

Owner's Manual

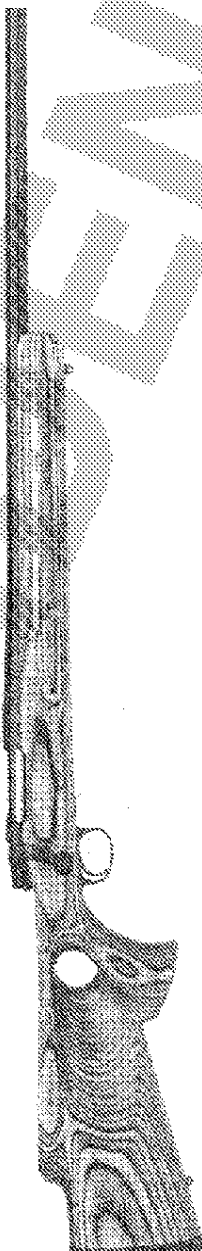
Instruction Book for:

MODEL XR-100
BOLT ACTION CENTERFIRE
TARGET RIFLE



PAGE 2.....THE TEN COMMANDMENTS OF FIREARM SAFETY
PAGE 7.....IMPORTANT PARTS OF THE FIREARM
PAGE 10.....HOW TO LOAD AND UNLOAD
PAGE 10.....LUBRICATION AND MAINTENANCE
PAGE 13.....HOW TO OBTAIN PARTS & TO SERVICE

Remington.



A Tradition of Performance and Safety.

In 1816 Eliphalet Remington was confident he could make a flintlock that was as good or better than any he could buy. His confidence was well founded. The barrel he handcrafted set a new standard for firearm accuracy and spawned generations of products that have made Remington® Arms America's leading gun maker. While performance and style are certainly hallmarks of Remington firearms, one factor ultimately drives their performance: Safety. Eliphalet Remington never lost sight of the fact that his rifles were potentially lethal and could kill someone if handled improperly. And after more than 180 years, the same holds true for any firearm, including your new Remington. Eliphalet Remington's first flintlock launched a proud tradition of accuracy and responsibility.



Eliphalet Remington's first flintlock launched a proud tradition of accuracy and responsibility.

Safety is Critical to Performance.

A superbly crafted gun is only as good as the hands that hold it. You can never be overcautious. Shooting accidents are often caused by careless oversights such as failing to control the direction of the muzzle, failing to fully engage the safety, leaving ammunition in the chamber or using improper loads. These oversights can result in the destruction of life, limb or property. There's no calling back a bullet once it's been fired, so it's critical that you know the principles of safe gun handling and storage before you ever take your new Remington firearm out of the box.

The proper use and performance of your firearm depends on correct assembly and maintenance, so it's critical that you familiarize yourself with the information in this instruction book. Even if you're a veteran shooter with a collection of Remington firearms, take the time to read this literature. Not all firearms are the same. That means the first step in safe handling is to learn the features and requirements of your new Remington.

The Ten Commandments of Firearm Safety

The Ten Commandments of Firearm Safety should be etched in your memory to ever let them govern your actions wherever and whenever you're involved with firearms, in the field, on the range, or in your home. Please take the time to review and understand these rules.

1st COMMANDMENT

Always Keep the Muzzle Pointed in a Safe Direction.

This is the most important gun safety rule. A safe direction is one in which an accidental discharge will not cause injury to yourself or others. Never allow your gun to point at anything you don't intend to shoot. Be especially careful when you're loading or unloading. Treat every gun as if it were loaded. And make it a habit to know where the muzzle is pointed at all times, even when your firearm is unloaded. No one will be injured by an accidental discharge if you keep your firearm pointed in a safe direction. It's as simple as that.



2nd COMMANDMENT

Firearms Should be Unloaded When Not Actually in Use.

Load your firearm only when you're in the field on the target range and ready to fire. Never let a loaded gun out of your sight or out of your hands. Unload it as soon as you're finished shooting — before you bring it into your car, camp, or home. Remember, unloading your firearm means unloading it completely, so there's no ammunition in the chamber or in the magazine. Before handling a firearm or passing it to someone else, visually check the chamber, receiver and magazine to be certain they do not contain ammunition. Always keep the gun's action open when not in use. Never assume a gun is unloaded even if you were the last person to use it. Always check for yourself.

Let common sense rule when you carry a loaded gun. If you're in a situation that could risk accidental discharge — such as crossing a fence, wading through a stream or climbing a tree — always unload your gun. Never pull or push a loaded firearm toward you or another person. And never carry a loaded gun in a scabbard, detached holster or gun case.

Certain firearms (including some Remington® rifles and shotguns) are equipped with internal safety devices to prevent unauthorized use. In addition, some firearms owners use external devices, such as cable locks and trigger blocks, for the same purpose. Even if you use such a device, you should still keep your firearm unloaded when stored or not in use. And, using internal or external devices cannot substitute, however, for securing your firearm's ammunition in a separate, locked location.



Firearms should be stored in a secure place where unauthorized persons cannot access them. A gun safe is an ideal way to secure your firearm.

Safe storage of firearms is just as critical as safe handling. Never store guns loaded. Be sure to keep your firearms in a secure place where unauthorized persons cannot get their hands on them without your knowledge.

Take special care if there are children around. Children are fascinated by guns. It's a natural curiosity that can have tragic consequences when not properly supervised. Store your firearms in a locked gun safe or some other secure place that physically bars a child from gaining access.

Ammunition should be stored and locked in a location separate from your firearm. Never leave an unsecured firearm or ammunition in a closet, dresser drawer or under the bed. Remember, it is your responsibility to make sure that children and others unfamiliar with firearms cannot get access to your firearm and ammunition.

3rd COMMANDMENT

Don't Rely on Your Gun's Safety.

Treat every gun as if it can fire at any time, whether or not there's pressure on the trigger. Your firearm has been carefully designed to maximize performance and safety. However, because it's a mechanically complex device, it could fail.

Human error is a more likely reason for a gun safety to fail. By mistake, you may think the safety's on when it really isn't. Or the safety may have been disengaged without your knowledge. Or you could think your gun is unloaded when there's actually a cartridge or shell in it. A mechanical safety is not a substitute for common sense. It's merely a supplement to your proper handling of a firearm.

Never touch the trigger on a firearm until you are ready to shoot. Keep your fingers away from the trigger when you're loading or unloading. And don't pull the trigger when the safety is engaged or positioned between "safe" and "fire."

Before using your gun, read this instruction book to understand the operation and operation of your firearm's safety. Even when the safety's on, maintain control of your loaded firearm and control the direction of the muzzle. In other words, don't rely on your safety to justify careless handling. If your firearm's internal mechanisms are broken or have been altered, your firearm may fire even when the safety is on. Remember, you and your safe gun handling practices are your gun's best safety.

4th COMMANDMENT

Be Sure of Your Target and What's Beyond It.

You can't stop a shot in mid air, so never fire unless you know exactly where your shot is going and what it will strike. Never fire at a sound, a movement or a patch of color. A hunter in camouflage can easily be mistaken for a target by an impulsive shooter. Before you pull the trigger be absolutely sure of your target and what's behind it. Make sure the shot has a backstop such as a hill side or dense material like sand.

Remember, bullets can travel great distances with tremendous velocity. Know how far your shot will go if you miss your target or the bullet ricochets.



5th COMMANDMENT

Use Proper Ammunition.

Every firearm is designed to use a certain caliber or gauge of ammunition. Using the wrong ammunition, mixing ammunition or using improperly reloaded ammunition can cause serious personal injury or death. And it only takes one cartridge or shotshell of the incorrect caliber or gauge, or which has been improperly reloaded, to destroy your firearm. It's your responsibility to make sure the ammunition you use exactly matches the caliber or gauge of your gun. Refer to this instruction book to find out the specific requirements of your firearm. Always read and heed the instructions on ammunition boxes.

Confusing shells or cartridges can cause serious personal injury or death and destroy your firearm. Examine your shells or cartridges closely and use only the precise caliber or gauge for your specific firearm. For example, suppose you accidentally loaded a 20 ga. shell into a 12 ga. shotgun. Because the 20 ga. shell is too small for the chamber, the 20 ga. shell could travel down the barrel and get lodged in the bore. If you then loaded a standard 12 ga. shell behind it and fired, the 12 ga. shot will slam into the lodged 20 ga. shell and may cause the barrel to explode right in your hand. This is commonly called a 12/20 burst, and it can kill you.

Check all ammunition before you load it to make sure it matches your gun's requirements. Every Remington® cartridge and shell is head-stamped with its caliber or gauge for easy identification. Moreover, you'll find the caliber or gauge of your new Remington firearm imprinted on the barrel.

Reloading Requires Extra Diligence.

If you're an ammunition reloader, you are responsible for personally ensuring that the loads and components of your reloaded ammunition meet your gun's factory-tested standards. Never use ammunition which has been recased by someone else!

Many shooters handload as a hobby to save money on commercial, factory-made ammunition. However, it requires a thorough knowledge of reloading procedures and a deep respect for the explosive potential of gunpowder.

Firearms are designed, manufactured and proof tested to standards based on factory-loaded ammunition. Hand-cased or reloaded ammunition that deviates, either intentionally or accidentally, from load or component recommendations can be very dangerous.

Reloaders must observe all possible safety precautions and practices related to the proper handling of explosives. Whether you're a seasoned reloader or just starting out, you should study the subject, watch reloading demonstrations and talk to experienced reloaders.

The first rule of reloading is to always follow the manufacturer's instructions for the components you're using. They'll tell you to follow certain guidelines. Namely:

1. Don't mix or substitute powders or primers.
2. Don't use unknown or substandard components.
3. Use only suitable components that have been factory-tested by reputable ammunition, powder, and primer manufacturers.
4. Always be sure to use the manufacturer's recommended recipe when reloading.

Not following these guidelines could result in severe injury to yourself or severe damage to your firearm. Dangerously high pressure and explosions can result from an overcharge of powder or other deviations from established reloading guidelines. Be very careful. The process of reloading exposes you to environmentally hazardous material, lead, which we know to cause cancer and birth defects, is the most common substance in bullets and shot. It is important to handle lead bullets and shot with extreme care. Work only in a well ventilated area and always wash your hands after exposure and before eating. Never smoke while reloading.

Primers and powders are also highly toxic and flammable. So after reloading be sure to clean up all materials from your work area. Don't leave primer or powder spills anywhere on the floor or bench top. Dispose of all waste material in accordance with the manufacturer's recommendations.

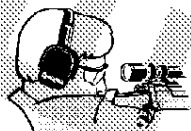
Finally, when reloading or handloading, concentrate on what you're doing at all times. Do not be distracted by talking to others, listening to the radio or watching TV while reloading. Never reload after consuming alcoholic beverages or drugs of any kind. You are working with extremely hazardous materials and you can't risk even a few seconds of distraction. Remember, if you reload, you are the ammunition manufacturer and you are responsible for the performance and safety of your reloaded ammunition.

6th COMMANDMENT

If Your Gun Fails to Fire When the Trigger is Pulled, Handle With Care.
If for some reason the ammunition doesn't fire when you pull the trigger, stop and remember the 1st Commandment of Firearm Safety—always keep the muzzle pointed in a safe direction. Keep your face away from the breach, then put the safety on, carefully open the action, unload the firearm and dispose of the cartridge safely. Remember that anytime there's a shell in the chamber, your gun is loaded and ready to use. Even if you tried to shoot and your gun didn't fire, treat your firearm as if it could still discharge.

7th COMMANDMENT

Always Wear Eye and Ear Protection When Shooting.
Your sight and hearing risk injury from shooting and should be protected at all times. Wear protective shooting glasses to guard against falling shot, clay target chips, powder residue, ruptured cartridge cases and even twigs and branches in the field. Also be sure to wear eye protection when you're disassembling or clearing a gun so that loosened parts (like springs) and cleaning solvents don't come in contact with your eyes. Continued exposure to shooting noise can permanently damage your hearing. On the range, where shooting volume is the loudest, be sure to use the maximum protection of a headset. And learn to use ear protection in the field, especially in confined locations like duck blinds.



8th COMMANDMENT

Be Sure the Barrel is Clear of Obstructions Before Shooting.
Before loading your gun, open the action and make sure there's no ammunition in the chamber or magazine. Check the barrel for any obstructions or debris. Even a small amount of snow, mud, excess lubricant, or grease in the bore can dangerously increase pressure and cause the barrel to bulge or burst when firing. Use a cleaning rod and patch to wipe away anti-rust compounds or any oil or residues or obstructions in the barrel. Never try to shoot out an obstruction by loading another shell and firing.

When firing, rely on your instincts. If the noise or recoil of your firearm seems weak, stop everything, unload your firearm and be sure nothing is lodged in the barrel. Remember the 12/20 rule? That's what can happen when the barrel is obstructed. So always be sure you're using the correct ammunition in your firearm and that it's free of obstructions.

9th COMMANDMENT

Don't Alter or Modify Your Gun and Have it Serviced Regularly.

Your firearm has been designed to operate according to certain factory specifications. You'll jeopardize your safety and that of others around you by attempting to alter its trigger, mechanical safety or other mechanisms. So never alter or modify your firearm in any way.



Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only a qualified service facility should service, repair or modify your Remington-UMC firearm. Consult your instruction book for instructions on how to send your firearm to the factory or for the location of the nearest Remington Authorized Service Center.

Proper cleaning and lubrication are also important to firearm maintenance and are necessary to assure accuracy, safety and reliability. Before cleaning, always make sure that your gun is completely unloaded. And always clean the barrel from the chamber end to the muzzle when possible.

Make it a practice to clean your bore every time you're going to shoot. Be sure to clean your entire gun, bore and after long-term storage and no less than once a year. It's so important to clean your gun whenever it's been exposed to adverse conditions such as rain, dirt, mud, snow, steel or saltwater.

For safe and dependable operation of your firearm, all parts of your gun must be properly cleaned and lubricated. Periodically inspect the internal workings of your firearm to be sure they're clean and free of rust, unwanted dirt and debris.

Use recommended lubricants on your gun and do not over-lubricate. Excessive use of a non-recommended lubricant could adversely affect the function and safe operation of your firearm. Remember, you are responsible for the proper care and maintenance of your firearm. Failure to properly maintain your firearm can not only damage or ruin your firearm, it can expose you and others to unnecessary risks of personal injury or death.

Remington® has a wide range of firearm care products and resources for best results when cleaning your gun. Everything from solvents and lubricants to rods and patches. They're all available from your Remington dealer.



10th COMMANDMENT

Learn the Mechanics and Handling Characteristics of Your Firearm.

Not all guns are alike. They have different mechanical characteristics that dictate how you should carry and handle them. Anyone who plans to use a firearm should first become totally familiar with the type of firearm it is and the safe handling procedures for loading, unloading, carrying, shooting and storing it.

Before you even unpack your new Remington firearm, read this instruction book "from cover to cover" and familiarize yourself with the different components parts of the gun. Then read, understand and follow the Ten Commandments of Firearm Safety in this book.

WARNING! Bore-sighting firearms in poorly ventilated areas, near open flames or handling ammunition may result in exposure to lead, a substance known to cause birth defects, reproductive abnormalities and other serious physical injury. Have adequate ventilation and all surfaces thoroughly after exposure.



SHOOT SOBER!!

There's one other rule that must be followed when handling firearms. It's called the rule is necessary in order to effectively practice the Ten Commandments of Firearm Safety: the rule is: **SHOOT SOBER!!** Guns and alcohol or drugs make a deadly combination. **Never** consume anything that would mildly impair your judgment or physical coordination when you're using a firearm. An staggering percentage of the shooting accidents that occur every year involve alcohol or drugs. Be smart. **Always** shoot sober and stay alive.

WARNING! Failure to follow any of these safety rules may cause personal injury or death to the shooter or bystanders and damage to property. Do not use firearms until you fully understand and practice the Ten Commandments of Firearm Safety. If you have any questions about the safe use of a Remington firearm, write to: Remington Arms Company, Inc., 5000 North Main St., P.O. Box 400, Madison, NC 27026-0400, or call us at 1-800-243-9700.

DON'T KEEP THIS TO YOURSELF.

Now that you're a gun owner you have the obligation to help ensure that shooting sports are safe for everyone: participants and bystanders alike. You can do that by practicing these principles of firearm safety and passing them on to others — especially new shooters. Set an example to beginners. Be a guide to their safe entry into the exciting world of shooting sports. Invest your time and patience in the love of the sport and for its future. After all, it's your love of the sport that led you to buy a new Remington.

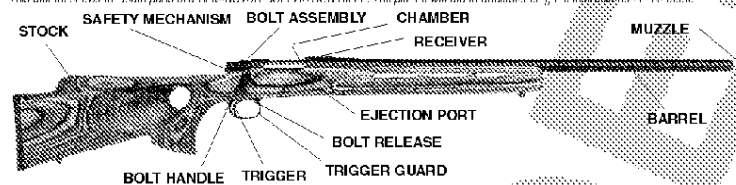
Firearm ownership is a right and privilege. It's a right guaranteed in this nation's Constitution. It's a privilege which carries with it the personal responsibility to use your firearm in a way which will ensure your safety and the safety of others. The preservation of this right and privilege depends on the personal commitment of you and your fellow shooters to the safe and responsible use of firearms. Let the Ten Commandments of Firearm Safety outlined in the book guide you at all times. Teach and promote these rules whenever you can. Remember, firearm safety depends on your efforts. The only way to really enjoy your new Remington firearm and to preserve sport shooting as we know it today.

Remington® Bolt Action Centerfire Rifle

Congratulations on your purchase of a Remington® Rifle. With proper care, it should give you many years of dependable use and enjoyment. For best results, we recommend that you use Remington Ammunition – the ammunition used in factory testing your firearm against our exacting function and performance standards.

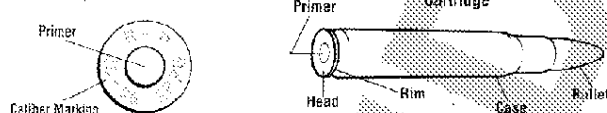
PICTURE 1

This picture shows the main parts of a Remington Bolt Action Rifle. The picture will aid in understanding the warnings in this book.



PICTURE 2

This picture shows the main parts of the ammunition.



Important Parts of the Firearm

The Safety Mechanism

Note: All Remington Bolt Action Rifles function the same regardless of button appearance.

The safety mechanism protects against accidental or unintentional discharge under normal usage when properly engaged and in good working order. The safety mechanism is not a substitute for following the rules of safe gun handling.

To engage the safety mechanism, pull the safety mechanism fully to the rear towards the 'S' position. See Picture 3.

Always put the safety mechanism in the 'S' position before handling, loading or unloading the firearm.

When you are ready to fire the firearm, push the safety mechanism forward towards the 'F' position to disengage the safety mechanism. See Picture 4.

Do not touch the trigger while moving the safety mechanism. Your fingers and all other objects should be kept outside of the trigger guard and away from the trigger until you are actually ready to fire by pulling the trigger.

Never pull the trigger when the safety mechanism is in the 'S' position.

WARNING: The firearm will fire when the trigger is pulled and the safety mechanism is in the 'F' position.

Even when the safety mechanism is in the 'S' position, exercise handling care when the firearm is fired. SEE THE REMINGTON COMMITMENTS OF FIREARM SAFETY ON PAGE 2.

The Security System

An external gun lock has been supplied with the rifle. The gun lock is a security device to help you prevent unauthorized use of your rifle. The instructions for the safe and proper use of the gun lock are provided in the packaging for the lock. READ AND FOLLOW THE INSTRUCTIONS for the gun lock. You may also obtain the instructions and warnings for the gun lock for the Remington website at WWW.REMINGTON.COM, or by calling Remington's toll-free number at 1-800-243-9700.

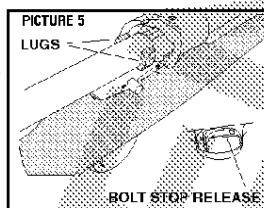
To Install the Bolt Assembly: The bolt assembly locks the cartridge into the chamber.



1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Align the lugs on the bolt assembly with the receiver.

See Picture 5.

4. Slide the bolt into the receiver and push all the way in.
5. To place the bolt in the lock position, push the bolt handle down.



To Remove Bolt Assembly:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Do not touch the trigger while moving the safety mechanism.
4. Raise the bolt handle.
5. Pull the bolt handle all the way back.
6. Push the bolt stop release in trigger guard. See Picture 5.
7. Slide the bolt assembly from the firearm.

Trigger Adjustment/Alteration Warnings

The Model XR-100™ Dartmaster® Single Shot Target Rifle is equipped with a target style trigger assembly which is adjustable for trigger pull weight from 1 1/2 lbs. - 3 1/2 lbs. All users of the trigger must strictly adhere to the instructions and warnings in this manual.

WARNING! DO NOT ATTEMPT TO ADJUST THE TRIGGER PULL WEIGHT OF THE RIFLES TRIGGER ASSEMBLY IF YOU HAVE NOT READ, OR DO NOT UNDERSTAND THE INSTRUCTIONS PROVIDED IN THIS MANUAL. NEVER MAKE ANY ADJUSTMENTS TO THE TRIGGER ASSEMBLY OTHER THAN THE TRIGGER PULL WEIGHT ADJUSTMENT AS SPECIFIED IN THE INSTRUCTIONS OF THIS MANUAL.

WARNING! IMPROPER ADJUSTMENTS TO THE TRIGGER ASSEMBLY CAN CREATE A HAZARDOUS CONDITION IN THE RIFLE AND RESULT IN PERSONAL INJURY OR DEATH.

Usage Limitations

WARNING! The Model XR-100 rifle is specially designed and intended for use by competitive target shooters ONLY. Because of its adjustable and highly sensitive trigger mechanism, the rifle must NEVER be carried in the field with a round in the chamber. This rifle is to be used ONLY under the following conditions:

- (1) This rifle is for use ONLY by experienced and responsible shooters in a controlled target shooting environment where the rifle is NEVER loaded with a live round of ammunition EXCEPT when it is in the ready-to-fire position with the muzzle pointed safely down range, AND.
- (2) If a cartridge loaded into the chamber is not fired it must be IMMEDIATELY unloaded from the rifle; NEVER move the rifle away from the down range position while it is unloading the round from the chamber. Failure to follow these limitations in use could result in an accidental discharge causing personal injury or death.

Firearm Sale Or Transfer

WARNING! BECAUSE THE MODEL XR-100™ DARTMASTER® SINGLE SHOT TARGET RIFLE IS A "TARGET" RIFLE WITH A "ADJUST" STYLE TRIGGER ASSEMBLY, IT IS NOT INTENDED TO BE A "FIREARMS" TRANSFER POSSESSION. A "FIREARMS" TRANSFER POSSESSION IS:

- (1) When the purchaser or recipient of your rifle that the rifle is equipped with a target style trigger assembly intended to be used in a controlled target shooting environment as specified above; AND
- (2) Give the purchaser or recipient the owners manual for review and reference.

WARNING! NEVER ALTER OR MODIFY ANY PART OF THE TRIGGER ASSEMBLY OR ANY PART OF THE FIRING MECHANISM. IMPROPER ALTERATIONS CAN CREATE A HAZARDOUS CONDITION IN THE RIFLE AND RESULT IN PERSONAL INJURY OR DEATH.

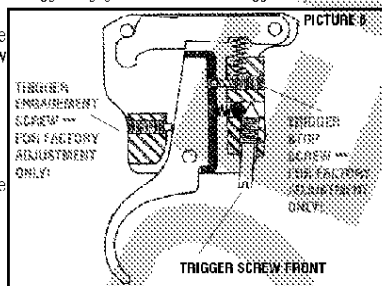
WARNING! NEVER PUT YOUR FINGER ON THE TRIGGER UNLESS YOU ARE GOING TO FIRE THE FIREARM.

The Trigger Assembly And Trigger Pull Adjustment

The trigger assembly of the Model XR-100 rifle has three adjusting screws: (1) trigger screw front, (2) trigger engagement screw, and (3) trigger stop screw. See Picture 6. The trigger engagement screw and the trigger stop screw are for adjustment by the Remington factory or a Remington Authorized Service Center **ONLY**. NEVER adjust or change the factory settings of either the trigger engagement screw or the trigger stop screw.

The trigger pull of the Model XR-100 rifle may be adjusted by the user by adjusting the trigger screw front. To adjust the trigger pull, follow these steps:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt all the way back.
5. Check the chamber and loading platform to make sure there are no cartridges in the firearm.
6. Adjust the trigger pull by turning the trigger screw front. See Picture 6.
7. Turn the trigger screw front clockwise to adjust for a heavier trigger pull. Turn the trigger screw front counterclockwise to adjust for a lighter trigger pull.



WARNING: The weight of the trigger pull on this target rifle must never be adjusted to less than 5 lbs.

NOTE: Once you have adjusted the trigger pull, you must check the safety of the trigger assembly as follows:

1. Check the chamber and loading platform to make sure there are no cartridges in the firearm.
2. Put the safety in the 'F' position.
3. Close the bolt handle. The firing pin must remain locked (try to rack).
4. Repeat (at least ten (10) times). If the firing pin does not lock during any of the repetitions of the test, you must increase the trigger pull force by turning the trigger screw front clockwise. Then repeat the test. If you are unable to adjust the trigger pull, return to a service agent which passes the bolt lock test, then return the firearm to the factory or a Remington Authorized Service Center for inspection and maintenance.

NOTE: The trigger was adjusted by Remington at the time of manufacture. With the exception of the trigger pull adjustment as described above, all adjustments to the trigger assembly and firing mechanism must be made only by the factory or a REMINGTON® AUTHORIZED SERVICE CENTER.

WARNING: NEVER remove the trigger assembly from the trigger assembly.

WARNING: NEVER put your finger on the trigger until you are going to fire the firearm.

The Barrel

The inside of the barrel must be clean and free of obstructions.

I. TO CHECK THE INSIDE OF THE BARREL:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt all the way back.
5. Remove any ammunition from the loading platform and chamber. See To Unload the Firearm below.
6. Remove the bolt.
7. Look through the inside of the barrel from the chamber end to the muzzle. See Picture 1 on page 7.

II. TO REMOVE OBJECT FROM INSIDE THE BARREL:

1. Use correct size cleaning rod.
2. Push cleaning rod from the chamber end all the way through the barrel, until the rod comes out of the muzzle.
3. If an object cannot be easily pushed out of the barrel with a cleaning rod, return the firearm to the factory or a REMINGTON AUTHORIZED SERVICE CENTER.

WARNING! NEVER try to remove an object from the barrel by loading another cartridge and firing. This may cause the barrel to burst or a cartridge case to rupture and cause serious personal injury.

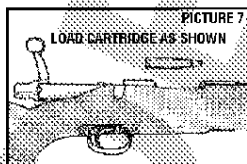
III. TO CLEAN THE BARREL FOLLOW THE INSTRUCTIONS SHOWN ON PAGE 10.

Before loading the firearm, make sure the muzzle of the barrel is free of dirt or other obstructions.

To Load the Firearm

TO LOAD ONE CARTRIDGE ONLY:

1. Point the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Pull the bolt handle all the way back.
5. Put one cartridge of the correct caliber on the loading platform in the chamber. See Picture 7.
6. Slide the bolt handle forward, then push the bolt handle down to lock the cartridge into the chamber.



THE FIREARM IS NOW LOADED.

7. When you have the firearm pointed safely downrange and are ready to fire, put the safety mechanism in the 'F' or fire position.

THE FIREARM IS NOW READY TO FIRE BY PULLING THE TRIGGER.

WARNING! Always check the cartridge for the correct caliber before loading the firearm.

To Unload the Firearm

1. Point the muzzle of the firearm in a safe direction.
2. Put the safety mechanism in the 'S' position.
3. Raise the bolt handle.
4. Put one hand over the top of the ejection port.
5. Slowly pull the bolt handle rearward with your other hand to remove the cartridge from the chamber.
6. Hold cartridge and remove it from the firearm.

WARNING! Check the chamber and the loading platform to make sure there are no cartridges in the firearm.

TELESCOPIC SIGHTS:

The top of the receiver has provision for telescopic sights.

Lubrication and Maintenance

When the firearm is to be stored, it should be carefully cleaned and thoroughly oiled. Outside surfaces should be wiped with a light coat of Rem-™ Oil occasionally. When the firearm is to be reused, all excess lubrication must be removed. The chamber and bore must be thoroughly wiped dry.

NOTE: Remington® Rem-™ Oil is available from your local dealer. If your dealer is out of stock, ask him to order Rem-™ Oil from his Remington's distributor.

To Clean the Barrel

WARNING! Check the chamber and magazine to be sure there are no cartridges in the firearm.

1. Use the equipment provided in a good cleaning kit. For recommendations, see your REMINGTON AUTHORIZED SERVICE CENTER.
2. Remove the bolt assembly. See instructions on page 8.

3. Select the correct caliber cleaning brush and attach the brush to the cleaning rod.
4. Put the cleaning brush into the gun's cleaning solvent.

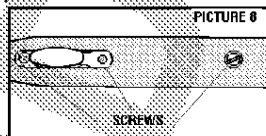
NOTE: Barrel should lay horizontally with the ejection port facing down during cleaning. Always clean the barrel from the chamber end of the muzzle.

5. Push the cleaning brush through the barrel several times.
6. Remove brush from rod, attach tip with patch, and push through the bore.
7. Repeat several times, using a new cleaning patch each time, until the patch is no dirty.
8. Push a clean patch saturated with Rem™ Oil through the barrel.
9. Push a clean dry patch through the barrel to remove excess lubricant.
10. Apply a thin coat of Rem™ Oil to the outside of the barrel with a soft clean cloth.
11. After clearing the barrel, clean the receiver and the trigger assembly.

WARNING: This firearm should be checked periodically by the Remington-Union Tool Company or a Remington-Union AUTHORIZED SERVICE CENTER. This will ensure proper inspection and any necessary repair or replacement of damaged parts.

To Clean the Receiver and Trigger Assembly

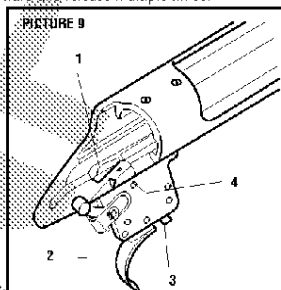
1. Put the safety mechanism in the "S" position.
2. Remove the bolt assembly. See instructions on page 8.
3. Turn the rifle upside down.
4. Remove the stock screws. See Picture 8.



5. Lift the stock away from the receiver and trigger assembly.

NOTE: Clean and lubricate the receiver and trigger assembly as a unit. Do not remove the trigger assembly from the receiver.

6. Thoroughly spray the receiver inside and out with Rem™ Action Cleaner and allow to dry.
7. Thoroughly spray inside the trigger assembly at the four points specified in Picture 9 with Rem Action Cleaner.
8. Place the safety in the fire "F" position. Pull the trigger rearward and release multiple times.
9. Pull and hold the trigger rearward. Then using a small punch or screwdriver depress the sear (Lubrication Point 1 in Picture 9) and release multiple times.
10. Release the trigger and operate the safety from the fire "F" to the safe "S" position multiple times.
11. Again thoroughly spray inside the trigger assembly at the four points specified in Picture 9 with Rem™ Action Cleaner. Air dry or use compressed air to thoroughly dry the trigger assembly.
12. Place a drop of Rem™ Oil in each of the four points in the trigger assembly specified in Picture 9.
13. Place the safety in the fire "F" position. Pull the trigger rearward and release multiple times. If the trigger does not completely return, reassemble the rifle and return it to a Remington® Authorized Service Center.



WARNING: If the trigger does not fully return to the "On" position each time it is released, then your rifle is NOT in a safe operating condition and should NOT be used until fully inspected and repaired by a Remington Authorized Service Center.

14. If the trigger completely returns as specified in operation 13, pull and hold the trigger rearward and using a small punch or screwdriver depress the sear and release multiple times. The sear must return to the full upward position without hesitation. **If the sear does not freely return, reassemble the rifle and return it to a Remington Authorized Service Center.**

WARNING: If the sear does not return to the full upward position without hesitation, then your rifle is NOT in a safe condition and it must NOT be used until you have had it inspected by a Remington Authorized Service Center.

15. If the sear freely returns to the full upward position as specified in operation 14, release the trigger and operate the safety from the fire "F" to the safe "S" position multiple times. The safety must operate freely. The safety spring must position the safety in the full safe "S" or fire "F" position. The safety should not remain in a position anywhere between the full safe "S" or fire "F" position. If the safety does not freely return to the full safe "S" or fire "F" position, repeat operations 7 thru 15. **If the safety does not freely return to the safe "S" or fire "F" position after repeating operations 7 thru 15, return the firearm to a Remington Authorized Service Center for an inspection of the safety and trigger assembly.**
16. Place the safety in the safe "S" position and lightly spray Rem™ Oil on all the external surfaces of the trigger assembly and receiver. Wipe off excess oil.

TO ASSEMBLE

1. Put the stock over the receiver and trigger assembly.
2. Replace and tighten the trigger guard screws.

WARNING: Before you replace the bolt assembly, make sure the barrel is free from obstructions.

3. Replace the bolt assembly. See Instructions on page 8.

WARNING: After cleaning the trigger assembly, check the loading platform operation, and make sure there are no obstructions in the firearm. The safety mechanism and the firing pin must operate properly. The firing pin must remain cocked. To check, pull the trigger. The hammer must fall. Repeat this step at least ten times. If the firing pin will not remain cocked when the bolt is removed, return the firearm to the factory or a REMINGTON AUTHORIZED SERVICE CENTER.

Cleaning Frequency

1. Before and after long term storage.
2. When the rifle has been subjected to adverse conditions such as shooting in the rain, snow, sleet or salt water areas.
3. When the rifle is exposed to dirty conditions such as being on the ground or doors, being dropped in the mud, etc.

Instructions for Cleaning the Bolt Assembly

TO DISASSEMBLE THE BOLT ASSEMBLY:

1. Remove the bolt assembly from the firearm. See instructions on page 8.
2. Put the notch on the firing pin head over a coin edge. Pull the bolt assembly away from the firing pin. Put a coin into the slot near the back edge of the firing pin head. See Picture 10.
3. Hold the bolt assembly and turn the bolt plug clockwise until the firing pin assembly can be removed from the bolt assembly.

CAUTION: Clean the firing pin assembly as follows:

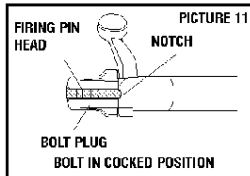
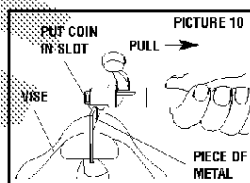
4. Clean all parts with gun cleaning solvent. Dry with a clean cloth.
5. Apply a thin coat of Rem™ Oil.

TO ASSEMBLE:

1. Put the firing pin assembly into the rear of the bolt assembly.
2. Tighten the bolt plug into the bolt assembly with your hand.
3. Pull the coin from the slot in the firing pin head.
4. Turn the bolt plug until the firing pin head goes into the small notch on the rear pin of the bolt. The bolt is now cocked. See Picture 11.

NOTE: The bolt must be cocked to be assembled into the rifle.

5. Assemble the bolt assembly into the rifle. See Instructions on page 8.



How to Obtain Parts and Service From Remington® Arms Co.

TO ORDER PARTS:

Many Remington® Dealers and Authorized Service Centers carry a full line of parts. Please check with them first before ordering parts.

To expedite your PARTS order or request REPAIR SERVICE visit our web site at www.remington.com. Detailed instructions are provided along with parts and/or service order forms. You may also reach Remington by calling our toll free customer service number, 1-800-243-9700, Mon.-Fri., 9:00 AM-5:00 PM Eastern time.

1. Fax completed order form (from the web site) to 1-336-548-7801.
2. To order by phone without the order form call 1-800-243-9700.

Please have the following information ready before you call.

- Firearm model and serial number.
- Part description and quantity. Part descriptions can be found on the parts listing page in this manual.
- Your complete mailing address (P.O. Box and Street Address), including zip code, telephone number and e-mail address.
- Method of payment: Mastercard, Visa, Amex or Discover card number and expiration date. Prepayment may be made by check or money order. A quote may be made to you over the phone. (Sorry, no C.O.D.s.)

WARNING: FOR GUN BUYER INFORMATION PARTS INFORMATION HERE

NOTE: SOME PARTS MAY BE RESTRICTED. See parts list for details. Owner's manuals/instruction books may be requested via our web site at: www.remington.com or by calling 1-800-243-9700.

REPAIR SERVICES

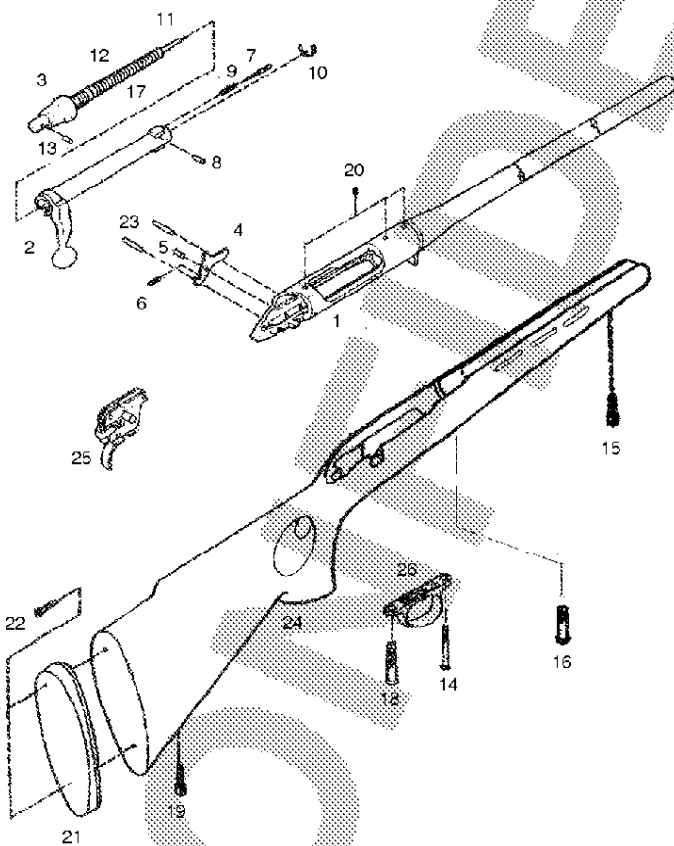
1. To locate the Remington Authorized Service Center nearest you visit our web site at www.remington.com and use our Repair Service Locator. If you need additional on-line assistance, email us at info@remington.com to obtain a listing of Remington Authorized Service Centers. Contact the Remington Authorized Service Center of your choice for evaluation of your firearm and/or additional shipping instructions.
2. If your Remington Authorized Service Center cannot provide the service or repair you require and you need further assistance, please call our toll free number 1-800-243-9700, Mon.-Fri., 9:00 AM-5:00 PM Eastern time and select the option for repairs. The shipment of your firearm is required, please:
 - Record the serial number of your firearm before sending it to us.
 - Pack your firearm for safety and to prevent further damage in shipping and handling. Preferably, ship in a firearm box.
 - Remove all accessories from the firearm to prevent loss or damage.
 - Enclose a letter with the firearm detailing the model name or number of your firearm and serial number along with a full description of the problem. Be sure to include your full name and address (P.O. Box and Street Address), including zip code, daytime telephone number and e-mail address.
 - Ship your firearm by either United Parcel Service (UPS) or Parcel Post (US Post Office). Remington is not responsible for damage or loss during shipment, so you may elect to purchase insurance from your carrier.

Ship to:

Remington Arms Company, Inc.
Attn: Arms Service Division
14 Hoeffer Ave.
Illion, NY 13357

WARNING: DO NOT SEND LIVE OR SPENT SHELLS IN YOUR FIREARM OR IN THE GUN BOX WITH THE FIREARM. THIS IS A VIOLATION OF FEDERAL LAWS. IF YOU ARE A GUN BUYER, PLEASE SEND THEM IN A SEPARATE PACKAGE AND INCLUDE NAME AND ADDRESS WITH IT. IF YOU ARE A GUN BUYER, PLEASE INCLUDE NAME AND ADDRESS WITH IT. IF YOU ARE A GUN BUYER, PLEASE INCLUDE NAME AND ADDRESS WITH IT.

MODEL XR-100™ Bolt Action Centerfire Target Rifle



MODEL XR-100™
Bolt Action Centerfire Target Rifle
PARTS LIST

VIEW NO.	PART NAME
1	Barrel Assembly
2	Bolt Assembly
3	Bolt Plug
4	Bolt Stop (Restricted)
5	Bolt Stop Pin (Restricted)
6	Bolt Stop Spring (Restricted)
7	Ejector
8	Ejector Pin
9	Ejector Spring
10	Extractor
11	Firing Pin (Restricted)
12	Firing Pin Assembly
13	Firing Pin Cross Pin
14	Front Guard Screw
15	Front Swivel Screw
16	Front Take-down Screw
17	Main Spring
18	Rear Guard Screw
19	Rear Swivel Screw
20	Receiver Plug Screw
21	Recoil Pac
22	Recoil Pac Screw (2)
23	Scar Pin (Restricted) (2)
24	Stock Assembly
25	Trigger Assembly (Restricted)
26	Trigger Guard

Firearm Owner's Record

Model _____ Serial # _____ Date Purchased _____

Purchased From _____

Price Paid _____

Remember to complete and return the Firearm Warranty Registration Card in order to obtain full benefit of your Limited Two Year Firearm Warranty.

A WORD ON THE MAINTENANCE AND CARE OF YOUR REMINGTON FIREARM

Don't Alter or Modify Your Gun and Have it Serviced Regularly. Your firearm has been designed to operate according to certain factory specifications. Don't jeopardize your safety and that of others around you by attempting to alter its trigger, mechanical safety or other mechanisms. So never alter or modify your firearm in any way.

Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only a qualified service facility should service, repair or modify your Remington® firearm. Consult your instruction book for instructions on how to send your firearm to the factory or for the location of the nearest Remington Authorized Service Center. Remington recommends that you have your firearm professionally serviced annually. You should also have your firearm professionally serviced after prolonged storage. If there is ever any question pertaining to the proper functioning characteristics of your firearm.

Proper cleaning and lubrication are also important to firearm maintenance and are necessary to assure accuracy, safety and reliability. Before cleaning, always make sure the your gun is completely unloaded. And always clean the barrel from the chamber end to the muzzle when possible.

[illegible]

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