

To Remington Authorized Repair Centers (not for outside distribution)
From: Remington Arms Co., Inc.
Subject: Bolt Action Centerfire **Safety Modification Program**
Models: 700, 40-X made prior to 1982

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**
 - A. **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.)

 - A. **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 per the checklist
 - B. **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 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.
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 off position, and mark bolt lock arm below receiver.
 - Remove safety switch snap washer.
 - Remove safety detent spring.
 - Remove safety pivot pin.
 1. **NOTE: bolt release will also come off.**
 - Slide safety out the back of trigger housing.

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1. 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. 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 in both the safe on and safe off position. 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. Check to verify that the bolt can be cycled with the safety in either the “S” or “On Safe” position or the “F” or “Off or Fire” position. If the bolt cannot be cycled with the safety in the “S” or “On safe” position then the bolt-lock removal not been properly performed. **Start over on step 4.**
6. To reassemble stock:
 - A. 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.

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- 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.

B. 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.

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 in both the safe on and safe off position. Cycle the bolt with the safe ON, then push the safety to the OFF 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 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