push bolt forward into rifle. Push bolt forward into rifle.

TO COCK BOLT — Bolt must remain cocked to put 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 (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 then cocked and ready for re-entry to rifle.

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 muzzle is pointed in a safe direction.

SAFETY (Fig. 1) — Close bolt and push safety 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 can be pulled to fire rifle.

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 rifle.

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 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 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 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, 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

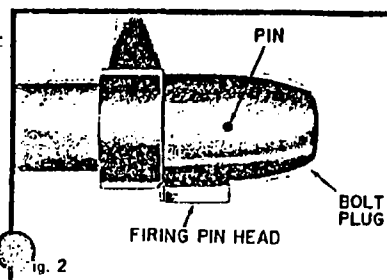


Fig. 2

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 five 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 low, rear sight should be raised. If rifle shoots

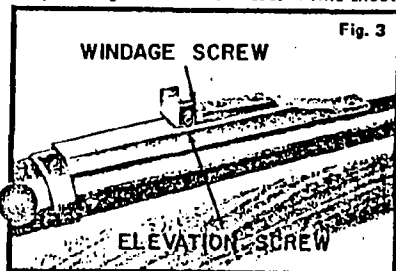


Fig. 3

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 leaf). 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 clean from breech to muzzle. Scrub barrel bore and cartridge chamber with a good bore solvent, if 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 removed by pivoting downward until it pulls free of floor plate. Lift stock away from action. Barrel. Clean bolt and action in solvent. A wipe clean. Reverse procedure to reassemble.

TO DISASSEMBLE BOLT PARTS — Bolt assembly may be cleaned and oiled as a unit. Should disassembly be required, proceed as follows: With bolt cocked (handle down), insert pin (close fitting through holes in both sides of bolt plug (Fig. 2). Lift handle and remove bolt from rifle. Unscrew and remove bolt plug — firing pin assembly. To reassemble, screw assembly into bolt until firing pin head contacts rear of bolt. Back off (counter-clockwise) until firing pin head snaps into detent on rear edge of 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 on bolt to prevent wear. Wash action and bolt parts with a good grade of petroleum solvent; dry and re-oil very lightly. After handling, wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed. After using in wet weather dry and wipe steel parts with oil to prevent rusting. 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 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.

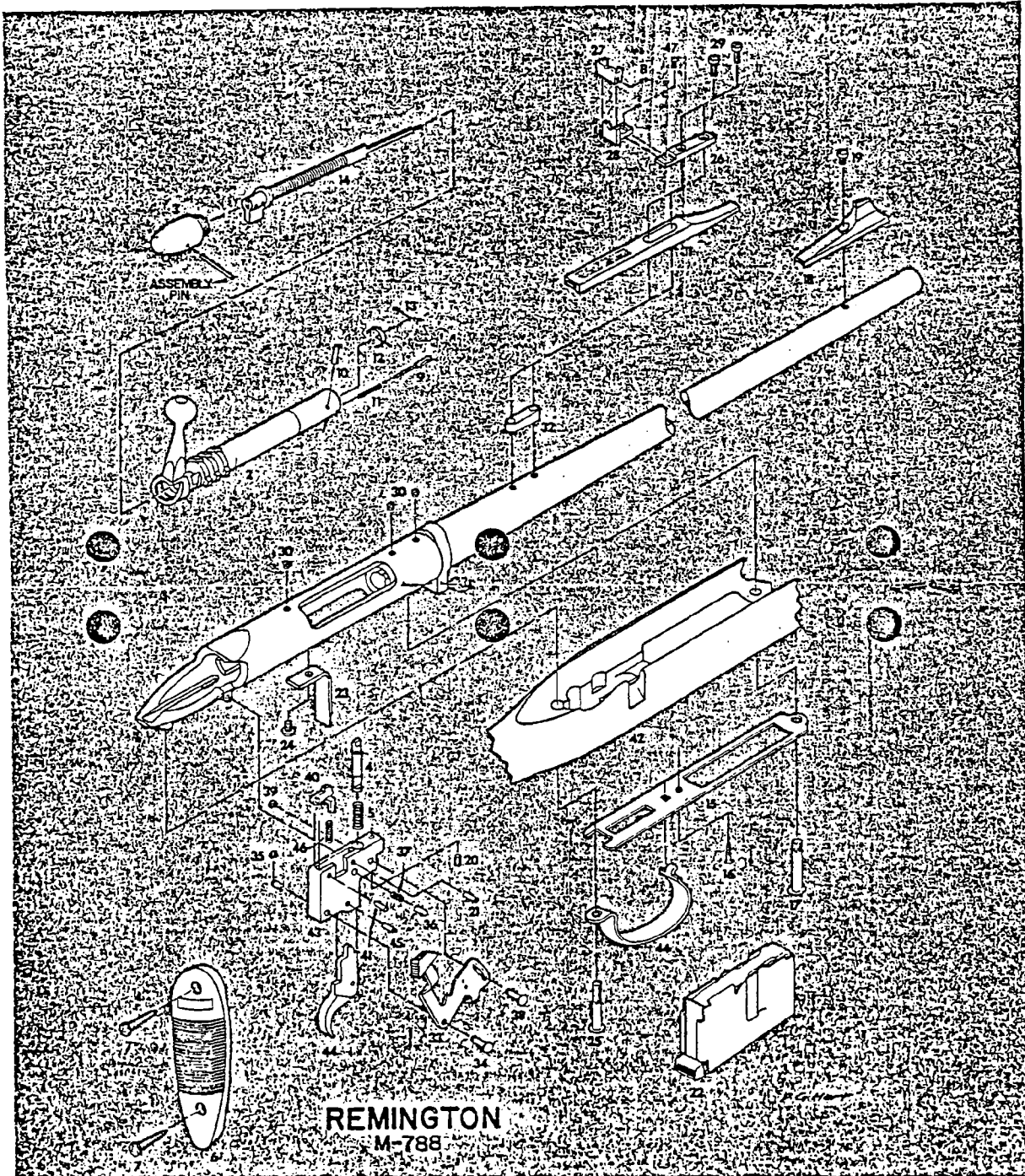
IMPORTANT — Remington firearms are designed, manufactured and proof tested to stand ards based on factory loaded ammunition. Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

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 made by Remington factory personnel, nor the replacement 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 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**



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 700

BOLT ACTION
HIGH POWER RIFLE

PARTS LIST

NOTE: Prices for barrels and bolts will be quoted upon application. Factory assembly required.

SEE INSTRUCTIONS FOR ORDERING PARTS

View No.	Part No.	NAME OF PART	List Price	View No.	Part No.	NAME OF PART	List Price
NOTE: Basic 308 caliber listed below. For other caliber parts and numbers see additional calibers list.				ADDITIONAL CALIBERS			
1		Barrel Assembly				NOTE: Part Not Listed Same as 308 Caliber	
2		Bolt Assembly				Barrel Assembly, 222 Rem.	
		Bolt Final Assembly				Barrel Assembly, 223 Rem.	
3	14217	Bolt Plug	\$ 1.30			Barrel Assembly, 22/250 Rem.	
4	14246	Bolt Stop	.90			Barrel Assembly, 243 Win.	
5	14024	Bolt Stop Spring	.35			Barrel Assembly, 6mm Rem.	
6	14245	Butt Plate	.50			Bolt Assembly, 222/223 Rem.	
7	25410	Butt Plate Screw	.35			Bolt Assembly, 22/250 Rem.	
8	14236	Elevation Screw	.35			Bolt Final Assembly, 222/223 Rem.	
9	14211	Ejector	.50			Bolt Final Assembly, 22/250 Rem.	
10	17676	Ejector Pin	.35	14210		Ejector, 222/223 Rem.	\$.50
11	14214	Ejector Spring	.35	15850		Extractor, 222/223 Rem.	1.90
12	14669	Extractor	1.90	27342		Extractor Rivet, 222/223 Rem.	.35
13	27340	Extractor Rivet	.35	29295		Firing Pin Assembly, 222/223 - 22/250 Rem.	5.20
14	29298	Firing Pin Assembly	5.20	29310		Floor Plate, 222/223 Rem.	1.15
15	29314	Floor Plate	1.15	29311		Floor Plate, 22/250 Rem.	1.15
16	14099	Floor Plate Screw	.35	29402		Front Sight, 222/223 Rem.	.90
17	14224	Front Guard Screw	.35	29535		Magazine Assembly, 222 Rem.	5.20
18	29400	Front Sight (also 22/250 Rem.)	.90	29542		Magazine Assembly, 223 Rem.	5.20
19	29396	Front Sight Screw	.35	29536		Magazine Assembly, 22/250 Rem.	5.20
	14250	Front Sight Washer		29540		Magazine Assembly, 243 Win.	5.20
20	14027	Flushing Lock Screw		29541		Magazine Assembly, 6mm Rem.	5.20
				29345		Magazine Guide Bar, 222/223 Rem.	.65
				29385		Stock Assembly, 222/223 Rem.	34.50
				29387		Stock Assembly, 22/250 Rem.	34.50
21	14031	Firing Pin				LEFT HAND CALIBERS	
22	29539	Magazine Assembly	5.20			NOTE: Part Not Listed Same as Standard Caliber	
23	29346	Magazine Guide Bar	.65			Barrel Assembly, 6mm Rem. L.H.	
24	14234	Magazine Guide Bar Screw	.35			Barrel Assembly, 308 Win. L.H.	
25	14235	Rear Guard Screw	.35			Bolt Assembly, L.H.	
	29350	Rear Sight Assembly	2.55			Bolt Final Assembly, L.H.	
26	14237	Rear Sight Base	.90			Bolt Plug, L.H.	\$ 1.30
27	14238	Rear Sight Eyepiece	1.30	14467		Firing Pin Final Assembly, L.H.	5.20
28	15728	Rear Sight Leaf	.50	29971		Stock Assembly, L.H.	34.50
29	29395	Rear Sight Screw	.35	30482		Trigger Housing Assembly, L.H.	6.25
30	14242	Receiver Plug Screw	.35	30330		Safety Assembly, L.H.	1.30
31	14243	Rib (Rear Sight)	.65	29370			
32	14244	Rib Spacer (Rear Sight)	.50			ACCESSORY	
33	29370	Safety Assembly	1.30			Sling Strap Assembly and Mountings Complete	\$ 6.25
34	14015	Safety Pivot Pin	.35				
35	14044	Safety Pivot Pin Retaining Washer	.35				
36	14497	Safety Detent	.35	25571			
37	14498	Safety Detent Spring	.35				
38	14015	Safety Retainer Pin	.35				
39	14044	Safety Retainer Pin Retaining Washer	.35				
40	14503	Sear	1.30				
41	91126	Sear Pin	.35				
42	29388	Stock Assembly	34.50				
	29365	Trigger Housing Assembly	6.25				
43	14026	Trigger Housing	2.55				
44	14033	Trigger	1.15				
45	14031	Trigger Pin	.35				
46	14045	Trigger Spring	.35				
47	14240	Windage Screw	.35				

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE

DELIVERIES ARE F.O.B. ILION, N.Y.

R2524653

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 require slight adjustment or fitting to assure proper 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 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.

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.

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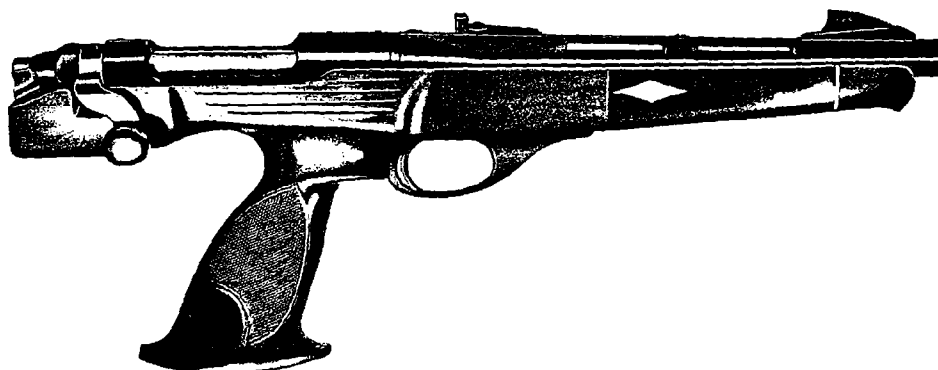
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ARMS SERVICE DIVISION
Ilion, New York 13357

Printed in U.S.A.

Form RD 5558
Rev. 675

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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Bolt Final Assembly	1	Trigger Housing Assembly	2
Bolt Components	1	Malfunctions	2-3
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Trigger Balance	1	Parts List - 221	5
Rear Sight Assembly	2	Exploded View - 7mm BR Rem	6
Front Sight	2	Parts List, 7mm BR Rem	7

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.

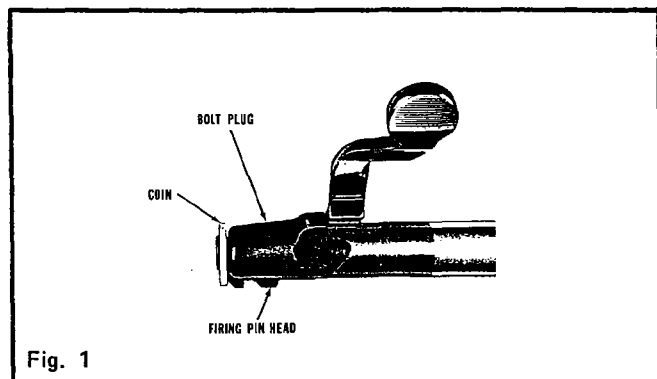


Fig. 1

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

- Cause:**
1. Broken or worn extractor.
 2. Fouled or rusted barrel chamber.

- Correction:**
1. Fit new extractor.
 2. Clean, lightly polish or replace barrel.

FAILS TO EJECT

- Cause:**
1. Ejector stuck in bolt.
 2. Fouling.
 3. Broken or worn extractor.

- Correction:**
1. Free or replace ejector.
 2. Clean bolt face and ejector.
 3. See "Fails To Extract".

FAILS TO COCK

- Cause:**
1. Broken, worn or improperly adjusted sear or sear block, or both.
 2. Firing 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. 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.

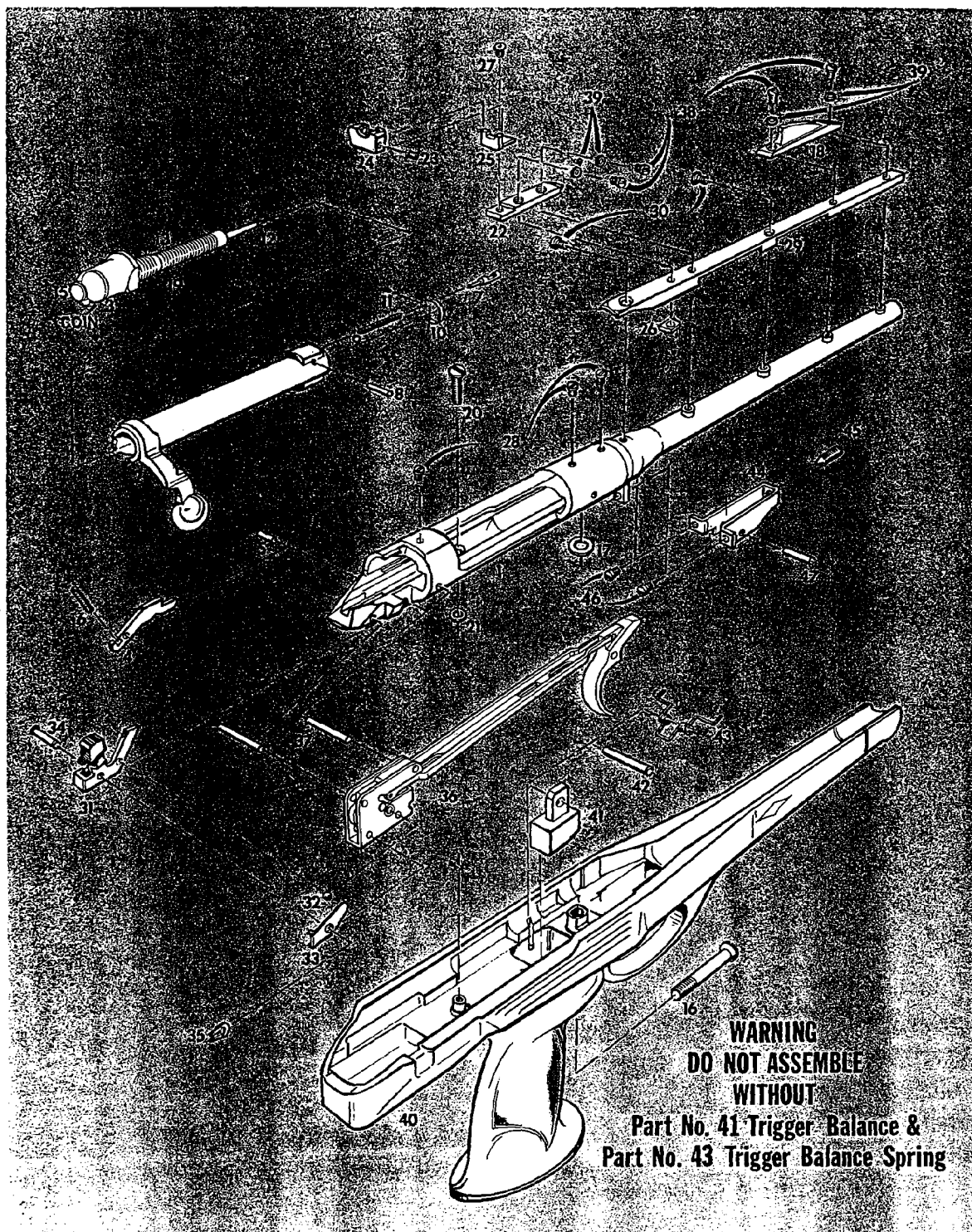
5. Allow at least one (1) hour for joined surfaces to weld together. Then remove tape or clamps.

To remove slight abrasions or blemishes in weld areas, use a good grade of auto rubbing compound.

EXPLODED
VIEW

MODEL XP-100

REMINGTON FIELD SERVICE MANUAL



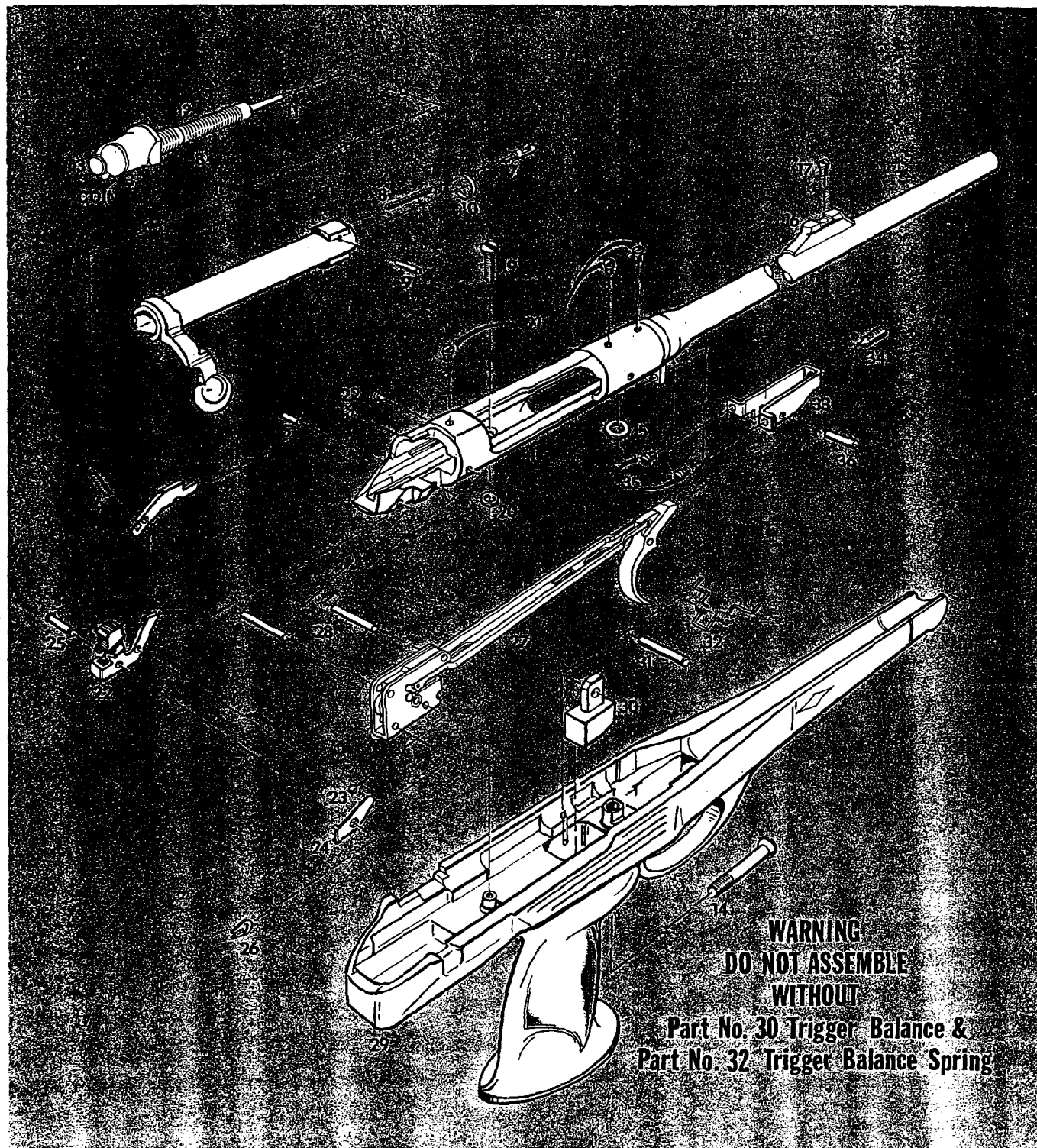
REMINGTON FIELD SERVICE MANUAL

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
1		Barrel Assembly, 221 Rem. "Fireball"	SUPERSEDED and SERVICE PARTS		
2		Bolt Assembly, 221 Rem. "Fireball"			
		Bolt Final Assembly, 221 Rem. "Fireball"			
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			
14	17022	Firing Pin Cross Pin			
15	23321	Firing Pin Head (Restricted)			
16	15447	Forward Receiver Screw			
17	15485	Forward Receiver Screw Washer			
18	15449	Front Sight			
19	15411	Main Spring			
20	15450	Rear Receiver Screw			
21	15484	Rear Receiver Screw Washer			
	26840	Rear Sight Assembly			
22	15727	Rear Sight Base			
23	15733	Rear Sight Elevation Screw			
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	Rib Screw			
31	91496	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	15473	Trigger Housing (Restricted)			
45	15469	Trigger Housing Screw, Front (Restricted)			
46	15474	Trigger Housing Screw, Rear (Restricted)			
47	24483	Trigger Pin (Restricted)			

EXPLODED
VIEW

MODEL XP-100
7mm BR REM.

REMINGTON FIELD SERVICE MANUAL



MODEL XP-100
7mm BR REM.

PARTS LIST

REMINGTON FIELD SERVICE MANUAL

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			
4	91761	Bolt Stop (Restricted)			
5	24484	Bolt Stop Pin (Restricted)			
6	15413	Bolt Stop Spring (Restricted)			
7	17017	Ejector			
8	17019	Ejector Spring			
9	17676	Ejector Pin			
10	91816	Extractor			
11		Firing Pin (Restricted)			
12	28600	Firing Pin Assembly			
13		Firing Pin Head (Restricted)			
14	15447	Forward Receiver Screw			
15	15485	Forward Receiver Screw Washer			
16	91763	Front Sight Ramp			
17	28505	Front Sight Ramp Screw			
18	15411	Main Spring			
19	15450	Rear Receiver Screw			
20	15484	Rear Receiver Screw Washer			
21	17034	Receiver Plug Screw			
22	91496	Safety Switch Assembly (Restricted)			
23	23222	Safety Switch Detent Ball (Restricted)			
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)			
28	24476	Sear Pin (Restricted)			
29	91765	Stock Assembly			
30	15470	Trigger Balance			
31	15471	Trigger Balance Pin			
32	15472	Trigger Balance Spring			
33	15473	Trigger Housing (Restricted)			
34	15469	Trigger Housing Screw, Front (Restricted)			
35	15474	Trigger Housing Screw, Rear (Restricted)			
36	24483	Trigger Pin (Restricted)			