

## Procedure for changing Bolt Lock Safety Arm to Non-Bolt Lock Safety Arm

### A. Check chamber and magazine for live ammo.

### B. Remove stock. **NOTE: Care to be taken to ensure stock / action / scope are not damaged.**

#### 1. ADL Stock removal.

- Remove 3 screws that hold stock to action.
- Carefully remove stock.
- Remove magazine spring and follower. **Note: Magazine box held into receiver with a screw.**
- Examine Trigger Assembly to the checklist – See attachment A.

#### 2. BDL Stock removal.

- Open hinged floor plate.
- Remove takedown screws. **Note: Care to be taken to ensure stock / action / scope are not damaged.**
- Remove floor plate with magazine spring and follower.
- Remove magazine box.
- Examine Trigger Assembly to the checklist – See attachment A.

### 3. After removing the stock assembly, if any of the following conditions exist the entire trigger assembly should be replaced:

- Adjustment screws altered out of adjustment.
- Components rusted, or coated with heavy sticky residue.
- Contains non-Remington components.
- Contains broken or damaged components.

### Else:

#### C. To remove safety to remove bolt lock arm.

- Lay action on bench with safety arm facing up.
- Remove safety switch snap washer.
- Remove safety detent spring.
- Remove safety pivot pin. **NOTE: bolt release will also come off.**
- Slide safety out the back of trigger housing. **NOTE: do not lose safety detent ball**
- Place template on side of safety arm - align holes and mark. \* **See illustration.**
- Cut or grind excess material away from bolt lock safety. **NOTE: make sure not to leave any burrs or sharp edges and recolor surface. \* See illustration of Bolt Lock Safety and Non-Bolt Lock Safety.**

D. To reinstall non-bolt lock arm.

- Install the bolt stop release
- Install safety arm, line up the pivot pin holes and push the pin through.
- Support rear of pin – a model 870 slide assembly works well for this purpose.
- Drop the detent ball into position.
- Set the safety detent spring in position.
- Install the safety snap washer (square side up) over the detent spring and on the pivot pin. From the rear to the detent spring, not over the dimples, slide the snap washer forward using a small flat screwdriver. Once it is in position rotate the snap washer over the dimples. Using the small screwdriver seat the washer on each side of the pivot pin. (Place the tip of the screwdriver near the pivot pin and lightly tap it to seat the snap washer.
- Function check the trigger assembly.

E. Reassemble stock.

1. ADL stock assembly:

- Make sure magazine box is aligned in receiver.
- Set follower and magazine spring into magazine box.
- Align stock to action being careful not to bind magazine spring between stock and magazine box.
- Align trigger guard and set in takedown screws.
- Snug takedown screws to align stock to action.
- Check bolt release, trigger centering, and trigger clearance.
- Tighten front takedown screw then rear takedown screw, then snug front guard screw. NOTE: do not over tighten screws if stock does not have pillars.
- Recheck bolt release, trigger centering, and trigger clearance.

2. BDL stock assembly:

- Align magazine box to bottom of receiver.
- Align stock to action.
- Set floor plate into stock and make sure it aligns with magazine box.
- With magazine follower and spring entered into magazine box some, place front and rear takedown screws into floor plate hole.
- Snug front and rear takedown screws to hold stock to action.
- Check magazine box fit to floor plate.
- Check bolt release, trigger centering, and trigger clearance.
- Tighten front takedown screw first, and then tighten rear takedown screw. Note: do not over tighten screws in stocks that do not have pillars.
- Close hinge floor plate and check for ease in operation.
- Recheck bolt release, trigger centering, and clearance.

F. Perform function test to ensure everything is working properly.

G. Firearm Care – Bolt Action. \* **See Attachment B.**

H. Special Notice to be returned with each firearm. \* **See Attachment C.**

**ILLUSTRATIONS:**

1. **Non-bolt lock template position:**
2. **Non-bolt lock safety and bolt lock safety comparison:**

## ATTACHMENT A

### TRIGGER ASSEMBLY CHECKLIST

Gunsmith Name: \_\_\_\_\_

Customer's Name: \_\_\_\_\_

Model: \_\_\_\_\_ Serial #: \_\_\_\_\_

Date: \_\_\_\_\_

#### Firing Mechanism Examination Process

Question	Yes	No
1. Is there the appearance of any rust on any of the trigger assembly parts?		
2. Is there any dirt or grime on any of the parts within the trigger assembly parts?		
3. Does there appear to be any sticky substances (grease, oil etc.) on any of the trigger assembly parts that would inhibit its functioning?		
4. Do any parts appear to be worn that would cause the gun not to function properly?		
5. Do any parts appear to be damaged or broken?		
6. Have the adjustment screw settings been altered in any way (has the seal been broken)?		
7. Have any of the seals on any of the other Trigger plate assembly screws been broken, tampered with?		
8. Firearm received with a safety		

related concern, <b>MUST BE RETURNED TO THE FACTORY.</b>		
9.		
10.		

Any yes answer to questions 1 – 7 would require a new Trigger Assembly to be installed on the rifle.

## ATTACHMENT B

### FIREARMS CARE – BOLT ACTION RIFLES

1. Pull the bolt to the rear. Check the chamber to make sure it's empty.
2. Open the magazine, or remove if possible. **Make sure the Magazine is empty.**
3. Release the bolt stop and remove the bolt. **Refer to the manufacturer's manual for instructions of firearm disassembly.**
4. If the gun has a scope, cap both ends to protect the optics. Never spray cleaners or lubes on a scope.
5. Clean the bore following instructions in your owner's manual. We recommend that you use a plastic bolt guide to protect the trigger assembly during the bore cleaning process.
6. Scrub the breech with a few drops of Rem Oil on a nylon breech brush. For heavy fouling, use a bronze or stainless steel breech brush.
7. Clean the receiver and barrel exterior using patches moistened with Rem Oil.
8. Spray the bolt with Rem Action Cleaner, the scrub with a nylon breech brush, especially the face, locking lugs, and extractor. Finish with a light spray of Rem Oil.
9. After heavy or extended rifle use, remove the stock according to the manufacturer's manual, the spray the trigger assembly, the action, and receiver with Rem Action cleaner. Brush off dirt and caked lubricants. Wipe clean with patches. Spray lightly with Rem Oil.

10. Reassemble the gun carefully, without forcing anything, and wipe all metal surface with Rem Oil. Wipe to remove fingerprints and leave a light oil film for rust prevention.

#### ATTACHMENT C

**Notice:**

Due to the changes in the trigger assembly now installed on your firearm, it will no longer be necessary for you to put the safety switch in the "F" position to unload the rifle. However, you still need to follow common safety rules while loading or unloading your rifle, including keeping your rifle pointed in a safe direction at all times.