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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

File m1700

Ilion, New York
April 17, 1980

TO: E. G. LARSON

FROM: J. W. BROOKS *JWB*

R I V E T L E S S E X T R A C T O R

The rivetless extractor is being put into the Model 700 Varmint Rifle in the 7mm-08 Caliber and the XP-100 Pistol in the 7mm BR Rem. Caliber starting with the initial production of these two items. It is proposed to introduce this extractor into all calibers in the Models 700, 788, XP-100 in the future.

Enclosed is a draft of an assembly procedure for field use. You may wish to notify the field and repair stations of the above two calibers that are now or will shortly be shipped to distributors.

JWB:T
Encl.
Firearms Research Division

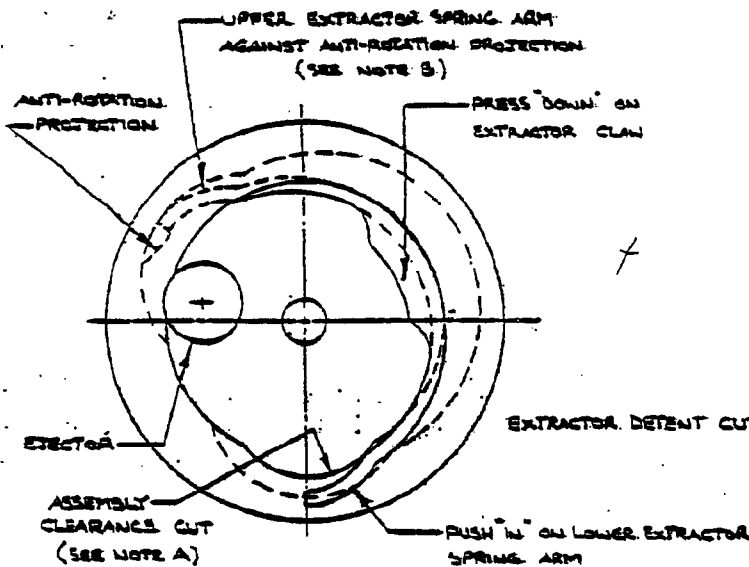


Fig. 1
EXTRACTOR IN "INITIAL"
ASSEMBLY POSITION
(SEE NOTE C)

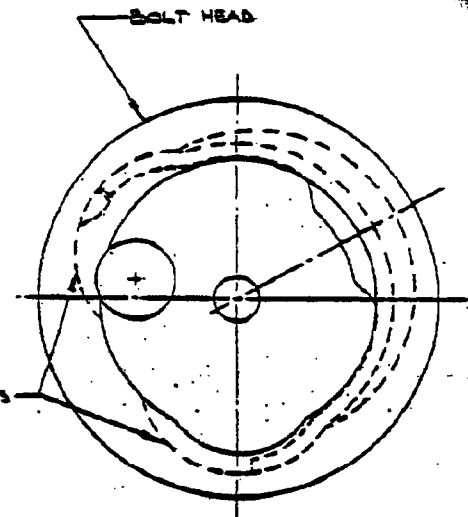


Fig. 2
EXTRACTOR IN "FINAL"
ASSEMBLED POSITION
(SEE NOTE C)

MODEL 700 - XP-100

RIVETLESS EXTRACTOR ASSEMBLY PROCEDURE

BEFORE ATTEMPTING TO ASSEMBLE EXTRACTOR - NOTE ITS CORRECT POSITION IN BOLT, RELATIVE TO EJECTOR, ASSEMBLY CLEARANCE CUT, ANTI-ROTATION PROJECTION AND EXTRACTOR DETENT CUTS AS SHOWN IN VIEWS ABOVE.

- NOTE: A. MAGNUM CAL. BOLTS DO NOT HAVE ASSEMBLY CLEARANCE CUT.
B. SMALL CAL. BOLTS (.222 ETC.) DO NOT HAVE ANTI-ROTATION PROJECTION.
C. FOR LEFT HAND BOLTS - POSITION OF EXTRACTOR AND EJECTOR WILL BE OPPOSITE HAND TO VIEWS SHOWN ABOVE.

ASSEMBLY STEP 1.

WITH BOLT HEAD VIEWED AS SHOWN IN FIG. 1 - LOCATE "UPPER" EXTRACTOR ARM IN DETENT CUT IN BOLT HEAD, WITH END AGAINST ANTI-ROTATION PROJECTION (SEE NOTE B). ALIGN "LOWER" SPRING ARM WITH ASSEMBLY CLEARANCE CUT (SEE NOTE A).

ASSEMBLY STEP 2.

SIMULTANEOUSLY PRESS "DOWN" ON EXTRACTOR CLAW AND PUSH "IN" ON LOWER SPRING ARM UNTIL IT "JUST CLEARS" ASSEMBLY CLEARANCE CUT (SEE NOTE A). CONTINUED PRESSURE "DOWN" ON EXTRACTOR WILL ALLOW IT TO "SPRING" INTO ITS CORRECT POSITION AS SHOWN IN FIG. 2.

CAUTION: APPLYING TOO MUCH FORCE ON LOWER SPRING ARM WILL CAUSE IT TO BE PUSHED IN TOO FAR BEYOND CLEARANCE CUT AND DEFORMATION AND INCORRECT FUNCTION WILL RESULT. NEEDLE NOSE PLIERS MAY BE USED TO CONTROL FORCE.

EXTRACTOR REMOVAL: EXTRACTOR CANNOT BE REMOVED WITHOUT BREAKING OR DEFORMING SPRING ARMS. IF REMOVAL IS REQUIRED AND SPRING ARMS DEFORM - EXTRACTOR CAN BE REPAIRED FOR RE-USE BY BENDING ARMS "OUT" TO THE DIMENSIONS SHOWN BELOW.

SMALL CALIBER — .505" ± .015"
(.222 ETC.)
REGULAR CALIBER — .615" ± .015"
(.30.06 ETC.)
MAGNUM CALIBER — .655" ± .015"
(7MM MAG. ETC.)

