

PROCEDURE FOR REPLACEMENT OF TRIGGER HOUSING ASSEMBLIES

MODELS 600, 660 AND MOHAWK 600 ONLY

10-27-78

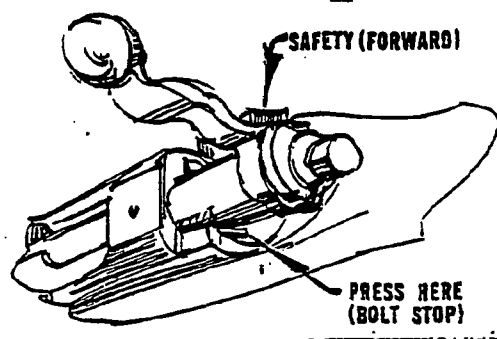
IMPORTANT NOTICE: ABSOLUTELY NO ALTERATIONS OR ADJUSTMENTS ARE TO BE MADE TO THE REPLACEMENT TRIGGER ASSEMBLY. IF ANY UNUSUAL PROBLEMS ARE ENCOUNTERED DURING REPLACEMENT OF TRIGGER ASSEMBLY, RETURN FIREARM TO FACTORY.

Inspect Chamber and Magazine for live ammunition.

- A. With firearms pointed in safe direction, open Bolt and visually inspect Chamber and Magazine.
 - 1. Firearm must be free of live ammunition.

Remove Bolt Assembly from Firearm.

- A. Pull Bolt rearward until Bolt Stop halts Bolt.
- B. Insert small tool against Bolt Stop and press downward. This will release Bolt. (See Figure below)



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2.

Remove Trigger Guard and Stock Assembly.

- A. Unscrew front and rear guard screws.
- B. Remove Trigger Guard.
- C. Lift away and remove Stock Assembly from Action.
- D. Remove Magazine Assembly from Receiver.

Remove Trigger Assembly from Action.

- A. Pull Safety lever rearward beyond the safe detent position to clear the rear Sear Pin.
- B. Tap out both Sear Pins from left to right.
- C. Pull Trigger Assembly from Receiver.

Assemble Replacement Trigger Assembly.

- A. Insert Trigger Assembly, identified with "V" stamped on left side of Trigger, with slave pins intact, into Receiver and align Sear Pin holes to Receiver.
- B. Lightly tap slave pins to engage Sear Pin holes in Receiver. Put Safety to "On" safe position.
- C. Insert tapered end of Sear Pins in left side of Receiver. Seat pins flush to slightly below Bolt stop with slot. Make sure pins do not protrude into Bolt Stop slot in Receiver.
- D. Prick punch Receiver at Sear Pin holes on left side. Bolt stop must not bind in slot.

E. Push Safety lever to "Off-Safe" position, pull Trigger and hold. Depress top rear of Sear safety cam to insure that it moves freely in Trigger Housing. The Sear safety cam must not bind and must retract without hesitation.

1. If binding occurs, insert wide blade screwdriver and carefully spread walls of housing against side of Receiver, and recheck Element "E", above. (See Figure below.)



2. Visually check alignment of inner walls of Trigger Housing with Firing Pin head guide slot in Receiver.
- F. Push Safety lever from "On-Safe" position to "Off-Safe" position, to insure free movement with no binding and positive engagement of detents. Check Bolt lock area of the Safety lever to make sure it works freely in Receiver slot. If slight binding occurs on Receiver,

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4.

F. Contd.

file Receiver slot. If excessive binding occurs, then use another Trigger Assembly.

G. Insert Bolt Assembly in Action.

H. Put removed Trigger Assembly in an individual envelope for return to Remington (one assembly per envelope).

Check Clearance

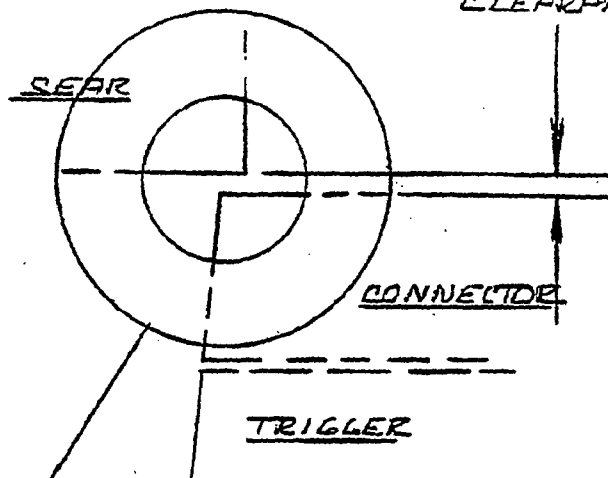
- A. With gun cocked, locate Safety lever to halfway point between "On-Safe" and "Off-Safe" location to position the safety ball detent between the indents with the Safety lever; in this unstable location insert an 1/8" wide screwdriver into the front of Trigger Housing (see Figure Pg. 6). Look through the engagement view hole to check for clearance between the Connector and Sear, while rotating Trigger back and forth. There must be clearance between the Connector and Sear, the Connector cannot catch on Sear. If clearance does not exist, install new Trigger Assembly.

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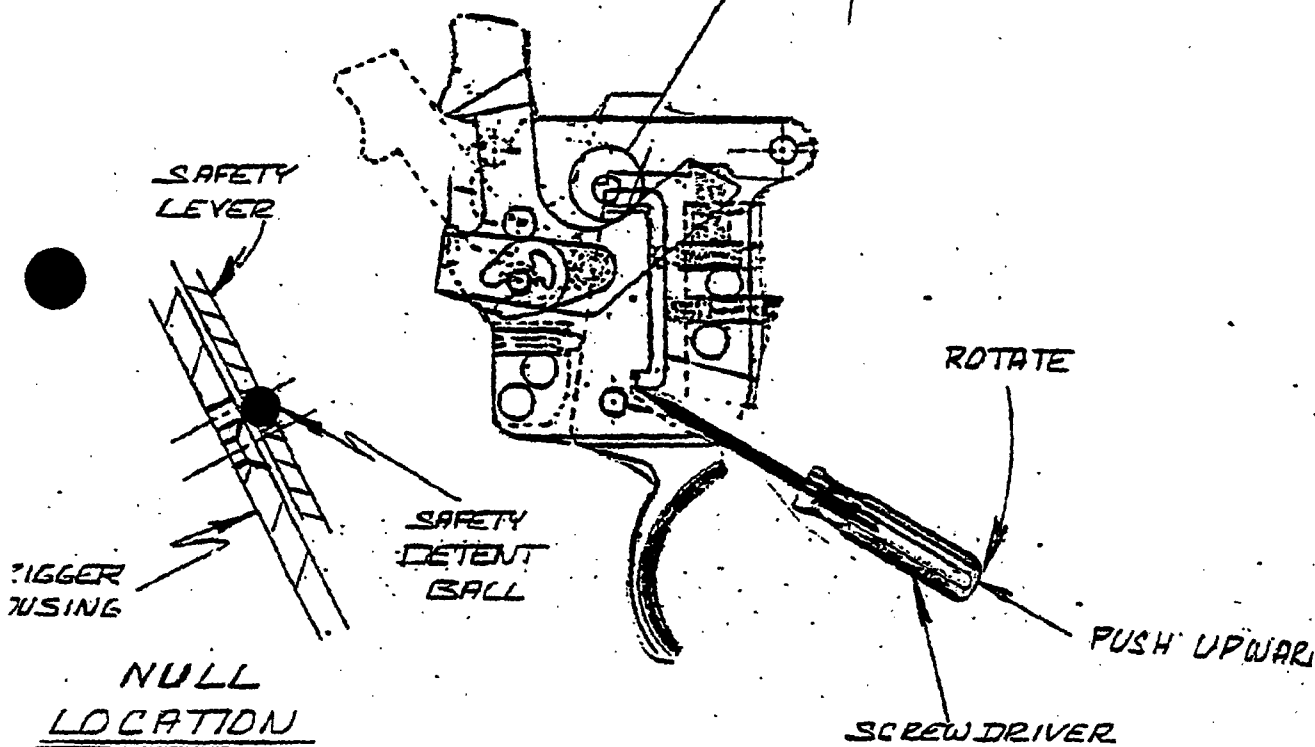
6.

CLEARANCE

ENLARGED VIEW
SEAR & CONNECTOR
CLEARANCE



TRIGGER



Trigger Assembly Clearance.

- A. Assemble Barrel Action to Stock to check Trigger Assembly clearance. The brass reinforcing screw located forward of the Trigger Assembly clearance cut may possibly interfere with the new design Trigger Assembly. If this occurs, bend center reinforcing screw toward muzzle for proper clearance. (Note illustration)

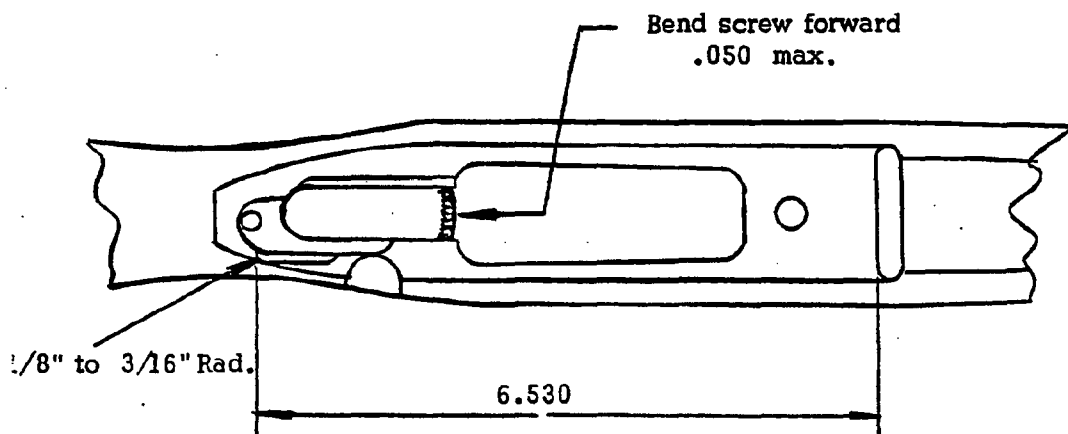
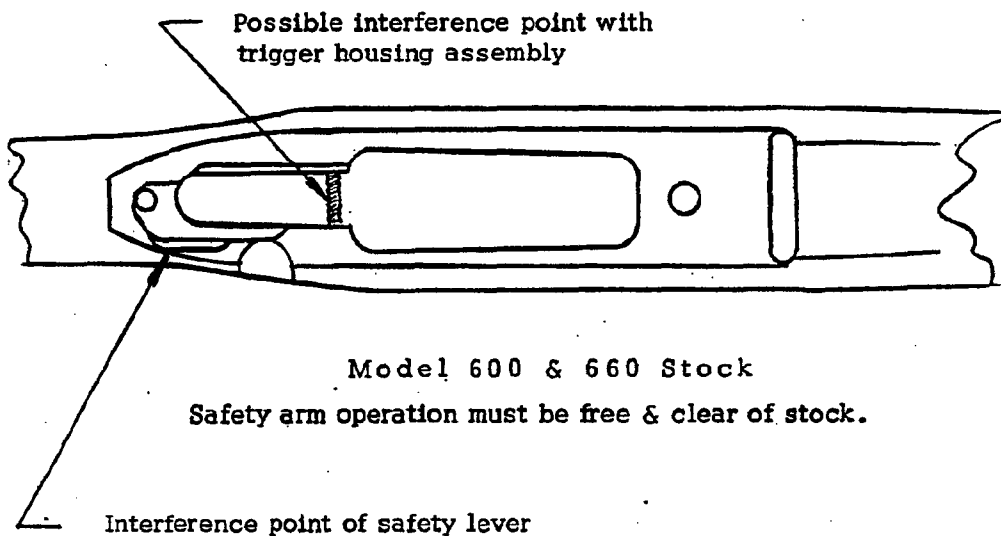
Safety Lever Clearance in Stock.

- A. For Safety lever clearance, wood is to be removed from the rear of the Safety clearance cut.
 1. With the Barrel Action removed from the Stock, measure 6.530" from the rear edge of the recoil lug shoulder to rear of Safety lever clearance cut and remove wood for Safety lever clearance, leaving a 1/8" to 3/16" radius in the rear corner. This wood removal can be performed with proper chisels and/or a rotary type high speed grinder. (Note illustration)

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Reinforcing screw should not interfere with trigger housing assembly.

- A. Bend screw forward .050" max.
- B. If interference remains:
 1. Replace stock on Mag. rifles (6.5 & 350 Mag.)
 2. Remove exposed stock reinforcing screw section on remaining caliber rifles



- B. After completing this operation, insert Barrel Action into Stock holding recoil lug tightly against recoil shoulder and with the Bolt in the closed position, pull the Safety rearward. Check Bolt lift to insure Safety arm has secured the Bolt in the locked position. Inspect the Safety lever for binding or contact with the Safety lever clearance cut in the Stock. Should the Safety lever, in the "On-Safe" position, contact the Stock, remove wood until clearance is obtained.
- C. After proper wood clearance has been obtained, complete the assembly of rifle. Check for clearance between Trigger and Trigger guard. Close the Bolt, put the Safety lever in the "On-Safe" position, pull the Trigger rearward and release. The Trigger should move rearward and forward freely with no binding. If any contact is found, the Trigger guard is to be filed.
- D. Check freeness of Safety. Safety must not bind. The Safety must snap in detent in both the "On-Safe" and "Off-Safe" positions.
- E. Check function of Safety. Cock rifle and move Safety to "On-Safe" position. No click or catch permitted when Trigger is pulled and the Trigger must readily retract when released. The Firing Pin must not fall.

E. Contd.

Move Safe to "Off-Safe" position. The Firing Pin must not fall.

Pull Trigger. The Firing Pin must fall.

Cock rifle and close Bolt firmly. The Firing Pin must not fall. (Repeat several times.)

Open Bolt, pull Safety to "On-Safe" position and close Bolt. The Bolt must lock down. The Safety must remain in "On-Safe" position and the Bolt must not open until Safety is pushed to the "Off-Safe" position.

With gun cocked, locate Safety lever to halfway point between "On-Safe" and "Off-Safe" location to position the Safety ball detent between the indents, with the Safety lever in this unstable location.

Pull Trigger. No click or catch permitted when Trigger is pulled and the Firing Pin must not fall. Remove finger from Trigger. The Trigger must retract. Push Safe to "On-Safe" position. The Firing Pin must not fall.

Pull Safe back slightly toward "On-Safe" position and release. Safety must snap forward to "Off-Safe" position.

Pull Trigger. The Firing Pin must fall.

Open Action.

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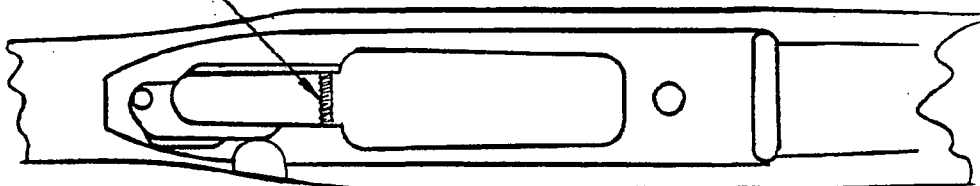
REINFORCING SCREW SHOULD NOT INTERFERE
WITH TRIGGER HOUSING ASSEMBLY.

A. BEND SCREW FORWARD .050" MAX.

B. IF INTERFERENCE REMAINS:

1. REPLACE STOCK ON MAG. RIFLES (G.S. & 350 MAG.)
2. REMOVE EXPOSED STOCK REINFORCING SCREW SECTION
ON REMAINING CALIBER RIFLES.

POSSIBLE INTERFERENCE POINT WITH
TRIGGER HOUSING ASSEMBLY.



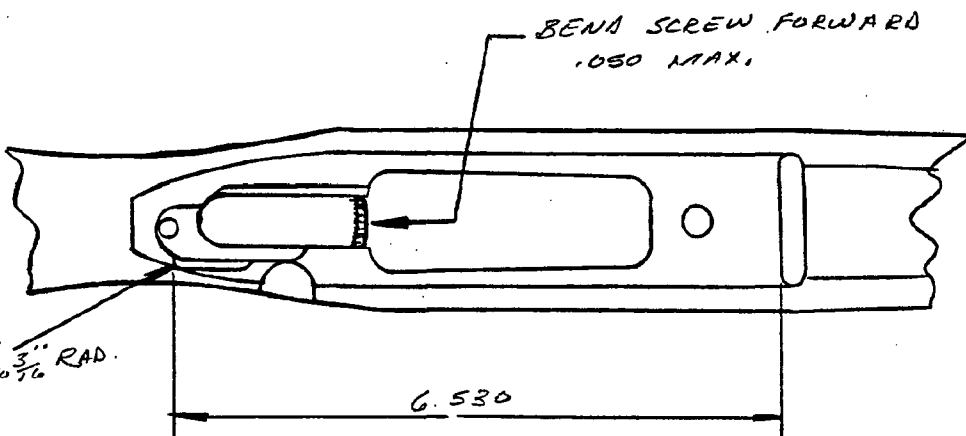
MODEL 600 & 660 STOCK

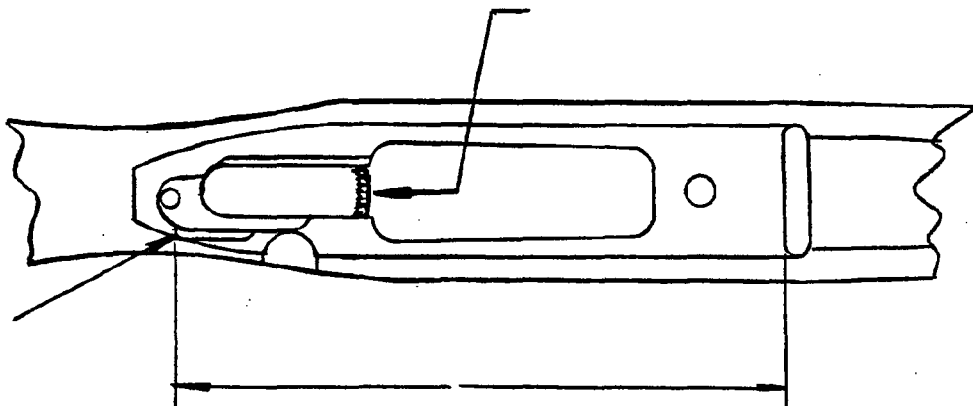
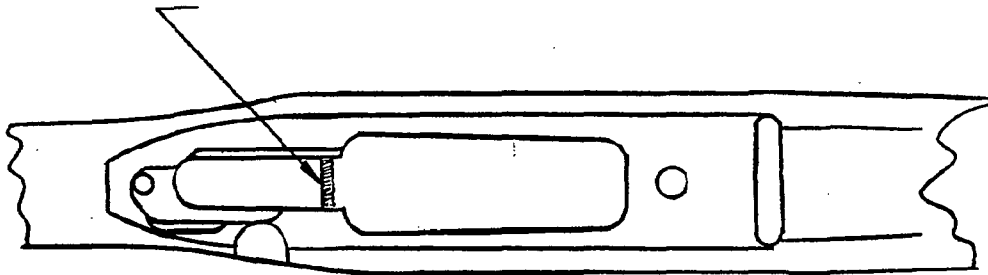
SAFETY ARM OPERATION MUST BE FREE & CLEAR OF STOCK

BEND SCREW FORWARD
.050" MAX.

$\frac{1}{8}$ " $\frac{3}{16}$ " RAD.

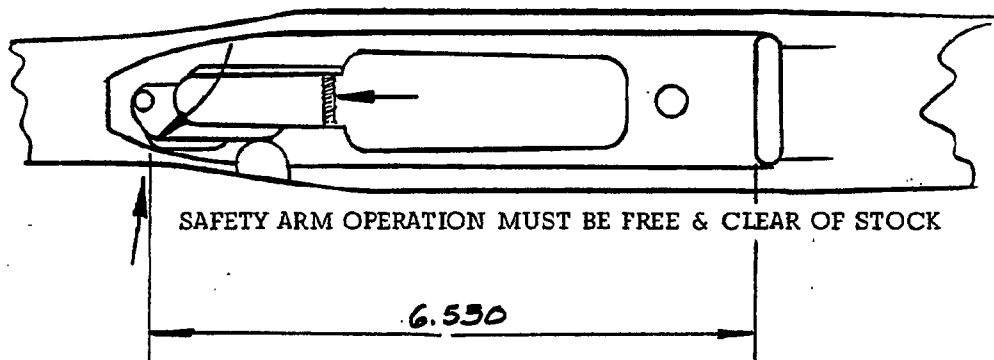
6.530





REINFORCING SCREW SHOULD NOT INTERFERE
WITH TRIGGER HOUSING ASSEMBLY

- a. Bend screw forward .050" max.
- b. If interference remains:
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Reinforcing screw bent forward .050" Max.

MODEL 600 & 660 STOCK

