

**SAFETY WARNING** — Failure to obey a safety warning may result in injury to you or to others.

**IMPORTANT** — Always Keep the Muzzle Pointed in A Safe Direction. Prior to using live ammunition, familiarize yourself thoroughly with these operating instructions. Get accustomed to the feel of your new gun — know the forces required to operate the action,\* to pull the trigger and, above all, know the location and operation of the safety.

**NOTE:** The Model 70 XTR is featured in all photographs.

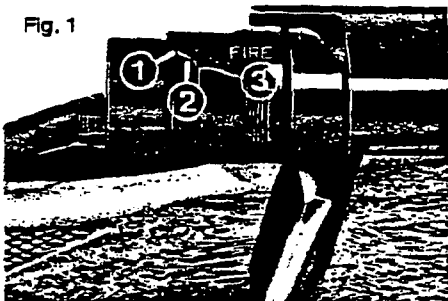
**HOW TO OPERATE THE SAFETY** — The safety can only be operated when the firing pin is cocked. To cock the firing pin, lift up on the bolt handle and then return it to the locked position (when the firing pin is cocked, a red indicator is visible at the rear of the bolt).

1. **Fully On** — (See Fig. 1) The safety drawn to the most rearward position and in line with the bolt. Both the firing pin and bolt are positively locked.

2. **Intermediate Position** — (See Fig. 1) With the safety in a mid-way position and at a right angle to the bolt. This position locks the firing pin, but not the bolt. The intermediate position also allows for removal of an unfired cartridge from the chamber and the magazine in complete safety. Also, the intermediate position is often used by sportsmen when ready and expecting to shoot.

3. **Firing Position** — (See Fig. 1) With the safety fully forward, the rifle is ready to fire. For ease of operation, it is recommended the safety be operated with the thumb.

Fig. 1



\***ACTION:** The mechanism of a firearm which loads and secures the cartridge in the chamber.

**TO INSTALL THE BOLT** — The bolt of your rifle is packed separately in the carton in which your rifle is shipped. Before inserting the bolt, make sure the firing pin is cocked (when the firing pin is cocked, a red indicator is visible at the rear of the bolt). If the firing pin is not in the cocked position, (See Fig. 2A) turn the rear section of the bolt until the breech bolt sleeve lock engages the notch in the breech bolt. On a new gun where surfaces are not yet burnished from use, it may be difficult to rotate the bolt sleeve by hand. If so, grasp the lower section of the firing pin in a vise, pull and turn.

Fit the forward end of the bolt in the rear of the receiver, then slide the bolt fully forward and lower the bolt handle to a locked position. The safety can now be operated. (Fig. 3)

**WARNING** The breech bolt has been carefully selected and fitted by the factory to assure correct headspace. It is etched with the same serial number as the gun for identification purposes. For safety sake, **DO NOT INTERCHANGE BREECH BOLTS.** If the breech bolt is lost or damaged, return the gun to the factory for replacement.

Fig. 2. ROTATE RED-COCKING LEVER



Fig. 3

