

To Remington Authorized Repair Centers (not for outside distribution)
From: Remington Arms Co., Inc.
Subject: Bolt Action Centerfire Safety Modification Program
Models: All 600, 660, and XP-100 made prior to 1975

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

[If you have any questions about the functioning of these firearms or any step in this procedure, please call your Remington Field Service Representative or refer to your Field Service Manual]

1. Make sure rifle is completely unloaded
 - **Check chamber and magazine for live ammo.**
2. Remove stock.
 - **NOTE: Care must be taken to ensure stock / action / scope are not damaged. (Clean any components as needed during inspection process.)**
 - 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 per the checklist
3. After removing the stock assembly, you must first inspect the trigger assembly. **If you find that 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.
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4. If the trigger assembly does not require replacement then you may remove the bolt lock arm from the safety. To remove the bolt-lock arm do the following:
 - Lay action on bench with safety arm facing up.
 - Put safety switch in the "F" or "Off or Fire" position, and mark bolt lock arm below receiver.
 - 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.
 - Cut bolt lock arm at or below mark, and remove any sharp edges.
 - **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.**
 - Clean the trigger assembly prior to reassembling the safety arm.

5. 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. Visually examine to see that the bolt lock arm is not extending into the bolt lock slot on the receiver. Check to verify that the bolt can be cycled back and forth with the safety in either the “S” or “On Safe” position or the “F” or “Off of Fire” position. If the bolt **cannot** be cycled with the safety in the “S” or “On Safe” position then the bolt-lock removal performed has not been properly performed – Start over at step 4
6. Reassemble stock.
 - 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 the 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.
7. Perform function test to ensure everything is working properly. Function check the trigger assembly. Operate the safety to see that it moves freely. Visually examine to see that the bolt lock arm is not extending into the bolt lock slot on the receiver.. Cycle the bolt with the safe in the “S” or “On Safe” position, then push the safety to the “F” or “Off or Fire” position to be sure that it does not fire on safe release. Do this several times. Then check to verify that the bolt can be raised

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and cycled in the "S" or "On Safe" position. If the bolt cannot be cycled with the safety kept in the "S" or "On Safe" position then the bolt lock removal has not been performed properly. Start over on Step 4.

8. Complete repair packet:

- A. Trigger Assembly Checklist;
- B. Notice of Change in Operation;
- C. Verification of Decline of Repair Form; and
- D. Safety rebate coupon with firearm care instructions