

PROCEDURE FOR REPLACEMENT OF TRIGGER HOUSING ASSEMBLIES

REMINGTON MODELS 600, 660 AND MOHAWK 600 ONLY

10-27-78

IMPORTANT NOTICE: ABSOLUTELY NO ALTERATIONS OR ADJUSTMENTS ARE TO BE MADE TO THE REPLACEMENT TRIGGER ASSEMBLY. IF ANY UNUSUAL PROBLEMS ARE ENCOUNTERED DURING REPLACEMENT OF TRIGGER ASSEMBLY, RETURN FIREARM TO FACTORY.

- 1) Inspect chamber and magazine for live ammunition.
- 2) Remove Bolt Assembly from firearm.
- 3) Remove Trigger Guard and Stock Assembly.
- 4) Remove Trigger Assembly by moving Safety to its full rearward position and remove two Sear Pins. Remove Trigger Assembly from the Action and place parts in an envelope for return to Remington, Ilion, New York, plant.
- 5) Assemble new Trigger Assembly to receiver. Be sure to assemble rear Sear Pin first.
 - a. Pull and hold Trigger and depress rear of Sear with a screw driver to check for binding. With Trigger pulled, the Sear must depress and return to its full upward position. If binding occurs, insert a wide blade screw driver and carefully spread the walls of the Trigger Housing against the side of the Receiver. Recheck for Sear bind. (See sketch below.)

- b. Stake Sear Pin holes in the Receiver on the left side to prevent pins from coming out and binding the Bolt stop.
 - c. Check for bind of the Safety lever in the Bolt lock slot of the Receiver. If the Safety lever binds, file the slot as needed to relieve.
- 6) Reassemble Bolt to Receiver.
- a. Check for proper operation of the Safety by putting Safety in "ON" position, pulling Trigger (gun must not fire), putting Safety in "OFF" position, pulling Trigger (gun must fire). Repeat this test three times. Safety must work freely without binding and with positive detenting action at "ON" and "OFF" position. If gun fails this test, install a new Trigger Assembly and repeat tests.
- 7) Set Barreled Action into Stock.
- a. With Trigger Guard removed, check for clearance between the Trigger Housing and the brass Stock reinforcing screw by looking through the bottom of the Stock. If the Trigger Assembly touches the Stock reinforcing screw, slightly bend the screw toward the muzzle to get clearance. (See sketch.)

- b. Alter Safety Lever clearance in the Stock with a file, chisel or rotary Dremel-type tool. Remove enough wood so that the Safety Lever, when in the "ON" and "OFF" position, does not rub or bind on the Stock at the rear or sides.
- 8. Completely reassemble Rifle.
 - a. Dry fire Rifle three times.
 - b. Check for Trigger rubbing on the Trigger Guard. If rubbing occurs, file the Trigger Guard to relieve.
 - c. With the Bolt closed, operate the Safety to the "ON" and "OFF" positions. The Safety must not touch, rub or interfere with the Stock. Perform step 7 b. again if this occurs.
 - d. Check Safety three times by operating Bolt, putting Safety in "ON" position, pulling Trigger, (gun must not fire and the Trigger must work freely with no binding and must readily retract), putting Safety in "OFF" position, pulling Trigger (gun must fire).
 - e. Check for Bolt lock by cocking the rifle (operate Bolt) and putting the Safety in "ON" position. The Bolt must lock closed.

If rifle fails tests a, b, c, d, or e, replace the Trigger Assembly. If problems persist, return the rifle to Remington's Ilion plant for factory repair.

The serial numbers of guns involved are as follows:

Remington Model 600	From Serial #	0001 to #	131,552
Remington Model 660	From Serial #	0001 to #	131,552
Mohawk 600	From Serial #	6,200,000 to #	6,899,999
Remington Model 660	From Serial #	6,200,000 to #	6,899,999
Remington Model XP-100	From Serial #	0001 to #	7,507,983

No guns of above models that carry a letter prefix "A" or "B" in the serial numbers are involved. XP-100's with an "A" or a "B" prefix or numbered between 7,507,984 and 7,509,999 are not involved.

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