

CONFIDENTIAL

Remington Arms Company Inc.
RESEARCH & DEVELOPMENT TECHNICAL CENTER
315 WEST RING ROAD
ELIZABETHTOWN, KY 42701

TLW 1012

APPENDIX I

Procedure for assembling and adjusting firecontrol

Parts

1 Trigger Housing
1 Trigger
1 Sear
1 Safety Arm
1 Trigger Pull Spring
1 Sear Spring
1 Safety Detent Spring
1 Trigger Pivot Pin
1 Sear Pivot Pin
1 Safety Pivot Pin
2 Retaining Rings
3 Adjustment Screws
1 Engagement Screw
1 Minimum Engagement Screw

1. Insert **Sear Spring** into the spring pocket on the **Sear** and secure **Sear** into the **Trigger Housing** using the **Sear Pivot Pin**.
2. Slip **Safety Detent Spring** into the spring hole on the **Safety Arm**.
3. Put the other end of the **Safety Detent Spring** into the **Trigger Housing** and then rotate the **Safety** into place and secure into housing using the **Safety Pivot Pin**. A small screwdriver is needed to hold down the **Sear Spring** while inserting the **Safety Pivot Pin**.
4. Insert the **Trigger** and secure with the **Trigger Pivot Pin**.
5. Push a **Retaining Ring** on the **Trigger Pivot Pin** and **Safety Pivot Pin**.
6. Attach the **Trigger Housing** to the **Receiver**.
7. Insert the **Trigger Pull Spring** into the bottom hole in the housing. Put loctite 222 on an **Adjustment Screw** and insert it behind the spring. Screw the setscrew in until it is flush with the housing.
8. Put loctite 290 on the **Engagement Screw** and screw it into the **Trigger**. Adjust the screw until it is close to the desired engagement value.
9. Put loctite 222 on the **Over travel Screw** and screw it into the top adjustment hole on the **Trigger Housing**. Screw it in until it is close to the desired over travel.
10. Put the action into the fixture on the comparator.
11. Set the engagement to 0.022-0.025" (DAT guns only) by adjusting the **Engagement Screw** at the front of the **Trigger**.
12. Adjust the over travel to 0.015"-0.020".
13. Put the action on the trigger pull device and set the trigger pull to 2.8 – 3.2 lbf. (DAT guns only).
14. Set the action aside and let the loctite set on all adjustment screws.
15. Put loctite 222 on the **Minimum Engagement Screw** and put it into the engagement screw on the trigger. Screw it all the way in until it bottoms on the engagement screw.
16. Put the safety in the "On-Safe" position. Put loctite 222 on the **Trigger Block Adjustment Screw** and screw it into the rear hole on the **Trigger**. Using a torque limiting screwdriver set the torque on the adjustment screw to 20 in-lbs.
17. Back the minimum engagement screw out until there is a .015" – 0.025" gap under the head. Use a feeler gauge to set.

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