

APPENDIX C

D A T A   S H E E T S

DATA SHEET NO. 1

# CUSTOMER SELECTION

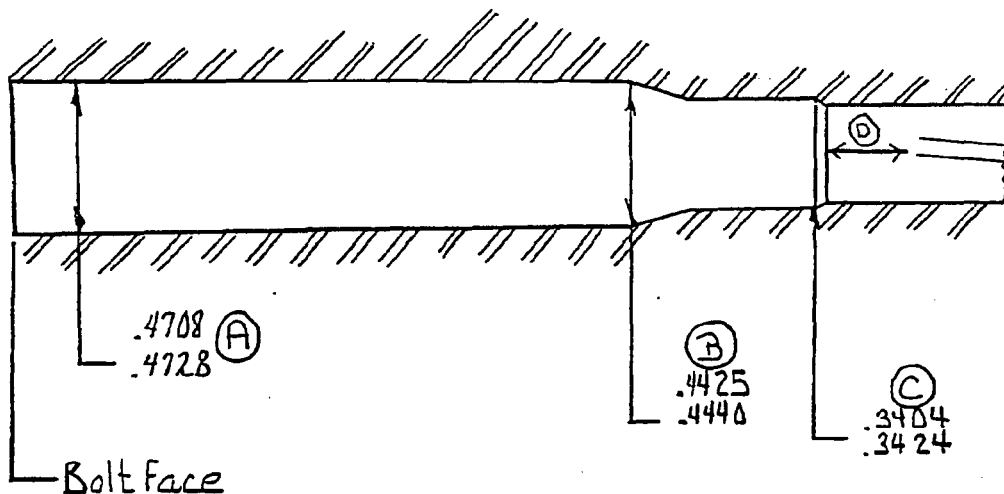
2/8/87

		1	2	3	4	5	6
	NAME	Browning BBR	Remington M1700 ADL	Ruger M177	Smith/Wesson M11500	Winchester M170 ZTR	
1	J. Lawerance	1	4	2	5	3	
2	S. Franz	1	3	5	2	4	
3	R. Nightingale	1	2	5	3	4	
4	J. Marrese	4	1	2	5	3	
5	E. Yetter	1	4	2	3	5	
6	F. Embhof	1	3	2	5	4	
7	D. Urtz	1	3	5	4	2	
8	C. Miller	1	4	3	2	5	
9	D. Findlay	1	2	3	4	5	
10	P. Nasypow	1	3	4	5	2	
11	J. Martin	3	4	1	5	2	
12	D. Bullis	1	3	4	5	2	
13	B. Panagian	1	4	3	5	2	
14	J. Bowers	1	2	5	4	3	
15	J. Baggetta	5	1	4	3	2	
16	T. Powers	3	2	4	5	1	
17	F. Supry	1	2	4	5	3	
18	D. Fiorentino	1	2	4	5	3	
19	J. Hennings	1	4	3	5	2	
20	S. Fanelli	5	2	1	4	3	
21	K. Caulkins	5	3	2	4	1	
22	T. Plunkett	2	1	5	4	3	
23	P. Hagen	4	3	1	2	5	
24	J. Stekel	4	3	1	5	2	
25	J. Brooks	1	4	5	3	2	
26	D. Williams	2	3	4	1	5	
27	W. Scram	3	2	5	1	4	
28	I. Capaletti	2	1	3	4	5	
29	J. Bechard	2	3	1	4	5	
30	R. Balaska	2	1	3	4	5	
31							
32							
33							
34							
35							
36							
37							
38							
39							
40							

PRELIMINARY MEASUREMENTS - BOLT ACTION RIFLES  
COMPETITIVE EVALUATION

DATA SHEET NO. 2  
C.J. Sweet  
MARCH 15, 1981

Gun No.		Headspace	Headspace after Proof	Firing Pin Indent (Avg. of 3)	Trigger Pull (Avg. of 3)	Safe ON OFF	Weight	Length	Center of Gravity	Bolt OPEN Force (Avg. of 3)	Bore Avg. of 5 meas.	Groove Avg. of 5 meas.	Twist	Safety Check
11	Remington - M700	Min + .002"	Min + .002"	.0267	8.75 lbs	5.31bs 7.71bs	7lbs 2oz	42 1/2 in.	1 1/2" rear	11 lbs 6 lbs	.308"	.3087"	1x9 1/2"	OK
12	30-06 cal. ADL	Min + .003"	Min + .003"	.025	4.00 lbs	5.61bs 5.71bs	6lbs 14oz	42 1/2 in.	1 1/2" rear	13 lbs 6 lbs				OK
13	30-06 cal. BDL	Min + .003"	Min + .003"	.0215"	4.00 lbs	5.11bs 5.41bs	7lbs 2oz	42 1/2 in.	1 1/2" rear	10 lbs 4 lbs				OK
14	243 cal. BDL VAR	Min + .002"	Min + .002"	.024"	4.00 lbs	5.31bs 5.91bs	8lbs 5oz	42 1/2 in.	1 1/2" rear	10 lbs 5 lbs	.3372"	.2431"	1x9 1/2"	OK
15	7MM MAG. Cal. BDL	Min + .002"	Min + .002"	.025"	4.25 lbs	5.41bs 2.01bs	7lbs 14oz	44 1/2 in.	0 9/16" rear	11 lbs 5 lbs	.2773"	.2843"	1x9 1/2"	OK
		X Min + .002"	Min + .002"	.024"	4.00 lbs	5.31bs 6.1"	7lbs 8oz	42 1/2 in.	1 1/2" rear	11 lbs 5 lbs				
	Browning - BBR													
21	30-06 cal. BBR (4 Groove)	Min + .002"	Min + .002"	.025"	5.50 lbs	5.01bs 3.51bs	7lbs 4oz	44 1/2 in.	1 1/2" rear	12 lbs 11 lbs	.3002"	.3080"	1x10"	OK
22	30-06 cal. BBR (4 Groove)	Min + .001"	Min + .001"	.023"	4.00 lbs	2.51bs 4.61bs	8lbs 2oz	44 1/2 in.	1 1/2" rear	13 lbs 11 lbs				OK
23	30-06 cal. BBR (4 Groove)	Min + .002"	Min + .002"	.024"	6.00 lbs	3.01bs 4.21bs	7lbs 14oz	44 1/2 in.	1 1/2" rear	12 lbs 7 lbs				OK
24	25-06 cal. BBR	Min + .002"	Min + .002"	.023"	6.00 lbs	3.41bs 4.51bs	8lbs 2oz	44 1/2 in.	1 1/2" rear	12 lbs 10 lbs	.2508"	.2576"	1x10"	OK
25	7MM MAG. Cal. BBR (4 Groove)	Min + .001"	Min + .002"	.025"	4.20 lbs	1.71bs 6.41bs	8lbs 0oz	44 1/2 in.	1 1/2" rear	13 lbs 7 lbs	.2783"	.2843"	1x9 3/4"	OK
		X Min + .002"	Min + .002"	.024"	5.51bs	3.11bs 5.11bs	8lbs 6oz	44 3/8 in.	1 1/2" rear	13 lbs 8 lbs				
	Winchester - 70 XTR													
31	30-06 cal. (4 Groove)	Min + .002"	Min + .002"	.023"	4.51bs	5.51bs 1.51bs	7lbs 4oz	43 in.	1 3/8" rear	8 lbs 5 lbs	.301"	.3087"	1x10"	OK
32	30-06 cal. (4 Groove)	Min + .005"	Min + .005"	.023"	5.50 lbs	7.21bs 2.51bs	7lbs 5oz	42 1/2 in.	1 3/8" rear	8 lbs 5 lbs				OK
33	30-06 cal. (4 Groove)	Min + .003"	Min + .003"	.021"	4.00 lbs	4.51bs 1.51bs	7lbs 2oz	42 1/2 in.	1 1/2" rear	8 lbs 5 lbs				OK
34	243 cal. VAR (4 Groove)	Min + .004"	Min + .004"	.0175"	7.50 lbs	7.51bs 2.01bs	9lbs 3oz	44 1/2 in.	1 3/8" rear	6 lbs 5 lbs	.2571"	.2439"	1x10"	OK
35	7MM Mag. Cal (6 Groove)	Min + .005"	Min + .005"	.023"	6.00 lbs	5.11bs 1.91bs	7lbs 6oz	43 in.	1 1/2" rear	8 lbs 6 lbs	.2228"	.2848"	1x9 3/8"	OK
		X Min + .003"	Min + .003"	.023"	6.01bs	6.11bs 1.91bs	7lbs 6oz	43 in.						
	Smith & Wesson - M1500													
41	30-06 cal. (4 Groove)	Min + .002"	Min + .002"	.0265"	4.20 lbs	3.01bs 3.01bs	7lbs 11oz	42 1/2 in.	2.0" rear	13 lbs 5 lbs	.3004"	.3083"	1x10"	OK
42	30-06 cal. (4 Groove)	Min + .003"	Min + .003"	.025"	4.25 lbs	3.51bs 3.21bs	7lbs 4oz	42 1/2 in.	1 1/2" rear	14 lbs 4 lbs				OK
43	30-06 cal. (4 Groove)	Min + .002"	Min + .002"	.025"	4.50 lbs	3.51bs 2.71bs	7lbs 4oz	42 1/2 in.	1 1/2" rear	13 lbs 5 lbs				OK
44	243 cal. (4 Groove)	Min + .003"	Min + .003"	.026"	4.50 lbs	2.31bs 2.11bs	7lbs 10oz	41 1/2 in.	1 1/2" rear	17 lbs 5 lbs	Min Gun	Wou/H/10"	1x10"	OK
45	7MM MAG. Cal. (4 Groove)	Min + .002"	Min + .002"	.026"	3.54 lbs	3.51bs 2.51bs	7lbs 10oz	43 1/2 in.	1.0" rear	14 lbs 5 lbs	.2766"	.2846"	1x9"	OK
	Ruger - M77													
51	30-06 cal	Min + .002"	Min + .002"	.0265"	4.01bs	2.81bs 3.21bs	7lbs 1oz	42 1/2 in.	2.5" rear	12 lbs 7 lbs	.3012"	.3082"	1x10"	OK
52	30-06 cal. 71ST	Min + .002"	Min + .002"	.026"	4.00 lbs	3.01bs 3.41bs	7lbs 5oz	42 1/2 in.	2.5" rear	14 lbs 6 lbs				OK
53	30-06 cal. 77R	Min + .002"	Min + .003"	.0265"	5.00 lbs	3.51bs 2.51bs	7lbs 6oz	42 1/2 in.	2.5" rear	12 lbs 5 lbs				OK
54	243 cal. VAR. 77V	Min + .004"	Min + .004"	.025"	4.11bs	3.61bs 2.51bs	9lbs 2oz	42 1/2 in.	1.0" rear	12 lbs 5 lbs	.2875"	.2431"	1x9 3/4"	OK
55	7MM MAG.	Min + .001"	Min + .001"	.0265"	4.00 lbs	3.01bs 2.51bs	7lbs 0oz	44 1/2 in.	2.0" rear	14 lbs 7 lbs	.2788"	.2851"	1x9 3/4"	OK

30-06 CAL. CHAMBER MEASUREMENTSData Sheet No. 3REMINGTON M/700 - #11

A- .4700"  
B- .4430"  
C- .3410"  
D- .2190"

BROWNING BER - #21

A- .4730"  
B- .4450"  
C- .3420"  
D- .0900"

WINCHESTER M/70XTR - #31

A- .4740"  
B- .4460"  
C- .3460"  
D- .0750"

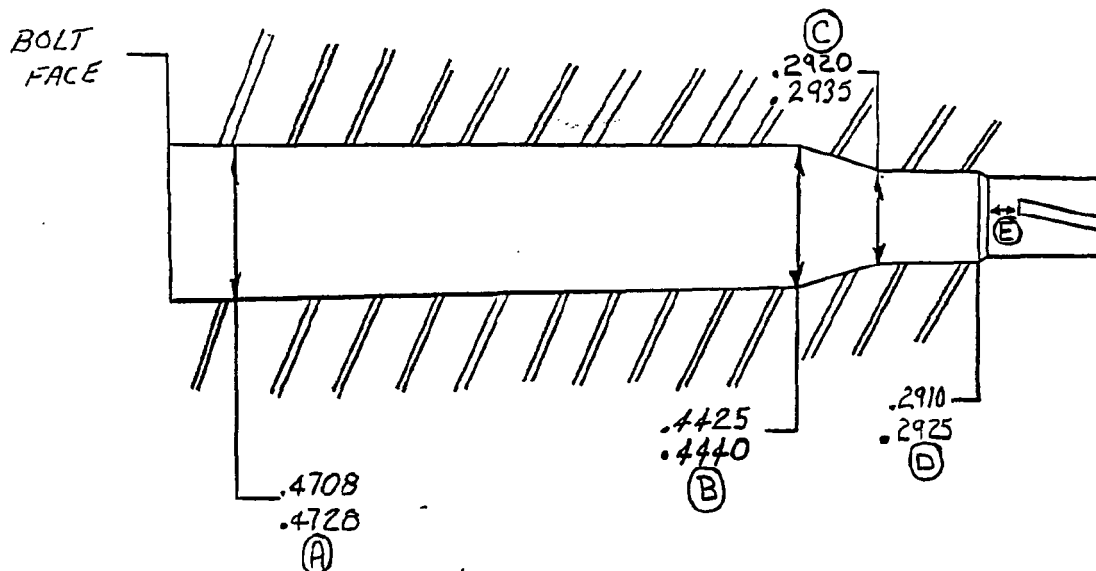
SMITH & WESSON M/1500 - #41

A- .4740"  
B- .4450"  
C- .3410"  
D- .2040"

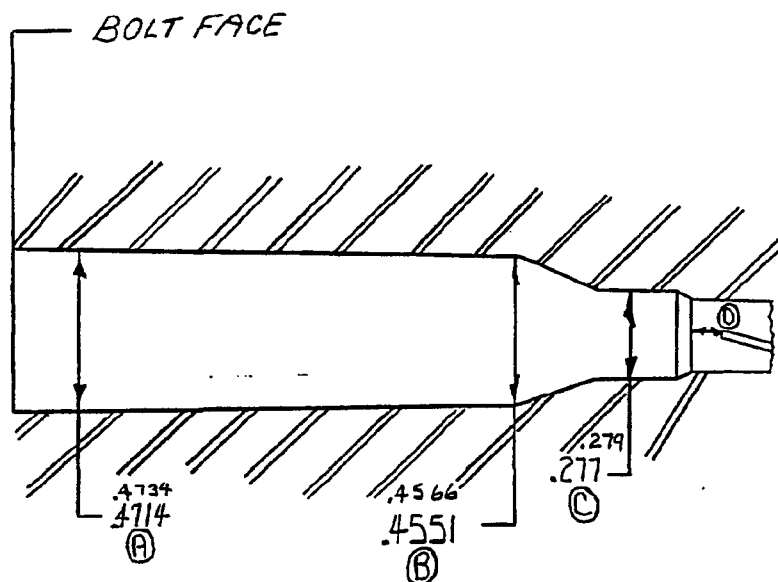
RUGER M/77 - #51

A- .4690"  
B- .4440"  
C- .3430"  
D- .1270"

CJS:cjs

25-06 CAL. CHAMBER MEASUREMENTSBROWNING BBR - #24

A- .4710"  
 B- .4450"  
 C- .2930"  
 D- .2920"  
 E- .1750"

REMINGTON M/700 - #14

A- .4710"  
B- .4550"  
C- .2790"  
D- .1580"

WINCHESTER M/70XTR - #14

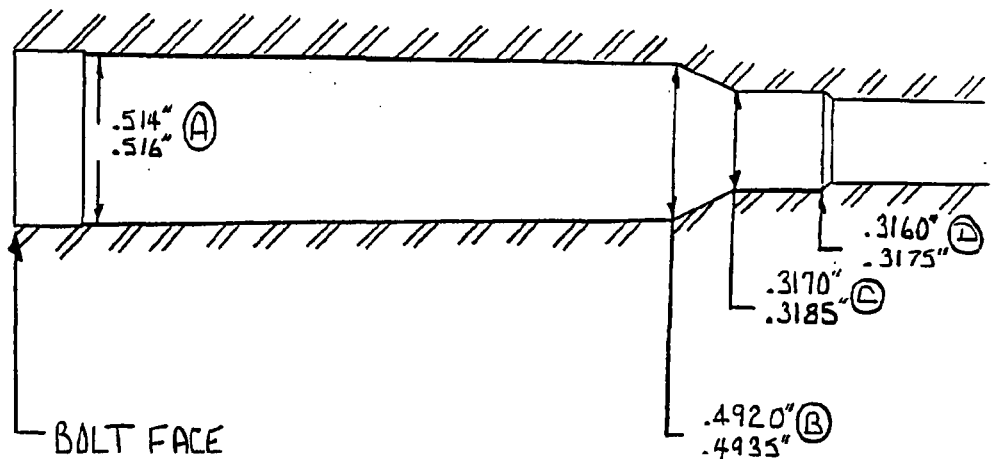
A- .4740"  
B- .4560"  
C- .2770"  
D- .0670"

SMITH AND WESSON M/1500 - #14

A- .4730"  
B- .4570"  
C- .2780"  
D- .1100"

RUGER M/ 77 - #54

A- .4740"  
B- .4580"  
C- .2780"  
D- .2280"

7MM MAG. CHAMBER MEASUREMENTSREMINGTON M/700 - #15

A- .5145"  
 B- .4930"  
 C- .3165"  
 D- .3180"

BROWNING BBR- #25

A- .5150"  
 B- .4930"  
 C- .3170"  
 D- .3180"

WINCHESTER M/70XTR- #35

A- .5180"  
 B- .4950"  
 C- .3200"  
 D- .3170"

SMITH & WESSON M/1500 - #45

A- .5150"  
 B- .4940"  
 C- .3200"  
 D- .3180"

Ruger M/77 - #55

A- .5140"  
 B- .4910"  
 C- .3190"  
 D- .3190"

CJS:cjs

Center fire Lock Time

DATA SHEET NO. 7

9-16-81

C.J.M.

R.E.N.

## Competitive Evaluation

	1	2	3	4	5	6
	Make	Rem	Win	Ruger	S+W	Browning
	Model	700	70XTR	M77	1500	BBR
	Serial Number	66275032	040304M	73-95020	AV001129	040304M12
1			61430481			
2						
3		10 <sup>3</sup> sec.				
4						
5						
6	1	3.3	3.8	4.1	3.8	3.6
7	2	3.3	4.0	4.2	3.8	3.6
8	3	3.3	4.1	4.2	3.8	3.4
9	4	3.3	4.0	4.2	3.8	3.5
10	5	3.3	4.1	4.2	3.8	3.3
11	6	3.2	3.8	4.2	3.8	3.4
12	7	3.3	4.0	4.2	3.8	3.2
13	8	3.3	4.1	4.2	3.8	3.1
14	9	3.2	4.1	4.2	3.8	3.4
15	10	3.4	4.0	4.2	3.9	3.3
16						
17						
18	3	Avg.	3.29	4.00	4.19	3.81
19						
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DATA SHEET NO 8  
C. J. Sweet  
9-17-81

ACCURACY SUMMARY SHEETS - BOLT ACTION  
1981 COMPETITIVE EVALUATION

1	2	3	4			5			6		
			AT 50 YARDS			AT 500 YARDS			AT 1000 YARDS		
7	8	9	MEAN GROUP SIZE	MEAN VERT.	MEAN HORIZ.	MEAN GROUP SIZE	MEAN VERT.	MEAN HORIZ.	MEAN GROUP SIZE	MEAN VERT.	MEAN HORIZ.
			SIZE	VERT.	HORIZ.	SIZE	VERT.	HORIZ.	SIZE	VERT.	HORIZ.
10	11	12	13	14	15	16	17	18	19	20	21
22	23	24	25	26	27	28	29	30	31	32	33
34	35	36	37	38	39	40	41	42	43	44	45
46	47	48	49	50	51	52	53	54	55	56	57
58	59	60	61	62	63	64	65	66	67	68	69
70	71	72	73	74	75	76	77	78	79	80	81
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598	599	600	601	602	603	604	605	606	607	608	609
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634	635	636	637	638	639	640	641	642	643	644	645
646	647	648	649	650	651	652	653	654	655	656	657
658	659	660	661	662	663	664	665	666	667	668	669
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694	695	696	697	698	699	700	701	702	703	704	705
706	707	708	709	710	711	712	713	714	715	716	717
718	719	720	721	722	723	724	725	726	727	728	729
730	731	732	733	734	735	736	737	738	739	740	741
742	743	744	745	746	747	748	749	750	751	752	753
754	755	756	757	758	759	760	761	762	763	764	765
766	767	768	769	770	771	772	773	774	775	776	777
778	779	780	781	782	783	784	785	786	787	788	789
790	791	792	793	794	795	796	797	798	799	800	801
802	803	804	805	806	807	808	809	810	811	812	813
814	815	816	817	818	819	820	821	822	823	824	825
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862	863	864	865	866	867	868	869	870	871	872	873
874	875	876	877	878	879	880	881	882	883	884	885
886	887	888	889	890	891	892	893	894	895	896	897
898	899	900	901	902	903	904	905	906	907	908	909
910	911	912	913	914	915	916	917	918	919	920	921
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934	935	936	937	938	939	940	941	942	943	944	945
946	947	948	949	950	951	952	953	954	955	956	957
958	959	960	961	962	963	964	965	966	967	968	969
970	971	972	973	974	975	976	977	978	979	980	981
982	983	984	985	986	987	988	989	990	991	992	993
994	995	996	997	998	999	1000	1001	1002	1003	1004	1005

Remington M-707  
30.06 cal. RDL  
243 cal. BDL VNR  
7MM Rem. Mag. BDL

RODWINING BBP  
30.06 cal. ADL (6 Groove)  
25.06 cal. (6 Groove)  
7MM Rem. Mag. (6 Groove)

WINCHESTER TOXTR  
30.06 cal. (4 Groove)  
243 cal. VAP. (6 Groove)  
7MM Rem. Mag. (6 Groove)

SMITH WESSON M-1500  
30.06 Cal. (4 Groove)  
243 Cal. (4 Groove)  
7MM Rem. Mag. (4 Groove)

PIPER M-77  
30.06 CAL.  
243 W.I. VAP.  
7MM Rem. Mag.

CONTROL RIFLES  
Verifications of Ammo used  
(Piper M-77 Group 1-5)  
Rem. M-40X.B. - 7MM MAG  
Rem. M-40X.B. - 30.06 Cal.  
Piper M-40X.B. - 243 Cal.  
Piper M-40X.B. - 25.06 Cal.

REM. STANDARDS

30.06 - 5 Shot Group  
7MM MAG. - "  
25.06 - "  
243 VAP. - "  
243 Cal. - "

\* \* - OUT OF REM. STANDARD

APPENDIX D

I N S T R U C T I O N   M A N U A L S

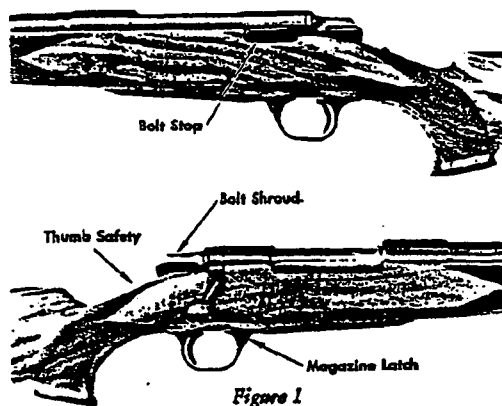


## BROWNING

### BOLT ACTION HIGH POWER RIFLE

#### NOMENCLATURE

In conventional gun terminology the position and movement of gun parts are described as they occur with the gun horizontal and in normal firing position; i.e., the muzzle is forward or front; the butt stock is rearward or rear; the trigger is downward or underneath; the sights are upward or on top. For general nomenclature refer to Figure 1.



## SERIAL NUMBER

The serial number of your rifle can be found on the side of the receiver.

### CAUTION

1. ALWAYS OPEN THE BOLT AND USUALLY CHECK THE CHAMBER AND MAGAZINE OF YOUR RIFLE to be certain that it does not inadvertently contain any ammunition. Whenever you are not actually firing your rifle, keep the safety in the "ON SAFE" position (see page 6) by sliding the safety to the rear so the RED warning dot cannot be seen.

2. BEWARE OF BARREL OBSTRUCTIONS for the safety of both your rifle and yourself. Before you load your rifle, open the bolt. BE SURE NO LIVE ROUND IS IN THE CHAMBER OR MAGAZINE — then remove the bolt and glance through the bore from the chamber end to be sure it is clear of any obstruction.

Be careful how you carry your rifle. Do not permit the muzzle to dip into mud, snow or water. Do not thrust your barrel through a thicket with the possibility of ramming a twig into the bore. Mud, snow and an infinite variety of other objects may inadvertently lodge in a barrel. It takes only one small obstruction to increase pressures dangerously.

Before the first firing of your rifle, clean the bore using a cleaning rod and patch. Wipe away any anti-rust compounds present in the action-chamber areas.

2

3. ALWAYS KEEP YOUR RIFLE'S SAFETY IN THE "ON SAFE" POSITION even if you are certain the rifle is unloaded. Check and double check, frequently. Be sure contact with brush, a tumble on slippery terrain, the moment of excitement after a shot, or a dozen other seemingly innocent incidents have not left you with a rifle, OFF SAFE. Safe gun handling does not stop with your rifle's mechanical safety. It starts there. Handle your rifle at all times with deep respect and with alert consideration to all within its range.

4. ALWAYS KEEP THE MUZZLE OF YOUR RIFLE POINTED IN A SAFE DIRECTION even though you are certain the rifle is unloaded and "ON SAFE." Never point your rifle at anything you do not intend to shoot.

5. ALWAYS UNLOAD YOUR RIFLE WHEN NOT IN USE. Store your rifle and ammunition separately — beyond the reach of children.

6. DO NOT SNAP THE HAMMER ON AN EMPTY CHAMBER — THE CHAMBER MAY NOT BE EMPTY! Treat every gun with the respect due a loaded gun — even though you are certain the gun is unloaded.

It is unnecessary to snap the hammer to prevent weakening the main spring. It will not weaken even though the hammer is left cocked indefinitely. Neither will snapping the hammer on an empty chamber damage or break the firing pin.

3

7. **WHENEVER YOU HAND YOUR RIFLE TO ANOTHER PERSON** always open the bolt. Whenever you accept a gun from another person, open the bolt if it isn't open, and inspect the chamber and magazine to be sure all live rounds are cleared.

8. **BE SURE OF YOUR BACKSTOP.** Know the range of your rifle and be certain there is no chance of damage or accident. Never shoot at water or hard objects.

9. **FOR EYE AND EAR PROTECTION** we recommend that you always wear shooting glasses and hearing protection when shooting.

10. **AMMUNITION** — Your rifle must be loaded only with cartridges of the correct caliber as inscribed on the side of the barrel. The barrel and action of this rifle have been made with large safety margins over the pressures developed by established commercial loads. Nevertheless, Browning can assume no responsibility for incidents which occur through use of cartridges of non-standard dimension or those developing pressures in excess of SAAMI (Sporting Arms and Ammunition Manufacturers' Institute) established standards.

### ASSEMBLY

1. Clean the anti-rust compound from the barrel, the receiver, and the bolt with a clean rag and light gun oil such as Browning Gun Oil or Browning Liquid Gunsmith.

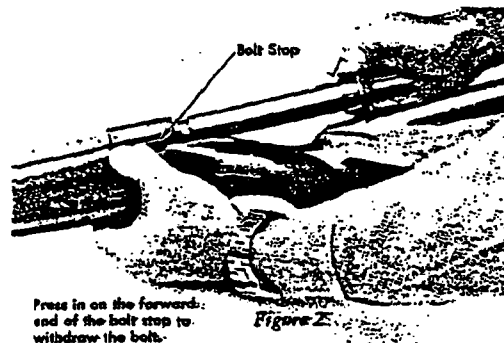
4

2. In order to insert the bolt the thumb safety must be pushed forward **OFF SAFE**. Align the forward end of the bolt in the rear opening of the receiver. Push the bolt completely forward and rotate the handle down to lock it. It is not necessary to depress the bolt stop to insert the bolt. Return the thumb safety to the "ON SAFE" position.

The rifle is now completely assembled and the bolt may be operated normally.

### TO REMOVE THE BOLT

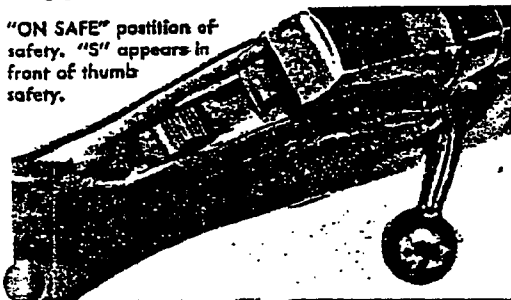
Verify that there are no cartridges in the chamber or in the magazine. Press in on the forward end of the bolt stop and draw the bolt to the rear completely removing it from the rifle. The bolt stop is the horizontal bar on the left side of the receiver. (See Figure 2.)



5

### OPERATION OF THE SAFETY

"ON SAFE" position of safety. "S" appears in front of thumb safety.



OFF SAFE or FIRE position. Red Warning dot appears behind safety.

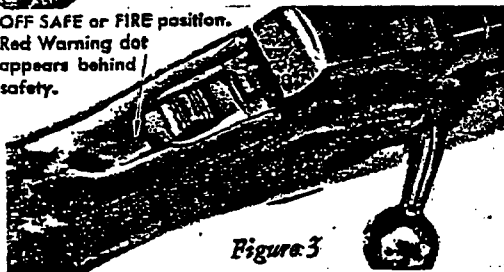


Figure 3

The safety is located on the top tang at the rear of the receiver. When the safety is drawn to the rear, the gun is "ON SAFE" with the trigger blocked and the bolt locked in a closed position. In this position an "S" will appear in front of the safety.

When the safety is pushed forward, the "S" will be covered and a red dot will appear indicating that the rifle is OFF SAFE and ready to fire. Whenever a cartridge is chambered, the rifle should be kept "ON SAFE" until you desire to fire it.

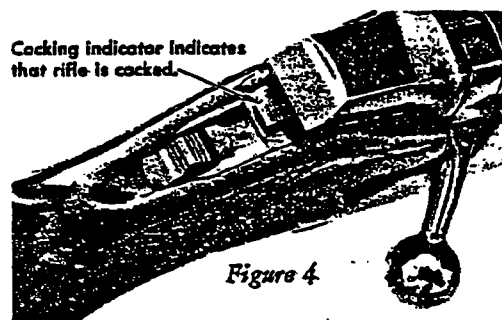
6

### TO DRAW THE BOLT REARWARD

**CAUTION:** The safety must be in the OFF SAFE position, whenever you wish to draw the bolt rearward. Therefore, exercise extreme caution whenever you are operating the bolt. In accordance with gun safety always assume your rifle is loaded, and be sure your muzzle is pointed in a safe direction when you operate the bolt.

### COCKING INDICATOR

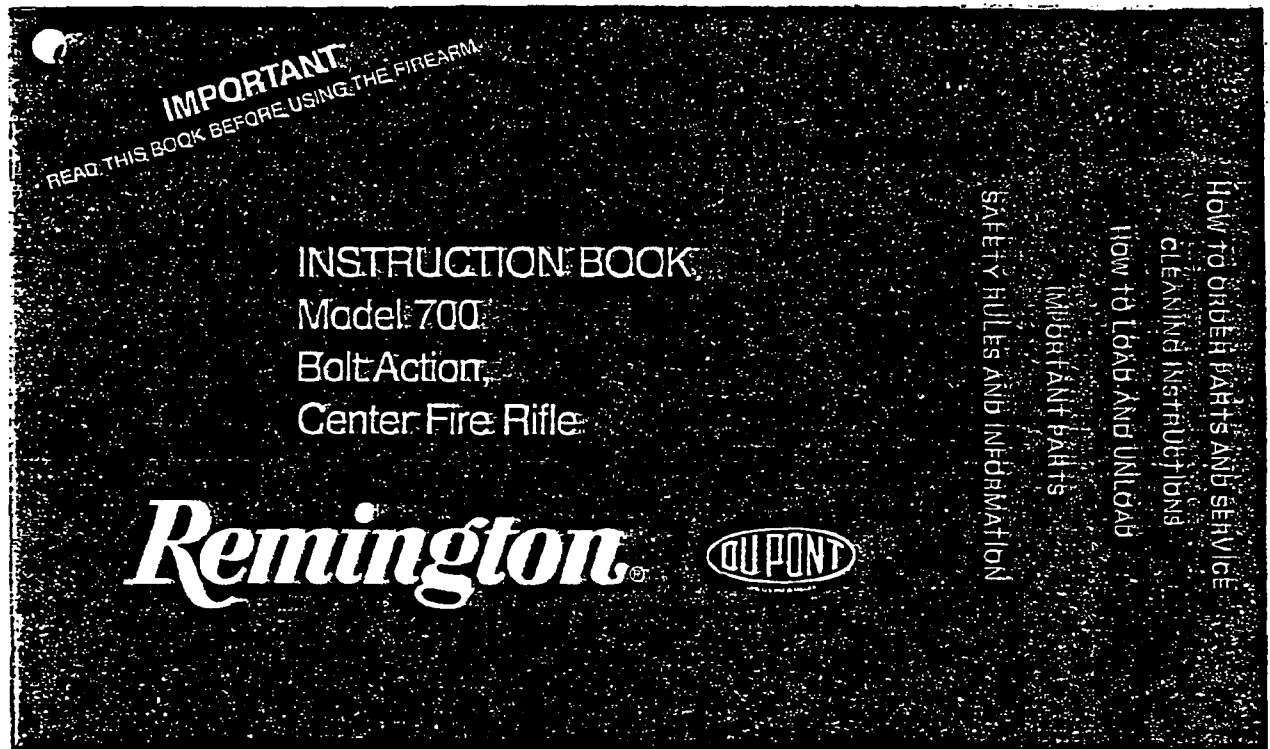
Below the bolt shroud and ahead of the safety will be found a serrated cocking indicator. This indicator is painted red. When the rifle is cocked it may be readily felt and seen. When the rifle is fired, the cocking indicator retracts into the bolt shroud and cannot be felt. (See Figure 4.)

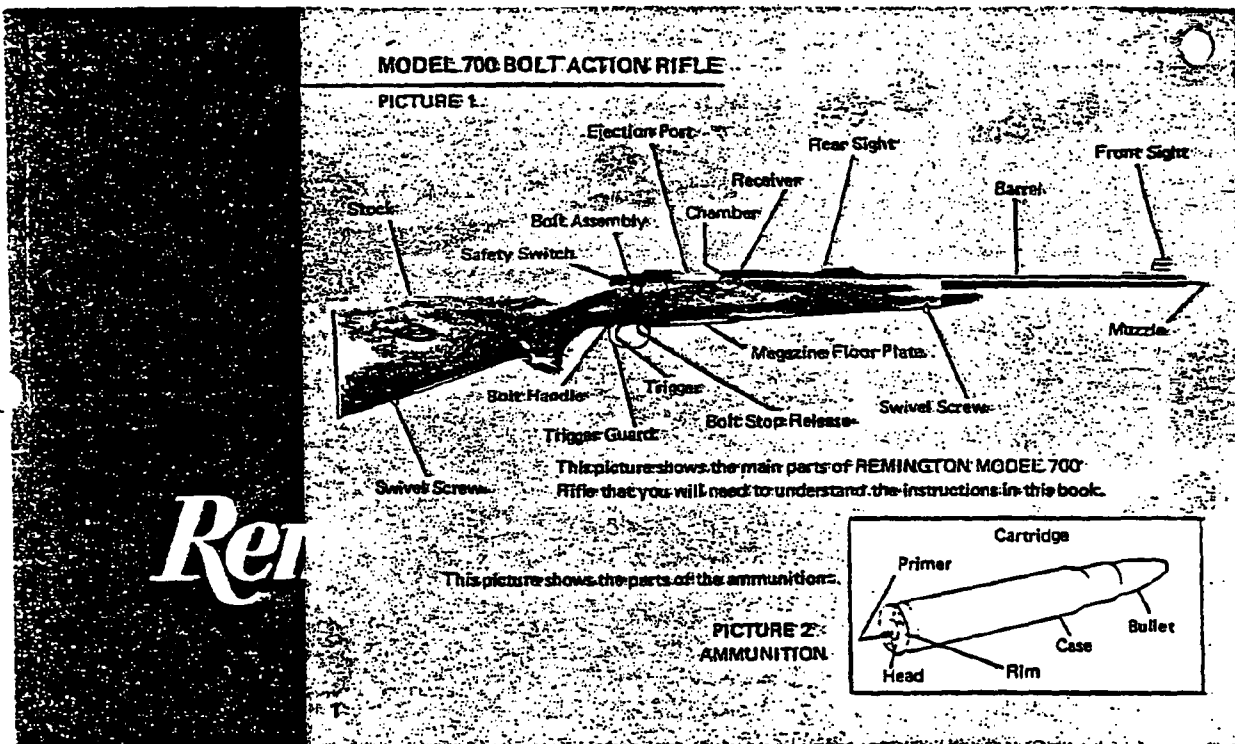


Cocking indicator indicates that rifle is cocked.

Figure 4

7





## **C** READ THESE SAFETY RULES

- To use your firearm correctly and safely, read and follow the instructions in the enclosed firearms safety booklet and this instruction book.
- Always keep the muzzle pointed in a safe direction.
- Keep the barrel clean, and free of obstructions.
- Unload firearms when not in use. Keep firearms and ammunition away from children. Lock firearms and ammunition in separate cabinets.
- Unload your firearm before climbing up or over a fallen tree, fence or slippery area.
- Before you pull the trigger, make sure you can see the target clearly, and the path of the bullet beyond the target.
- Never fire at water, rocks, or any hard surface.
- Never enter a vehicle with a loaded firearm, or put a loaded firearm in a vehicle. Unload the firearm, then put it in a gun case for safe transport.
- Never shoot and drink alcoholic beverages at the same time.
- Check your firearm periodically to make sure it is mechanically correct. Keep the firearm clean.
- Do not play with the safety switch. Use it as shown in this book.

SAFETY RULES AND INFORMATION

Important parts

How to load and unload

Cleaning instructions

How to order parts and service

## SAFETY INFORMATION

View No.	Part No.	
42	24476	Sear
43	30855	Slin
	26990	Slin
44	33366	Sto
	33371	Sto
	18186	Sto
	16970	Sto
45	26555	Sw
46	26345	Tri
47	15281	Tri
48	26371	Th
49	0904	Win
		S
		San
	91837	Ext
		M
	90906	Ext
	22021	Fir
		R
		R
	22041	Fir
		Z
		R



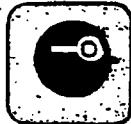
## NEVER USE THE WRONG AMMUNITION:

- Only use ammunition of the correct caliber, that is in good condition.
- Before loading, check the caliber shown on the ammunition, and caliber shown on the firearm. They must be the same caliber.
- Handloads can be dangerous. Remington Arms Company, Inc., is not responsible for accidents or damage caused by badly loaded handloads.



## NEVER MAKE ADJUSTMENTS:

- Do not make changes or alterations to any parts of a firearm. Use only REMINGTON parts.
- Never make an adjustment to the trigger, or change the shape or size of the sear, sear notch, or other parts.



## EYE PROTECTION:

- Wear safety glasses when using a firearm.



## EAR PROTECTION:

- Wear hearing protectors when firing to adjust the sights.



## IMPORTANT PARTS OF THE FIREARM

### THE SAFETY SWITCH

The safety switch provides protection against accidental or unintentional discharge under normal usage when properly engaged.

To engage the safety switch, put the switch in the "S" position. See picture 3.

Always put the safety switch in the "S" position when the firearm is loaded and not ready for firing.

The bolt handle cannot be lifted when the safety switch is in the "S" position. See picture 3.

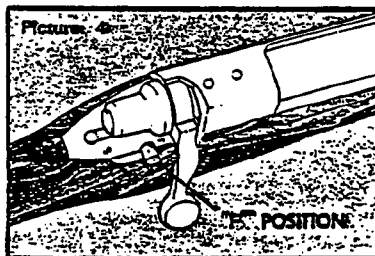
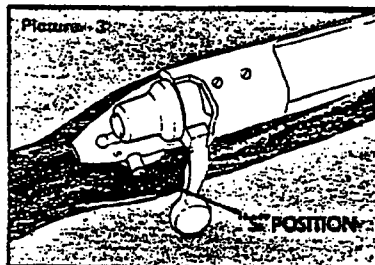
When you are ready to fire the firearm, put the safety switch in the "F" position. See picture 4.

Never pull the trigger when the safety switch is in the "S" position.

**WARNING:** The firearm will fire when the trigger is pulled and the safety switch is in the "F" position.



Even when the safety switch is in the "S" position, careless handling can cause the firearm to fire.



HOW TO ORDER PARTS AND SERVICE  
CLEANING INSTRUCTIONS  
HOW TO LOAD AND UNLOAD  
IMPORTANT PARTS

## THE BOLT ASSEMBLY

View No.	Part No.
42	24476
43	30855
	26990
44	33366
	33371
	18186
	16970
45	26555
46	26345
47	15281
	26371
	90904
	91837
	90906
	22021
	22041



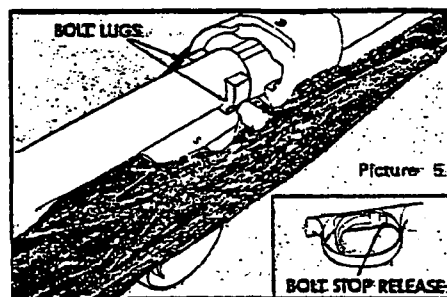
The bolt assembly locks the cartridge into the chamber.

## TO INSTALL THE BOLT ASSEMBLY:

1. Point the firearm in a safe direction.
2. Put the safety switch in the "F" position.
3. Align the lugs on the bolt assembly with the receiver. See picture 5.
4. Slide the bolt assembly into the receiver and push all the way in.
5. To lock the bolt assembly into position push the bolt handle down.

## TO REMOVE THE BOLT ASSEMBLY:

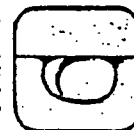
1. Point the firearm in a safe direction.
2. Put the safety switch in the "F" position.
3. Do not touch the trigger while moving the safety switch.
4. Raise the bolt handle.
5. Put the safety switch in the "S" position.
6. Pull the bolt handle all the way back.
7. Push the bolt stop release. See picture 5.
8. As you push the bolt stop release, slide the bolt from the firearm.



## THE TRIGGER ASSEMBLY

Pulling the trigger fires the firearm.

The trigger is adjusted at the factory. All adjustments to the trigger must be made by the factory or a REMINGTON RECOMMENDED GUNSMITH.



Never remove the trigger mechanism, or make adjustments to the trigger or trigger assembly.



NEVER put your finger on the trigger unless you are going to fire the firearm.



## THE BARREL

The inside of the barrel must be clean and free of obstructions.

### I. TO CHECK THE INSIDE OF THE BARREL:

1. Point the firearm in a safe direction.
2. Put the safety switch in the "F" position.
3. Raise the bolt handle.
4. Put the safety switch in the "S" position.
5. Pull the bolt handle all the way back.
6. Remove any ammunition from the chamber or magazine. See page 8.
7. Remove the bolt. See page 5.
8. Look through the inside of the barrel from the chamber end to the muzzle. See picture 1.

### II TO REMOVE OBJECT FROM INSIDE THE BARREL:

1. Use the correct size cleaning rod.
2. Push the cleaning rod from the chamber end all the way through the barrel, until the rod comes out the muzzle.
3. If an object cannot be easily pushed out of the barrel with a cleaning rod, return the firearm to the factory or a REMINGTON RECOMMENDED GUNSMITH.



NEVER try to remove an object from the barrel by loading another cartridge and firing.

### III TO CLEAN THE BARREL FOLLOW INSTRUCTIONS SHOWN ON PAGE 11.

Before loading the firearm make sure the inside of the barrel is free of dirt, or other objects.

HOW TO ORDER PARTS AND SERVICE  
CLEANING INSTRUCTIONS  
HOW TO LOAD AND UNLOAD

## TO LOAD THE FIREARM

### I TO LOAD THE MAGAZINE AND CHAMBER:

1. Point the firearm in a safe direction.
2. Put the safety switch in the "F" position.
3. Raise the bolt handle.
4. Put the safety switch in the "S" position.
5. Pull the bolt handle all the way back.
6. Push four cartridges of the correct caliber, one at a time into the magazine. If the firearm is a magnum, you only load three cartridges. Keep the bullets aligned toward the chamber. See picture 6.
7. Put one cartridge into the chamber.
8. Use your fingers to push the cartridges in the magazine all the way down. Slowly slide the bolt assembly forward, so that the bolt slides over the top of the cartridges in the magazine.
9. Push the bolt handle down.

THE FIREARM IS NOW LOADED.

10. To fire the firearm put the safety switch in the "F" position.

THE FIREARM IS READY TO FIRE.

### II TO LOAD ONE CARTRIDGE ONLY:

1. Point the firearm in a safe direction.
2. Put the safety switch in the "F" position.
3. Raise the bolt handle.
4. Put the safety switch in the "S" position.

7

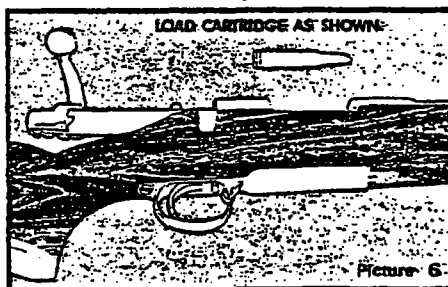
5. Pull the bolt handle all the way back.
6. Put one cartridge of the correct caliber on the magazine follower, or in the chamber. See picture 6.
7. Slide the bolt handle forward, then push the bolt handle down to lock the cartridge into the chamber.

THE FIREARM IS NOW LOADED.

8. To fire the firearm put the safety switch in the "F" position.

THE FIREARM IS READY TO FIRE.

WARNING: Always check the cartridge for the correct caliber before loading the firearm.



## TO UNLOAD THE FIREARM

There are two types of Model 700 rifles, one with a FLOOR PLATE and one without a FLOOR PLATE.

### INSTRUCTIONS FOR THE MODELS WITH A FLOOR PLATE

1. Point the muzzle in a safe direction.
2. Put the safety switch in the "F" position.
3. Raise the bolt handle.
4. Put the safety switch in the "S" position.
5. Put one hand over the top of the ejection port.
6. Slowly pull the bolt handle back with your other hand to remove the cartridge from the chamber.
7. Hold the cartridge and remove it from the firearm.
8. Put your hand under the floor plate.
9. Push the floor plate latch to release the floor plate. See picture 7.
10. The magazine spring and follower will be released from the magazine.
11. Remove released cartridges.
12. Push in the magazine follower, then close the floor plate.

**WARNING:** Make sure there are no cartridges in the chamber or magazine.

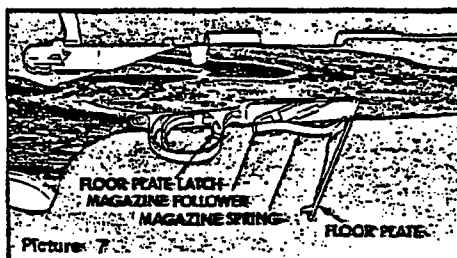
### INSTRUCTIONS FOR THE MODELS WITHOUT A FLOOR PLATE

1. Point the muzzle in a safe direction.
2. Put the safety switch in the "F" position.
3. Raise the bolt handle.
4. Put the safety switch in the "S" position.
5. Put one hand over the top of the ejection port.
6. Slowly pull the bolt handle back with your other hand to remove the cartridge from the chamber.




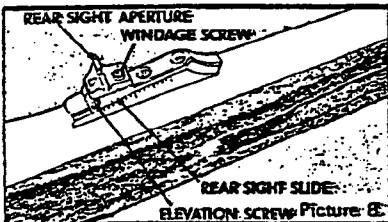



7. Hold the cartridge and remove it from the firearm.
8. Keep the muzzle pointed up, push the bolt handle slowly forward until the cartridge is released from the magazine. **CAUTION:** The cartridge may slide into the chamber, if the bolt is pushed too far forward. See note below.
9. Pull the bolt handle fully back and remove the cartridge from the ejection port.
10. Repeat this action until the magazine is empty.

**WARNING:** Check the chamber and the magazine to make sure there are no cartridges in the firearm.

**NOTE:** If the bolt is pushed all the way forward, and a cartridge slides into the chamber, the gun can be fired. Normally, the cartridges will slide out of the chamber when the bolt is pulled back. If the cartridge remains in the chamber, point the muzzle in a safe direction, slide the bolt forward all the way and push the bolt handle down to lock the bolt. Then repeat steps 2 through 10 above.



HOW TO OBERE PARTS AND SERVICE  
CLEANING INSTRUCTIONS  
HOW TO LOAD AND UNLOAD

View No.	F	TO ADJUST THE SIGHTS	POSITION ON TARGET	ADJUSTMENTS	
42 43 44	24 30 26 33 33 18 16	 <p>The sights are adjusted at the factory to hit a target at 100 yards. NOTE: For all models except the Varmint and Classic Grade,</p>	 <p>Bullet hits above the center.</p>	<ol style="list-style-type: none"><li>Loosen the elevation screw on the rear sight.</li><li>Slide the rear sight down (backward) on the ramp.</li><li>Tighten the elevation screw.</li></ol>	
45 46 47 48 49	26 26 15 26 90	<p><b>TO ADJUST THE REAR SIGHT</b></p> <p>Move the rear sight in the same direction as you need to move the bullet on the target.</p> 	 <p>Bullet hits below the center.</p>	<ol style="list-style-type: none"><li>Loosen the elevation screw on the rear sight.</li><li>Slide the rear sight up (forward) on the ramp.</li><li>Tighten the elevation screw.</li></ol>	
918			 <p>Bullet hits to the left.</p>	<ol style="list-style-type: none"><li>Loosen the windage screw on the rear sight.</li><li>Slide the rear sight aperture to the right.</li><li>Tighten the windage screw.</li></ol>	
909 220		<p><b>NOTE:</b> For more information on ballistics and trajectory, see the REMINGTON catalog.</p>	 <p>Bullet hits to the right.</p>	<ol style="list-style-type: none"><li>Loosen the windage screw on the rear sight.</li><li>Slide the rear sight aperture to the left.</li><li>Tighten the windage screw.</li></ol>	
220		<p><b>TELESCOPIC SIGHTS</b></p> <p>The top of the receiver has holes for the installation of telescopic sights.</p>			

9

### TO ASSEMBLE THE SLING STRAP

See picture 9 for the location of parts:

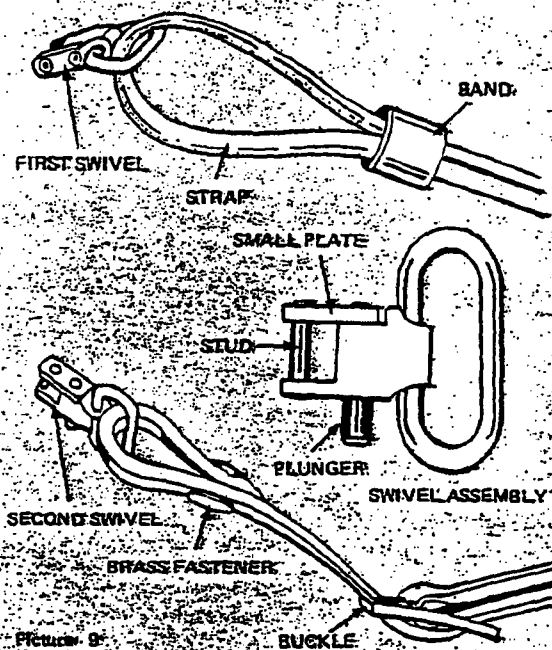
1. Slide the strap through the band.
2. Push the strap up through the first swivel.
3. Slide the strap back through the band.
4. Push the strap into and through the buckle.
5. Push the strap down and through the second swivel.
6. Align the slots in the strap and fasten with the brass fastener.

### TO ATTACH THE SLING STRAP ASSEMBLY TO THE STOCK.

See picture 9 for location of parts:

7. Push plunger on swivel until the small plate lifts and is free of the stud.
8. Push the stud into the center of the swivel screw.
9. Close the plate on the swivel to lock the swivel to the swivel screw.
10. To adjust the length of the strap, pull the strap through the buckle.

**TO REMOVE THE SLING FROM THE STOCK**  
To remove the sling strap assembly from the stock repeat step 7.



Picture 9

HOW TO ORDER PARTS AND SERVICE  
CLEANING INSTRUCTIONS

## LUBRICATION AND MAINTENANCE



### TO CLEAN THE BARREL

**WARNING:** Check the chamber and magazine to make sure there are no cartridges in the firearm.

1. Use the instructions and the equipment provided in a good cleaning kit.
2. Remove the bolt assembly. See page 5.
3. Select the correct caliber cleaning brush and attach the brush to the cleaning rod.
4. Put the cleaning brush into the gun cleaning solvent.
5. Push the cleaning rod through the barrel several times. **NOTE:** Always clean the barrel from the chamber end to the muzzle.
6. Push the correct cleaning patch through the bore.
7. Repeat several times using a new cleaning patch each time, until the patch is not dirty.
8. Apply a thin coat of oil to the outside of the barrel with a soft cloth.
9. Clean the varmint models with a wire brush and cleaning patches after firing 25 cartridges.

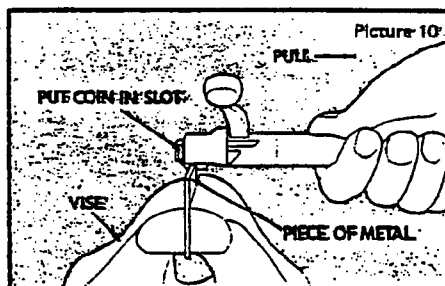
**WARNING:** Before you replace the bolt assembly, make sure the barrel is free of obstructions.

**WARNING:** This firearm should be checked periodically by The Remington Arms Company Inc. or a REMINGTON RECOMMENDED GUNSMITH. This will insure proper inspection and any necessary replacement of worn or damaged parts.

# INSTRUCTIONS FOR CLEANING THE BOLT ASSEMBLY

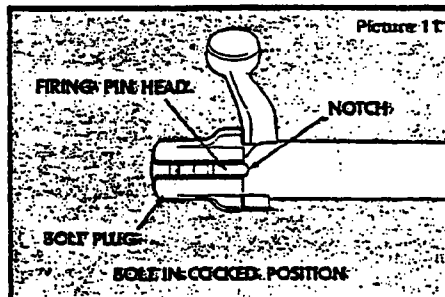
## TO DISASSEMBLE THE BOLT FOR CLEANING

1. Remove the bolt assembly from the firearm. See page 5.
2. Put the notch on the firing pin head over a metal edge. Pull the bolt assembly away from the firing pin. A coin can be put into the slot near the back edge of the firing pin head. See picture 10.
3. Hold the bolt assembly and turn the bolt plug until the firing pin assembly can be removed from the bolt assembly. CAUTION: Clean the firing pin assembly as a unit.
4. Clean all parts with gun cleaning solvent. Dry with a clean cloth.
5. Apply a thin coat of oil to prevent rusting.



## TO ASSEMBLE

1. Put the firing pin assembly into the rear of the bolt assembly.
2. Tighten the bolt plug into the bolt assembly with your hand.
3. Pull the coin from the slot in the firing pin head.
4. Turn the bolt plug until the firing pin head goes into the small notch on the rear rim of the bolt. The bolt is now cocked. See picture 11. NOTE: The bolt must be cocked to be assembled into the rifle.
5. Assemble the bolt assembly into the rifle. See page 5.



12

HOW TO ORDER PARTS AND SERVICE  
CLEANING INSTRUCTIONS

### TO CLEAN THE ACTION

1. Remove the bolt assembly. See page 5.
2. Turn the rifle upside down.
3. Remove the screws from the trigger guard. See picture 12, or picture 13.
4. Lift the stock away from the action.

**NOTE: MODELS WITHOUT A FLOOR PLATE:**  
Remove the magazine spring and follower from the magazine.

**NOTE: MODELS WITH A FLOOR PLATE:**  
Remove the magazine spring and follower from the receiver.

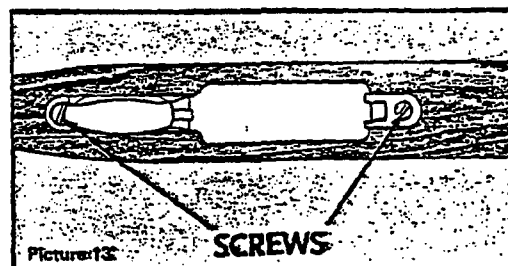
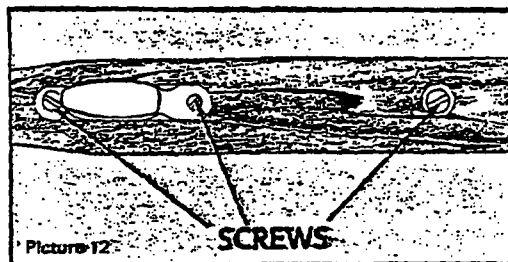
5. Clean the action with a gun cleaning solvent and dry with a cloth.  
Apply a thin coat of oil to prevent rust.

### TO ASSEMBLE THE MODELS WITHOUT A FLOOR PLATE

1. Put the magazine follower and the spring into the magazine.
2. Put the stock over the action.
3. Replace and tighten the screws on the trigger guard.
4. Replace the bolt assembly.

### TO ASSEMBLE THE MODELS WITH A FLOOR PLATE

1. Put the magazine all the way into the bottom of the receiver.
2. Assemble the trigger guard assembly on the stock.
3. Put the stock over the action.
4. Replace and tighten the trigger guard screws.
5. Replace the bolt assembly.



## D HOW TO ORDER PARTS FROM THE REMINGTON FACTORY

### TO ORDER PARTS:

1. Use the picture on page 15 to find the correct part name and number.
2. Write the model and serial number of your firearm, and the part name and number on the parts order.
3. Send parts order to:  
Arms Service Division  
Remington Arms Company, Inc.  
Ilion, New York 13357

- i. We can ship your order on a C.O.D. basis or provide an estimate of your required remittance.

NOTE: Bolts, barrels or receivers for centerfire rifles, pistols and rimfire rifles are not sold separately. Repairs or replacements for these parts must be done by Remington Arms Company, Inc. Barrels and bolts for shotguns are available as parts.

**WARNING:** Use only Remington parts in Remington firearms.

### TO ORDER FACTORY SERVICE:

Write a short description of the problem.

1. Give the model and serial number. Make a copy of this note. Attach the original note to the firearm, and put the copy in an envelope attached to the outside of the shipping box.

2. Make sure the gun is unloaded. Never include any ammunition in the package with the firearm.
3. Send by either United Parcel Service or Parcel Post. NOTE: Make sure the gun is unloaded, and there is no ammunition in the box.
4. Get insurance for the firearm.
5. Record serial number, it is required when calling factory to inquire if firearm has been received for repairs.

### INSTRUCTION BOOKS:

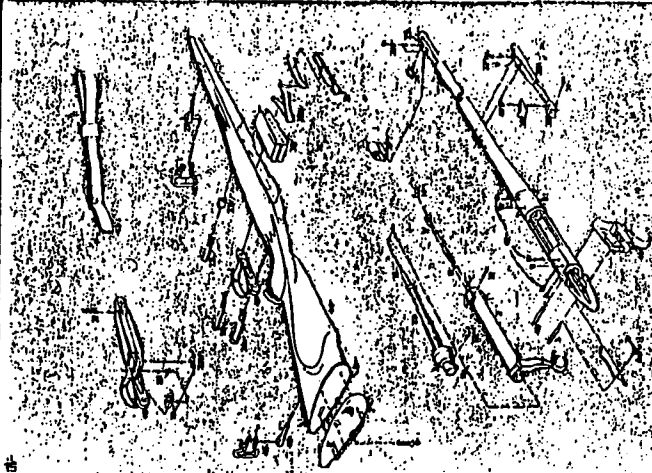
To get instruction books for any Remington firearm, write to Remington Arms Company, Inc., Arms Service Division, Ilion, New York 13357. Give the model, serial number, gauge or caliber.

### REMINGTON RECOMMENDED GUNSMITHS:

A listing is available from Remington Arms Company, Inc., 939 Barnum Avenue, Bridgeport, Conn. 06602.

HOW TO ORDER PARTS AND SERVICE

# MODEL 700 Bolt Action Center Fire Rifle



## MODEL 700 - PARTS LIST

PARTS SUBJECT TO CHANGE WITHOUT NOTICE:  
FOB Ilion, N.Y.

View No.	Part No.	NAME	View No.	Part No.	NAME
		NOTE: Each 5000 Caliber listed below.			
1		Barrel Assembly	24	15372	Front Sight
2		Bolt Assembly		15719	Front Sight (Low)
4	17012	Bolt Stop	25	20510	Front Sight Ramp
5	24475	Bolt Stop Pin		15625	Front Sight Ramp, BDL Grade
6	15224	Bolt Stop Spring	26	28505	Front Sight Ramp, Screw
7	00953	Bolt Plate	27	15303	Front Sight Hood, BDL Grade
8	00954	Bolt Plate Spacer, BDL Grade	29	15358	Front Sight Screw, BDL Grade
9	75380	Bolt Plate Screw		90967	Grip Cap, BDL Grade (not shown)
10	15297	Center Guard Screw, ADL Grade	25280		Grip Cap Screw
11	17017	Ejector		90958	Grip Cap Spacer, BDL Grade (not shown)
12	17876	Ejector Pin	30	15284	Magazine, ADL Grade
13	17019	Ejector Spring		16430	Magazine, BDL Grade (not shown)
14	91815	Extractor	31	90957	Magazine Follower (ADL Grade)
	15378	Extractor, Ejector Strap		16040	Magazine Tab Screw (ADL Grade)
15	22020	Firing Pin	32	17078	Magazine Spring
16	22040	Firing Pin Assembly		15677	Magazine Spring, BDL Grade
17	17022	Firing Pin Cross Pin	33	17023	Main Spring
18	16291	Floor Plate Latch, BDL Grade	34	26258	Rear Guard Screw
19	16451	Floor Plate Latch Pin, BDL Grade	35	32510	Rear Sight Aperture
20	16452	Floor Plate Latch Spring, BDL Grade	36	32500	Rear Sight Base
21	16453	Floor Plate Pivot Pin, BDL Grade	37	28505	Rear Sight Base Screw (2)
22	22035	Front Guard Screw	38	90906	Rear Sight Slide
23	15161	Front Guard Screw Bushing, ADL Grade	39	90900	Elevation Screw
			40	15258	Rear Sight Screw, BDL Grade
			41	17034	Receiver Plug Screw

	View No.	Part No.	NAME	View No.	Part No.	NAME	View No.	Part No.	NAME	View No.	Part No.	NAME
	43	24478	Sling Strap Assembly, BDL Grade		22037	Front Guard Spring, 222 Rem., 223 Rem., 243 & 308 Win., 6mm Rem., 22-250 Rem., 17 Rem.		17801	Magazine Spring, 243 & 308 Win., 6mm Rem.			MODEL 700 VARMINT See 30-06 list for parts not listed below
	43	26590	Sling Strap Assembly, BDL Grade					15608	Magazine Spring, 22-250 Rem.			Barrel Assembly
	44	33360	Stock Assembly, ADL Grade		14650	Front Sight, 7mm Rem. Mag., 264 Win.		15609	Magazine Spring, 22-250 Rem., 6mm Rem., 243 Win., BDL Grade		16204	Front Scope Base
		33371	Stock Assembly, BDL Grade		20611	Front Sight Ramp, ADL Grade					18843	Rear Scope Base
		18186	Stock Reinforcing Screw (not shown)		15992	Front Sight Ramp, BDL Grade		17058	Main Spring, 222 Rem., 223 Rem., 243 308 Win., 17 Rem.		16706	Scope Base Screw, Front
		16970	Stock Reinforcing Screw, Dowel Inl should be		15782	Magazine, ADL Grade, 222 Rem.		90040	Recoil Pad, 7mm Rem. Mag., 264 & 300 Win. Mag., 6mm Rem. Mag.		18842	Scope Base Screw, Rear
	45	26556	Swivel Assembly, BDL Grade (O.S.)		16716	Magazine, BDL Grade, 222 Rem., 223 17 Rem.					33376	Stock Assembly, 222 Rem., 223 Rem., 243 Win., 6mm Rem., 22-250 Rem., 33376
	46	26349	Trigger Assembly		15782	Magazine, ADL Grade, 243 & 308 Win., 6mm Rem., 22-250 Rem.		26410	Recoil Pad Screw, 7mm Rem. Mag., 264 & 300 Win. Mag., 6mm Rem. Mag.		33376	Stock Assembly, 25-06
	47	16281	Trigger Guard		16716	Magazine, BDL Grade, 243 & 308 Win., 6mm Rem., 22-250 Rem.		33380	Stock Assembly, 7mm Rem. Mag., ADL Grade			MODEL 700 "CLASSIC" See 30-06 list for parts not listed below
	48	26371	Trigger Guard Assembly, BDL Grade		90951	Magazine Follower, 222 Rem.		33305	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., ADL Grade			Barrel Assembly
	49	90904	Windage Screw		90952	Magazine Follower, 243 & 308 Win., 6mm Rem., 22-250 Rem.		33305	Stock Assembly, 7mm Rem. Mag., 264 300 Win. Mag., BDL Grade, 6mm Rem. Mag.		91644	Recoil Pad, 22-250 Rem., 243 Win., 6mm Rem., 270 Win., 30-06
			ADDITIONAL CALIBERS See 30-06 list for parts not listed below		90951	Magazine Follower, 223, 17 Rem.		33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., BDL Grade, 17 Rem.		91566	Recoil Pad, 7mm Rem. Mag.
			Barrel Assembly		91017	Magazine Follower, 270, 25-06, 30-06 (BDL Grade)		33370	Stock Assembly, 222 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., BDL Grade, 17 Rem.		26410	Recoil Pad Screw
	91637		Extractor, 7mm Rem. Mag., 264-300 Win. Mag., 6mm Rem. Mag.		90952	Magazine Follower, 6mm Rem. Mag.		26370	Trigger Guard Assembly, BDL Grade, 222 Rem., 17 Rem., 223 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem.		3-591	Stock Assembly, 270 Win., 30-06
	90906		Extractor, 222-223 Rem., 17 Rem.		16286	Magazine Spacer, 222 Rem., BDL Grade					34590	Stock Assembly, 22-250 Rem., 6mm Rem., 243 Win., . . . . .
	22021		Firing Pin, 222 Rem., 243-308 Win., 6mm Rem. Mag., 22-250 Rem., 223 Rem., 17 Rem.		16742	Magazine Spacer, 222 Rem., ADL Grade					34592	Stock Assembly, 7mm Rem. Mag.
			Firing Pin Assembly, 222 Rem., 17 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 223 Rem.		16706	Magazine Spacer, 223 Rem., BDL Grade, 17 Rem.						
	22041		Firing Pin Assembly, 222 Rem., 17 Rem., 243 Win., 308 Win., 6mm Rem., 22-250 Rem., 223 Rem.		91133	Magazine Spring, 222 Rem., 223 Rem., 17 Rem.						

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# INSTRUCTION MANUAL

for

# RUGER®

## M-77®

# BOLT ACTION RIFLE



A COPY OF THE INSTRUCTION MANUAL FOR EACH MODEL RUGER FIREARM  
IS AVAILABLE FROM THE FACTORY ON REQUEST.  
THESE INSTRUCTION MANUALS CONTAIN IMPORTANT WARNINGS  
WHICH SHOULD BE UNDERSTOOD BEFORE USING THESE FIREARMS.

**STURM, RUGER & Company, Inc.**  
**SOUTHPORT, CONNECTICUT 06490**  
**U.S.A.**

*RUGER FIREARMS ARE DESIGNED AND MANUFACTURED  
IN RUGER FACTORIES IN THE UNITED STATES OF AMERICA.*

D5/42/11-77

## GENERAL

All Ruger firearms are designed by our own engineers and are manufactured entirely in our own factories located in the United States. We do not purchase actions or market the products of other manufacturers and, as a result, our firearms offer exclusive advantages to the modern sportsman.

Particular attention is paid at all phases of design and manufacture to insure safety, reliability and metallurgical integrity.

The long spring type of extractor has never been surpassed for reliability in a bolt action rifle and reduces to a minimum the necessary protrusion of the cartridge from the end of the breech.

Magazine capacity is 5 rounds (3 rounds with magnum cartridges.)

The RUGER M77 is fitted with a thoroughly seasoned, hand-checked stock of genuine American Walnut which is mounted to the barrel-receiver assembly by means of the new (Patented) RUGER diagonal front-mounting-screw System.

The safety is of sliding shotgun type located on the tang. The trigger is adjustable for weight of pull.

## WARNING

Never aim at anything which you do not wish to shoot. Always keep the muzzle pointing in a safe direction. Be sure of your backstop or direction of fire before shooting.

## LOADING AND UNLOADING

- A. Loading the magazine —  
Open the breech by lifting the bolt handle and pulling the bolt rearwardly until it stops against the bolt stop. Load cartridges directly into the magazine.
- B. Loading the chamber —  
After loading the magazine, push the bolt handle forward, stripping a cartridge from the magazine and pushing the cartridge ahead of the bolt into the chamber. Close and lock the bolt.  
To single-load, place a cartridge directly into the chamber, close and lock the bolt. If there are cartridges in the magazine, depress the top cartridge until the bolt face is well ahead of the rims of the cartridges in the magazine.
- C. Unloading the chamber and magazine —  
Unlock the bolt and pull to the rear, to eject chambered cartridge. Leave bolt open. Push forward the small latch in the front of the trigger guard to open the hinged floorplate and release the cartridges in the magazine. Hold the other hand under the floorplate so as to retard the opening of the spring loaded floorplate and catch the cartridges.

**AMMUNITION:** This firearm has been proof-tested with special test ammunition which conforms to American Industry Specifications. It is intended for use only with standard ammunition of the proper caliber which conforms to Industry Specifications. We specifically disclaim responsibility for any damage or injury whatsoever occurring in connection with the use in this firearm of faulty or non-standard or hand-loaded ammunition.

## WARNING

Be certain that you have the correct caliber ammunition for your rifle, and that the chamber and bore are clear of any obstruction including grease or excessive oil.

In using this, or any other center-fire rifle, it is important that the primer of every cartridge be seated flush with, or below, the surface of the shell base. There is a remote danger that a protruding primer could be discharged prematurely by the closing of the breech mechanism.

### OPERATION OF SAFETY\*

The safety may be engaged only when the bolt is fully locked. Engagement of the safety holds the bolt securely locked.

The cocking piece protrudes noticeably from the rear of the bolt when cocked and serves as a cocking indicator which can be felt as well as seen.

To be properly cautious, the safety should always be engaged except when prepared to fire at the target. *Never depend on the safety or any mechanical device to justify careless handling. Always keep the muzzle pointed in a safe direction.*

### WARNING

- \* When engaging the Safety (by sliding it to the rear), be sure that it is moved all the way to its extreme rearward position. There is an extra resistance to the Safety movement about half-way back and this should not be confused with the true Safety position. The letter "S" should be clearly visible.

### TRIGGER ADJUSTMENT

The trigger adjustment screw (engagement) is preset at the factory to provide a recommended minimum sear engagement. The safety is fitted after this adjustment is made. Accordingly, the trigger adjustment screw (engagement) should not be moved by the owner as it is intended to be a factory adjustment only.

The minimum weight of pull is established by the trigger return spring (Part #D49) and this spring should not be modified. The weight of pull can be increased, beyond this minimum, if desired, by tightening adjustment screw (pull) (Part #D43 — see Fig. 1-B).

The trigger over-travel adjustment has been set to a minimum at the factory and further adjustment should not be made.

### TELESCOPE MOUNTING RING ASSEMBLY

Each Ruger telescope ring is a mated assembly of a top and a base. Do not mix the parts of the two ring assemblies as they are not interchangeable.

On the underside of each mounting ring assembly there is an integral lug, located off center with respect to the front and back sides of the mount. The lug is nearer to the front surface. By reference to the lug, the mounting ring can be correctly assembled with the front of the ring toward the muzzle of the rifle.

Disassemble one ring and reassemble over the scope body between the turret and the eyepiece. (Note: High ring goes on rear mount. Low ring on front mount.)

Install the four top screws. Do not tighten.

Disassemble the other ring and install it on the forward section of the scope tube with the lug forwardly also. Install the four top screws. Again, do not tighten.

Assemble the rings to the receiver with the lugs engaging the recesses in the top surface of the receiver. Tighten the clamp nuts so that the rings are locked to the semi-circular cuts on the sides of the receiver. Rotate the scope until crosshairs are aligned properly, and slide scope to desired eye relief.

Then tighten the eight top screws each a bit at a time to grip the scope body. Sight in according to the directions with your scope.

## DISASSEMBLY

1. Check to ensure that chamber and magazine are clear of ammunition.
2. To remove bolt: Open bolt and pull to the rear while at the same time pivoting open the bolt stop (located on the left side of the receiver). Remove bolt from gun.
3. To remove firing pin assembly from bolt: With bolt closed in the receiver and firing pin cocked, insert a small pin (or suitable nail) into the hole (see Fig. 1-A) which is visible on the bottom of the cocking piece. Remove bolt from the action.

Unscrew firing pin assembly and remove from bolt. (Caution: Do not remove the restraining pin until firing pin assembly is reassembled into bolt and bolt closed in the action.) Further disassembly of the firing pin assembly is not recommended."

4. To remove stock: Open floor plate. Remove the three screws. Remove trigger guard and floorplate hinge assembly. Remove magazine box. Lift barrel/action assembly from stock.
5. In the event that further disassembly is required, do not disturb the trigger adjustment screw (engagement) (Part #D22) or the trigger adjustment screws (over travel) (Parts #D45 and #D44).

## \* WARNING

The firing pin assembly is intended to be a permanent assembly and is not designed to be disassembled. The parts are under great spring pressure and if disassembled could fly apart with sufficient force to cause injury. In any event, special tools are required to correctly reassemble this part.

## REASSEMBLY

1. To replace bolt: Place safety in its off position. With bolt handle in an upward position and bolt head away from you, align the extractor with the

right hand locking lug. Align the locking lugs with the channels in each side of the rear of the receiver and partially insert. Pivot open the bolt stop. Push bolt fully forward. Release bolt stop.

2. To reassemble firing pin assembly into bolt: Screw firing pin assembly fully into bolt. Replace bolt in action, taking care to align the flat on the bottom of the cocking piece with the cocking piece channel in the tang. Close bolt. Remove restraining pin.
3. To replace stock: Place barrel/action assembly back into stock. Replace magazine box. Replace trigger guard and loosely install screws. Install floorplate hinge assembly and firmly tighten screw (this screw is angled and draws the action and barrel back into the bedding surfaces of the stock). Tighten the two trigger guard screws, snugly.

## CARE AND CLEANING

The mechanism should be lubricated with light machine oil or gun oil. Do not oil too heavily. As a rust prevention measure, all surfaces, including the bore of the barrel, should be wiped with oil after use. Do not flood the bore with oil.

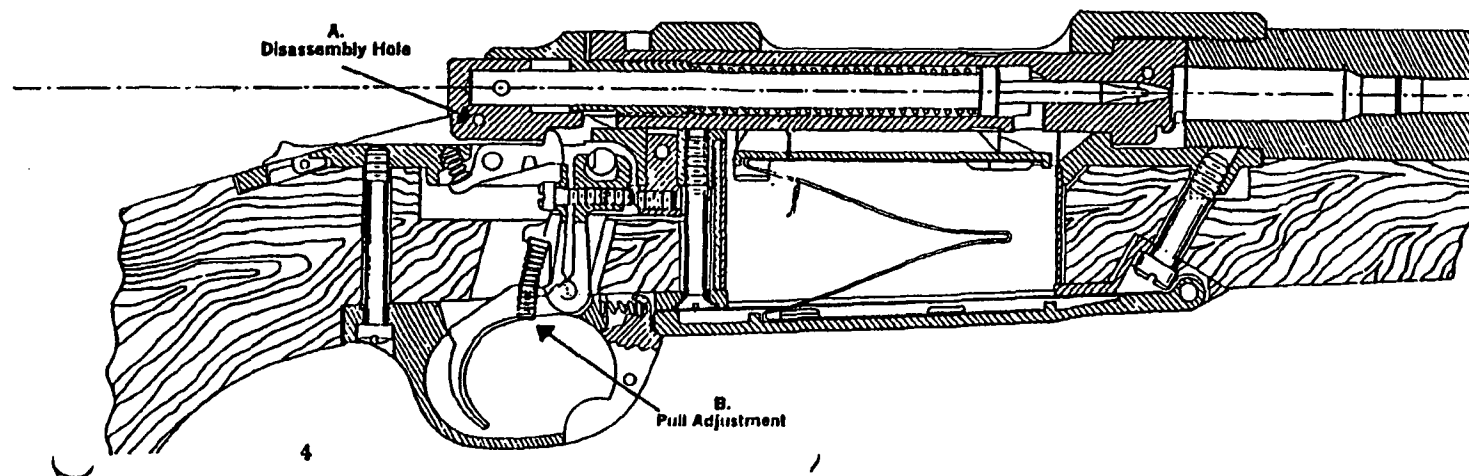
A comprehensive field-cleaning is not required more than once a season or unless obviously necessary. The purpose of such cleaning is only to remove powder residue from internal components or as a rust prevention procedure in the event that the gun has been soaked or submerged in water.

## SERVICE POLICY

Before shipment every Ruger firearm is carefully inspected and test-fired in order to prove that it is in perfect condition and conforms fully to our specifications and standards. If there is any question with regard to the performance of the rifle, please write to our Service Department, fully describing all circumstances and conditions involved.

If you should return your rifle for repair or order parts, please comply with the following suggestions for prompt service:

(Cont'd — Page 6)



# SERVICE POLICY (Cont'd)

## PARTS:

1. All parts orders should be sent to:  
Sturm, Ruger & Co., Inc., Product Service Dept., Newport, New Hampshire 03773
2. Please send remittance with order for parts. Because of handling costs, we cannot accept orders for parts for less than \$1.00.
3. Order parts by both name and number.

## FIREARMS:

1. Ruger Model 77 Rifles returned for service should be sent to:  
Sturm, Ruger & Co., Inc., Product Service Dept., Newport, New Hampshire 03773.
2. Rifles shipped to factory should be sent prepaid. We will not accept collect shipments.
3. For best repair service, always enclose letter furnishing serial number and Model of rifle. Also, state nature of trouble experienced or of work desired. (Merely stating "defective" or "repair" is inadequate information.) Please enclose copies of any previous correspondence.
4. Work performed will bear a net minimum labor charge of \$5.00. The charge for re-bluing is \$15.00, which includes labor.
5. Federal regulations must be complied with when shipping any firearm. In certain states and under certain regulations, it may be impossible for us to return a repaired firearm to an individual. It is therefore most strongly recommended that all firearms sent to us for repair, be sent through a federally licensed dealer!

## WARNING

Check chamber before shipping firearm. If firearms are sent to us in a loaded condition, we must notify Federal authorities.

Please do NOT send to our factory your scope or rifle case with the firearm being sent to us for repair.

## RETAIL PARTS LIST

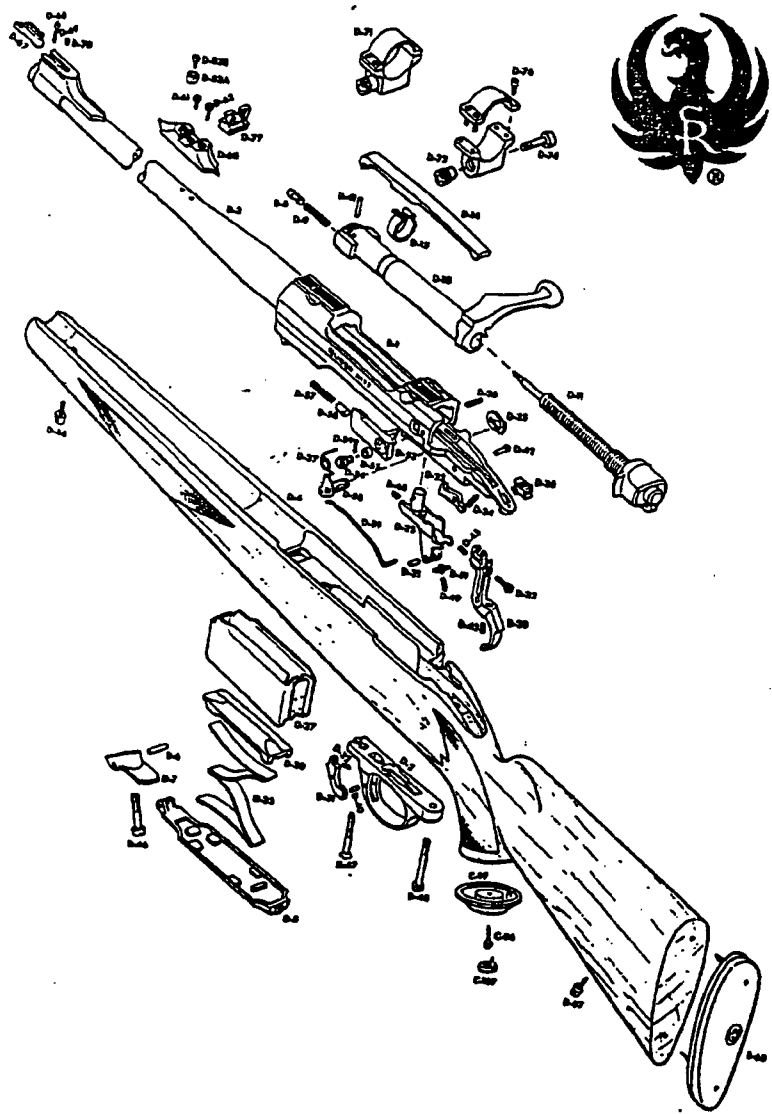
Part No.	Description	Price
D-3	*Barrel (only) (specify caliber)	\$45.00
***D-66	Barrel Band	5.75
***D-86B	Barrel Band Screw (not illus.)	.50
D-10	*Bolt (only)	25.00
D-35	Bolt Lock	1.25
D-53	Bolt Stop	6.00
D-56	Bolt Stop Plunger	.50
D-57	Bolt Stop Plunger Spring	.25
D-59	Bolt Stop Plunger Spring Retaining Pin	.25
D-54	Bolt Stop Screw Stud	.50
D-55	Bolt Stop Stud Bushing	.25
D-8	Ejector	1.00
D-41	Ejector Retaining Pin	.25
D-9	Ejector Spring	.25
**D-14	Extractor	7.00
**D-15	Extractor Band	2.00
*D-11	Firing Pin (assembly only)	10.00
**D-5	Floor Plate	4.00
D-7	Floor Plate Hinge	3.00
D-6	Floor Plate Pivot Pin	.25
***B-51	Forend Escutcheon (2 req'd) (not illus.)	.25 (each)
**D-27	Magazine Box	3.00
D-127	Magazine Box Assy. (.220 Swift only)	5.00

**D-30	Magazine Follower (stainless steel)	6.00
D-31	Magazine Latch	2.00
D-40	Magazine Latch Pin	.25
D-32	Magazine Latch Spring	.25
**D-33	Magazine Spring	2.00
C-97	Pistol Grip Cap	1.50
C-107	Pistol Grip Cap Medallion	.50
C-96	Pistol Grip Cap Screw	.25
D-1	Receiver	not offered
D-46	Receiver, Mounting Screw (front)	1.00
D-47	Receiver, Mounting Screw (center)	.50
D-48	Receiver, Mounting Screw (rear)	.25
S-63	Recoil Pad	5.00
	Recoil Pad Screws (2)	.50
D-38	Safety Button	3.00
D-39	Safety Link	.50
D-58	Safety Shaft Assembly	3.00
D-37	Safety Spring	.25
D-23	Sear	4.00
D-42	Sear Pivot Pin	.50
D-24	Sear Spring	.25
D-71	Scope Ring Assembly (STD.)	15.00 (pair)
D-71H	Scope Ring Assembly (high)	15.00 (pair)
D-74	Scope Ring Clamp	2.00 (each)
D-73	Scope Ring Nut	1.00 (each)
D-76	Scope Ring Screw	.25 (each)
D-68	Sight (front)-Plunger	.25
D-69	Sight (front)-Plunger Spring	.25
**D-65	Sight Base (front)	8.00
D-70	Sight Base (front)-Set Screw	.25
D-67	Sight Blade (front)	2.00
D-77	Sight (rear) Folding, Complete	3.00
**D-60	Sight (rear) Base Only	5.00
D-61	Sight Base (rear)-Center Screw	.50
D-62	Sight Base (rear)-Rear Screw	.50
D-83A	Williams Crib Lock (sight clamp rear)	.50
D-83B	Screw For Part #D-83A	.25
D-86	Sling Swivel Front Screw With Nut	.50
D-87	Sling Swivel Rear Mounting Stud	.50
**D-4	Stock (complete with pad & checkered)	50.00
***D-106	Stock Cross Bolt (not illus.)	1.00
***D-107	Stock Cross Bolt Nut (not illus.)	.35
***D-104	Stock Reinforcement Assy. (not illus.)	6.00
***D-75	Stock Reinforcement Screw (not illus.)	.35
D-2	Trigger Guard	8.00
D-20	Trigger	5.00
D-22	Trigger Adjustment Screw (engagement)	1.00
D-43	Trigger Adjustment Screw (weight of pull)	.25
D-45	Trigger Adjustment Screw (over travel)	.25
D-44	Trigger Adjustment Set Screw (over travel)	.25
D-25	*Trigger Housing	4.00
D-26	Trigger Housing Cross Pin	.25
D-21	Trigger Pivot Pin	.25
D-49	Trigger Return Spring	.25
D-51	Trigger Return Spring Seat	.50

\*Must be fitted at the factory

\*\*Order by Part No. and Caliber

\*\*\*Required for .458 Caliber rifles only



**BARBER - PRESALE R 0110003**



# Model 1500

## CENTERFIRE BOLT ACTION RIFLE

### OPERATION AND MAINTENANCE MANUAL



The Smith & Wesson Model 1500 centerfire, bolt action rifle has been designed and manufactured to provide many years of outstanding performance. This manual has been prepared so that any owner of a S & W Model 1500 will be able to have a better understanding of the proper care and routine maintenance of his new Smith & Wesson and as a result, enjoy the total satisfaction of his purchase. If there are any questions concerning material in this Manual, please contact the source from whom the S & W Model 1500 was purchased or any qualified gunsmith.

#### TO REMOVE THE BOLT FROM THE RIFLE

1. Check to make sure the rifle is unloaded.
2. With the bolt part way to the rear, depress the bolt catch located at the left rear of the receiver and draw the bolt rearward out of the receiver.

**NOTE:** The bolt may be inserted into the receiver or removed with the safety in either the "safe" or "fire" position.

#### TO ASSEMBLE THE BOLT TO THE RIFLE

1. Align the locking lugs on the bolt with their corresponding ways in the receiver.
2. Push the bolt forward gently into the receiver until the bolt catch snaps back into place behind the left hand locking lug.

#### TO OPERATE THE SAFETY

The safety on your Model 1500 Rifle is a two position safety located at the right rear of the receiver.

1. To put the safety in the "safe" position, move the thumbpiece fully rearward.
2. To put the safety in the "fire" position, move the thumbpiece fully forward.

**NOTE:** The bolt may be operated with the safety in either position — the "safe" or "fire".

**NOTE:** THE SAFETY OF YOUR MODEL 1500 RIFLE WORKS DIRECTLY ON THE TRIGGER ASSEMBLY OF THE RIFLE. FOR THIS REASON, THE TRIGGER MECHANISM ADJUSTMENTS OF THE RIFLE HAVE BEEN SEALED AT THE FACTORY. ANY ATTEMPT TO REDUCE THE ENGAGEMENT OF THE TRIGGER WITH THE SEAR MAY RENDER THE SAFETY INOPERATIVE, AND THUS CREATE A HAZARDOUS CONDITION.

#### TO LOAD THE RIFLE

1. Raise the bolt handle and pull the bolt fully rearward.
2. Place the safety in the "safe" position.
3. Press cartridges down into the magazine one at a time until the magazine is full (5 cartridges in

standard calibers, 4 in magnum calibers). The top cartridge will be fed into the chamber when the bolt handle is pushed forward and rotated to the locked (down) position.

4. Pushing the safety thumbpiece forward will now make the rifle ready to fire.

**NOTE:** ALWAYS POINT THE RIFLE IN A SAFE DIRECTION.

**NOTE:** The rear of the firing pin assembly will protrude slightly from the rear of the bolt assembly when the rifle is cocked. This serves as a cocking indicator and as a warning that if the safety is in the "fire" position, the firing pin will fall if the trigger is pulled.

#### TO REMOVE THE CARTRIDGES WITHOUT FIRING

1. Push the safety thumbpiece to the "safe" (rearward) position.
2. Open the bolt and remove the cartridge from the chamber.
3. Push in the floorplate catch located in the front of the trigger guard and allow the floorplate to swing open. The cartridges in the magazine may now be removed.

**NOTE:** Cartridges may be removed by cycling them from the magazine to the chamber and out. If this is done, be sure the safety is first put in the "safe" position. Since the bolt handle must be rotated down to the locked position, this method is not recommended.

#### SCOPE MOUNTING

Screw holes are provided in the top of the receiver to allow mounting of a scope sight using various scope mounts.

#### RECEIVER SIGHT MOUNTING

Screw holes are provided for mounting a receiver (peep) sight at the rear of the receiver. Minor alteration of the stock may be necessary to do this.

#### CARE AND CLEANING

Your Model 1500 rifle should be lubricated lightly with a good non-gumming light machine or gun oil. Excessive lubrication should be avoided, since excess lubricant can collect dirt and dust and oil can penetrate the wood of the stock, eventually weakening it. All metal parts should be coated inside and out very lightly with a good light oil or silicone preparation as a rust prevention measure.

With modern smokeless, non-corrosive ammunition, frequent cleaning of the bore should only be neces-

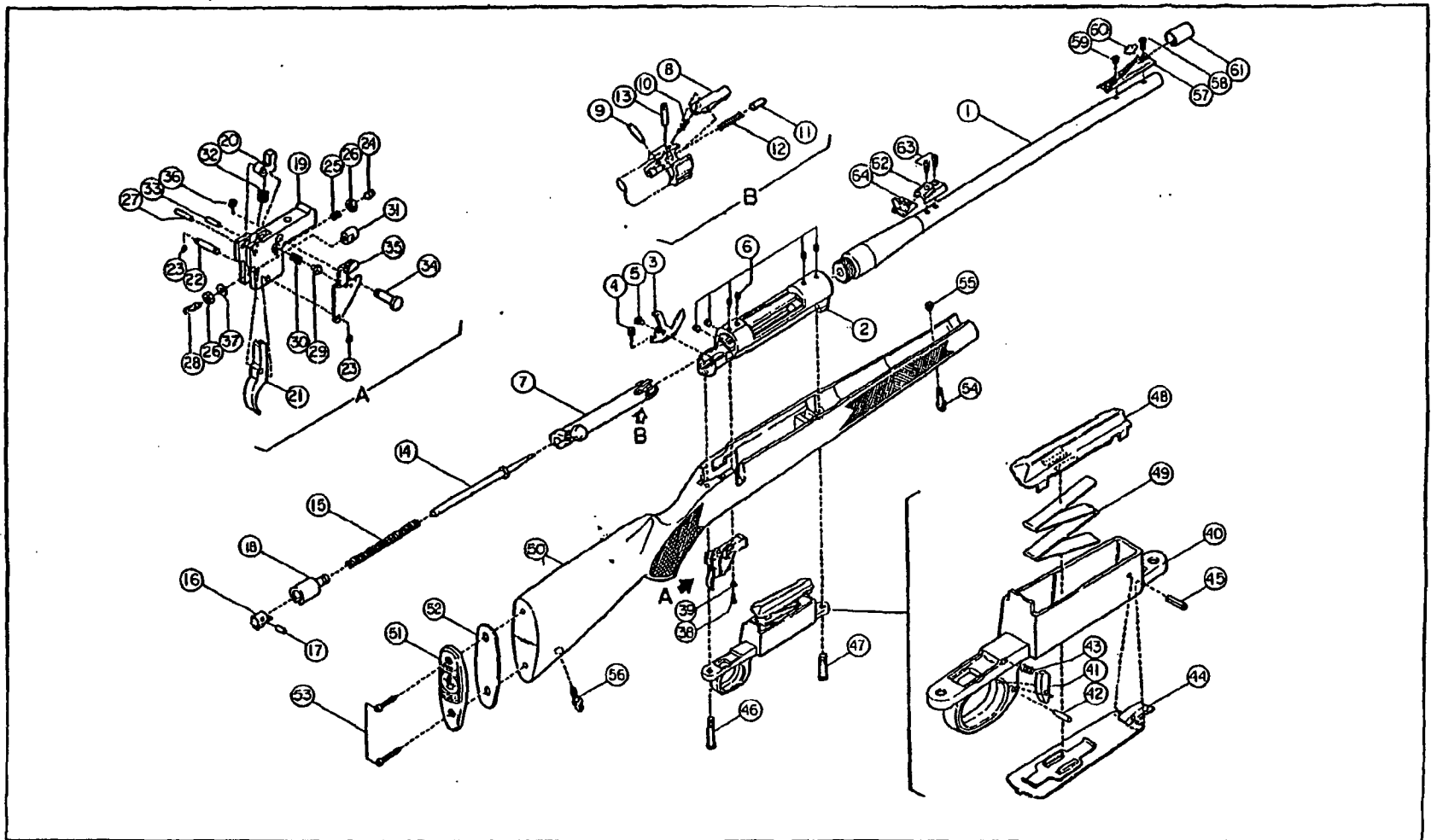
For inquiries,  
send to:  
Smith & Wesson  
2100 Roosevelt Ave.  
Springfield, Ma. 01101



Smith & Wesson

# MODEL 1500 STANDARD EXPLODED VIEW

For service or parts,  
send to:  
Smith & Wesson  
2095 Roosevelt Ave.  
Springfield, Ma. 01101  
Attn. Service Dept.



BARBER - PRESALE R 0110005

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R2510993

sary, but should only be done when an objectionable buildup of fouling occurs or preparatory to storing the rifle for a long period. When cleaning the bore, it is good practice to insert the cleaning rod from the rear to avoid possible wear of the rifling at the muzzle.

#### INSTRUCTIONS FOR ORDERING PARTS

When ordering parts, please give the following information:

1. Model number of the firearm.
2. Serial number of the firearm.
3. Caliber and grade of the firearm.
4. Part name and number of the part required.

Please order parts separately from factory repair service or delivery may be delayed.

Send your order to:

Smith & Wesson  
2100 Roosevelt Ave.  
Springfield, MA 01101  
Attn: Parts Department

#### INSTRUCTIONS FOR FACTORY SERVICE

Should your Smith & Wesson long gun require adjustment, repair, or refinishing, we recommend most sincerely that the weapon be returned to the factory. There is no other way to insure that the work will be done in a properly equipped and staffed shop.

Charges are very reasonable, being based on the cost of parts replaced plus a labor charge for the time expended on the job. A labor charge for one hour is usually sufficient to cover all but very extensive overhaul jobs.

Long guns returned to the factory should be **MARKED FOR THE ATTENTION OF THE SERVICE DEPARTMENT**. A letter of instructions should be enclosed with the gun, and shipment by individuals must be Prepaid. Adherence to these suggestions will prevent loss of time in handling at the factory.

When your Long gun arrives for service, it will be very carefully inspected, together with your letter of instructions. Next, a quotation covering total cost of work to be performed will be sent to you. No actual work will be performed before receiving your approval of our quotation unless you specifically authorize us to do so.

### THE SMITH & WESSON SPORTING GOODS GROUP PRODUCTS

- SMITH & WESSON AMMUNITION
- LEATHER GOODS
- HAND GUNS
- KNIVES
- PUMP SHOTGUNS
- AUTOMATIC SHOTGUNS
- CENTERFIRE RIFLES
- AIR GUNS



**Smith & Wesson**

SMITH & WESSON COMPANY

Springfield, Ma. 01101

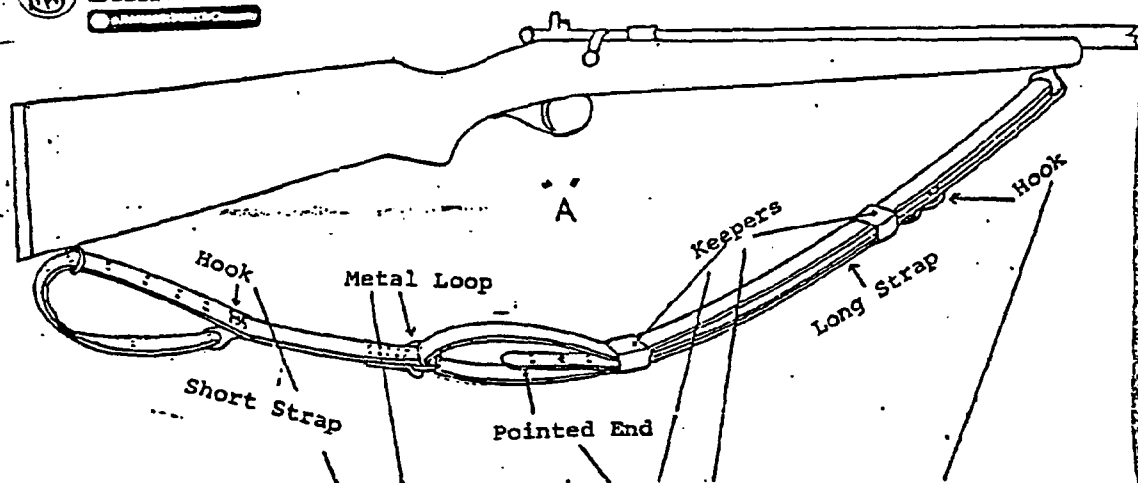
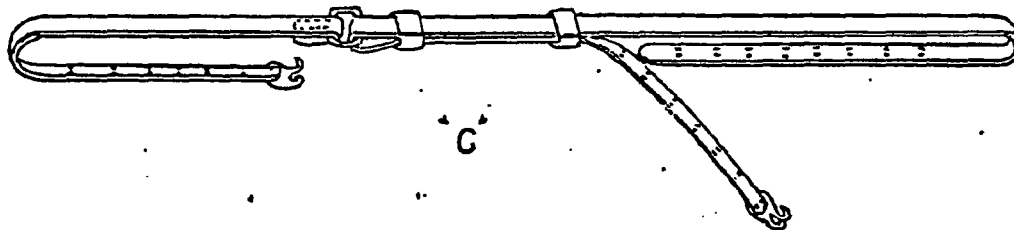
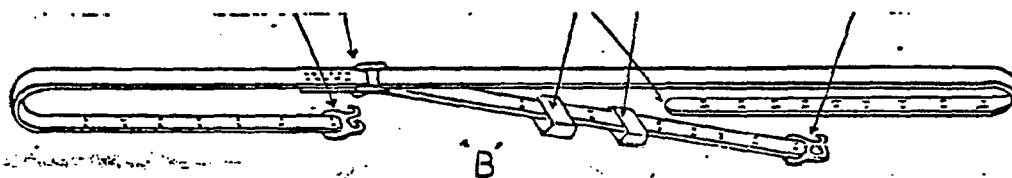


Diagram A shows adjustment and assembly for target shooting.



- 1) Slide the pointed end of the long strap through both keepers, then adjust keepers to approximate position of Diagram "C".
- 2) Slide short strap through the metal loop on the butt end of your rifle. Slide the long strap point through the muzzle end metal loop.
- 3) Slide the pointed end of the long strap through both keepers holding the pointed section between the upper and lower thirds of the long strap.
- 4) Insert long strap adjustment hook into one set of adjustment holes. Next slide keepers to approximate position of Diagram "A".
- 5) Insert hook on short strap into short strap adjustment holes. Sling is now located and assembled to resemble Diagram "A" with hooks adjusted to fit the individual shooter.
- 6) Short strap hook can be inserted in long strap adjustment holes to form a carrying strap.

# PARTS LIST FOR MODEL 1500 STANDARD AND DELUXE

Subject to change without notice F.O.B. Springfield, Ma.  
When ordering part, please include Model No., Serial No., Part No. and Description.

View No.	Part No. Standard	Part No. Deluxe	Description	View No.	Part No. Standard	Part No. Deluxe	Description
	13002	13114	Barrel/Receiver Assembly: (View Nos. 1-6) 243 Win.	29	13034	13034	Safety Plunger (All Calibers)
	13125	13075	Barrel/Receiver Assembly 30-06	30	13035	13035	Safety Plunger Spring (All Calibers)
	13127	13103	Barrel/Receiver Assembly 270 Win.	31	13036	13036	Block (All Calibers)
	13074	13076	Barrel/Receiver Assembly 7mm Mag.	32	13037	13037	Sear Spring (All Calibers)
1	13003	13115	Barrel 243 Win.	33	13038	13038	Sear Stop Pin (All Calibers)
1	13126	13084	Barrel 30-06	34	13039	13039	Safety Guide Pin (All Calibers)
1	13128	13104	Barrel 270 Win.	35	13040	13040	Safety (All Calibers)
1	13130	13106	Barrel 7mm Mag.	36	13041	13091	Retaining Ring, Safety Guide Pin (All Calibers)
	13004	13116	Receiver Assembly (Views Nos. 2-6). 243 Win.	37	13042	13092	Washer (All Calibers)
	13131	13085	Receiver Assembly 30-06	38	13043	13093	Trigger Housing Screw (All Calibers)
	13131	13085	Receiver Assembly 270 Win.	39	13044	13094	Star Washer (All Calibers)
	13131	13085	Receiver Assembly 7mm Mag.		13045	13095	Trigger Guard Assembly (Includes Views No. 40-49) 30-06, 270 Win., 7mm Mag.
2	13132	13086	Receiver 30-06, 270 Win., 7mm Mag.		13140	13123	Trigger Guard Assembly 243 Win.
2	13005	13117	Receiver 243 Win.	40	13046	13096	Trigger Guard—30-06, 270 Win., 7mm Mag.
2	13006	13006	Bolt Stop		13141	13124	Trigger Guard Assembly 243 Win.
4	13007	13007	Bolt Stop Spring	41	13047	13047	Floor Plate Catch (All Calibers)
5	13008	13008	Bolt Stop Screw	42	13048	13048	Floor Plate Catch Pin (All Calibers)
6	13009	13009	Receiver Plug Screw (Long)	43	13049	13049	Floor Plate Catch Spring (All Calibers)
	13080	13080	Receiver Plug Screw (Short)	44	13050	13097	Floor Plate 30-06, 270 Win., 7mm Mag.
	13136	13087	Bolt Assembly (Includes views No. 7 thru 13) 30-06, 270 Win.	45	13142	13110	Floor Plate 243 Win.
	13010	13118	Bolt Assembly 243 Win.	46	13051	13051	Floor Plate Pin (All Calibers)
	13137	13107	Bolt Assembly 7mm Mag.	47	13052	13052	Rear Guard Screw (All Calibers)
7	13138	13088	Bolt Body 30-06 and 270 Win.	48	13053	13053	Front Guard Screw (All Calibers)
	13011	13119	Bolt Body 243 Win.		13054	13098	Magazine Follower—30-06, 270 Win., 7mm Mag.
	13139	13108	Bolt Body 7mm Mag.		13143	13105	Magazine Follower 243 Win.
8	13012	13012	Extractor 30-06, 270 Win., 243 Win.	49	13055	13055	Magazine Spring (All Calibers)
9	13109	13109	Extractor 7mm Mag.		13134	13078	Stock Assembly (Includes Views No. 50 thru 56) 30-06, 270 Win.
10	13013	13013	Extractor Pin (All Calibers)		13077	13079	Stock Assembly—7mm Mag.
11	13014	13014	Extractor Spring (All Calibers)		13056	13099	Stock Assembly—243 Win.
12	13015	13015	Ejector (All Calibers)	50	13135	13100	Stock 30-06, 270 Win.
13	13016	13016	Ejector Spring (All Calibers)	50	13133	13111	Stock 7mm Mag.
	13129	13129	Ejector Pin (All Calibers)	50	13057	13083	Stock—243 Win.
	13017	13017	Firing Pin Assembly (Includes views No. 14 thru 18) 30-06, 270 Win., 7mm Mag.	51	13058	13058	Butt Plate—243 Win.
	13120	13120	Firing Pin Assembly 243 Win.	51	13101	13101	Butt Plate—30-06, 270 Win.
14	13121	13121	Firing Pin 243 Win.	52	13059	13059	Butt Plate White Spacer—243 Win.
14	13018	13018	Firing Pin—30-06, 270 Win., 7mm Mag.	52	13102	13102	Butt Plate White Spacer 30-06, 270 Win.
15	13019	13019	Main Spring—30-06, 270 Win., 7mm Mag.	53	13060	13060	Butt Plate Screw
15	13122	13122	Main Spring 243 Win.	54	13061	13061	Front Swivel Screw
16	13020	13020	Cocking Piece (All Calibers)	55	13062	13062	Front Swivel Nut
17	13021	13021	Firing Pin Retaining Pin (All Calibers)	56	13063	13063	Rear Swivel Screw
18	13002	13002	Bolt Sleeve (All Calibers)		13064	N.A.	Front Sight Assembly (Includes Views Number 57 thru 61)
	13023	13023	Trigger Housing Assembly (Includes Views No. 19 thru 39) All Calibers	57	13065	N.A.	Front Sight Ramp
19	13024	13024	Trigger Housing (All Calibers)	58	13066	N.A.	Front Sight Screw (L)
20	13025	13025	Sear (All Calibers)	59	13067	N.A.	Front Sight Screw (S)
21	13026	13026	Trigger (All Calibers)	60	13068	N.A.	Front Sight
22	13027	13027	Trigger Pin (All Calibers)	61	13069	N.A.	Front Sight Hood
23	13028	13028	Retaining Ring, Trigger Pin (All Calibers)		13070	N.A.	Rear Sight Assembly (Standard grade only) Views Numbers 62-64
24	13029	13029	Trigger Adjusting screw, Front (All Calibers)	62	13071	N.A.	Rear Sight Base
25	13030	13030	Trigger Spring (All Calibers)	63	13072	N.A.	Rear Sight Base Screw
26	13031	13031	Lock Nut (All Calibers)	64	13073	N.A.	Rear Sight
27	13032	13032	Sear Pin (All Calibers)		13112	13112	Recoil Pad 7mm Mag.
28	13033	13033	Trigger Adjusting Screw, Rear (All Calibers)		13113	13113	Spacer 7mm Mag.
					N.A.	13000	O.D. Swivel
					N.A.	13001	Strap

	Order Number	Caliber	Barrel Length	Length Overall	Magazine Capacity	Approx. Weight
Deluxe	16004	243 Win.	22"	42"	5	7 lbs. 8 oz.
	16003	270 Win.	22"	42½"	5	7 lbs. 10 oz.
	16001	30-06	22"	42½"	5	7 lbs. 10 oz.
	16002	7mm Rem. Mag.	24"	44½"	4	7 lbs. 13 oz.
Standard	15004	243 Win.	22"	42"	5	7 lbs. 8 oz.
	15003	270 Win.	22"	42½"	5	7 lbs. 10 oz.
	15001	30-06	22"	42½"	5	7 lbs. 10 oz.
	15002	7mm Rem. Mag.	24"	44½"	4	7 lbs. 13 oz.



Instructions for your

**Model 70 XTR**  
Center Fire Rifle



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

**SAFETY WARNING** **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.

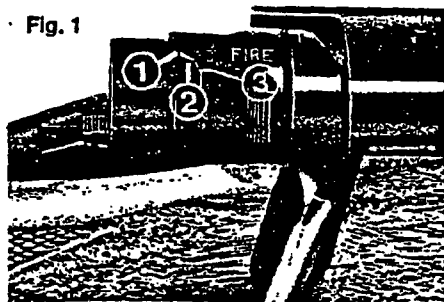
**SAFETY WARNING** **HOW TO OPERATE THE SAFETY** — The safety can only be operated when the firing pin is cocked. To cock the firing pin, lift up on the bolt handle and then return it to the locked position (when the firing pin is cocked, a red indicator is visible at the rear of the bolt).

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



**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.

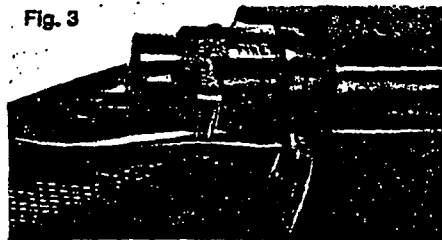
Fit the forward end of the bolt in the rear of the receiver, then slide the bolt fully forward and lower the bolt handle to a locked position. The safety can now be operated. (Fig. 3)

**SAFETY 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



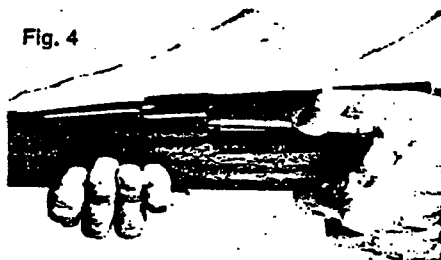
**\*ACTION:** The mechanism of a firearm which loads and secures the cartridge in the chamber.

**SAFETY WARNING** **HOW TO LOAD** — Use the correct ammunition referenced by the inscription on the barrel. Before loading your gun be sure all grease and oil has been removed from the barrel and chamber, and there is no obstruction.

**SAFETY WARNING** 1. With the safety in the intermediate position (Fig. 3) lift the bolt handle and pull the bolt back all the way. Lay a cartridge in the receiver just forward of the bolt. Press the cartridge down with your thumb until it snaps into the magazine. (Fig. 4)

2. Press each succeeding cartridge similarly into the magazine. (Fig. 4)

Fig. 4



3. With the magazine loaded to capacity, an additional cartridge may be placed directly into the chamber. Then, press down the top cartridge in the magazine and close the bolt. (Fig. 5)

Fig. 5



## MAGAZINE CAPACITY —

### Model 70 XTR

3 Roundst	4 Roundst
222 Rem.	284 Win. Mag.
22-250 Rem.	7mm Rem. Mag.
25-06 Rem.	300 Win. Mag.
270 Win.	338 Win. Mag.
308 Win.	375 H & H Mag.
243 Win.	485 Win. Mag.
30-06 Spr.	

†Includes one cartridge in chamber.

**SAFETY WARNING** **TO OPERATE** — 1. When ready to shoot, and with a loaded cartridge in the chamber, the safety on, and your finger off the trigger, push the safety fully forward. Your rifle is now ready to fire.

**SAFETY WARNING** **REMEMBER**, The recoil from a center fire rifle, especially magnum calibers, will be somewhat heavier than most other guns, so firmly shoulder your gun, take aim and when on target pull the trigger.

2. Pull bolt handle up and fully back, ejecting fired cartridge case.

3. Push bolt forward, positioning a new cartridge from the magazine into the chamber. Lock bolt by turning bolt handle fully down. Your rifle is again cocked and ready to fire, or put the safety in the "on" position until you are ready to fire again.

**SAFETY WARNING** **TO REMOVE CARTRIDGES WITHOUT FIRING** — Pull safety rearward to "intermediate" position. With the rifle pointed in a safe direction and your finger off the trigger, operate the action, extracting and ejecting each loaded round from the chamber.

**SAFETY WARNING** Alternate method for Model 70 XTR.

1. With the safety in the "intermediate" position, open the magazine cover by pressing back the magazine cover catch (Fig. 6) in front of the trigger guard.

2. Allow magazine cover to swing open and remove cartridges. (Fig. 7)

3. Lift bolt handle up and pull bolt fully back to remove cartridge from chamber.



Fig. 6

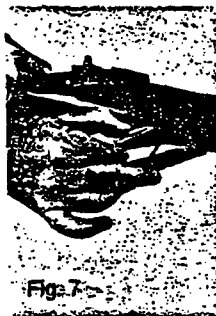


Fig. 7

**SAFETY WARNING** **IMPORTANT** — Always visually check and know for sure that your gun is not loaded, by looking directly into the chamber and magazine with the action open and bolt fully to the rear.

**TO REMOVE THE BOLT** — 1. Cock the firing pin by raising and lowering the bolt handle. Place the safety in the "intermediate" position. Again, raise bolt handle and draw the bolt fully to the rear.

2. Depress the bolt stop located at the left rear of the receiver and remove the bolt.

3. To remove the firing pin assembly from the breech bolt, the firing pin must be cocked and the safety in the "intermediate" position. Then, compress the small breech bolt sleeve lock and turn the rear breech bolt sleeve to the left. Assemble in reverse order.

**CARE AND CLEANING** — Remember rust is neglect. Protect your rifle with good gun care products. A light coat of good gun oil on metal surfaces will prevent rust. To clean the inside of the barrel, remove the bolt and invert the gun to prevent the bore cleaner from running into the action.

**SAFETY WARNING** Visually check the chamber making sure it is not loaded. Use a cleaning rod with a brass brush soaked in nitro solvent, work it through the entire length of the

bore several times. Follow this by dry patch until the bore is thoroughly cleaned. Then with a patch moistened with gun oil apply a light protective film to the bore. Periodically, dirt and fouling should be removed from inside of the receiver and action parts. This should be done with a suitable brush with nitro solvent followed by a thorough wiping and a light oiling. Do not store your gun in a case, a fabric lining will absorb the protective coating of oil and permit rusting.



#### TEN COMMANDMENTS OF FIREARMS SAFETY

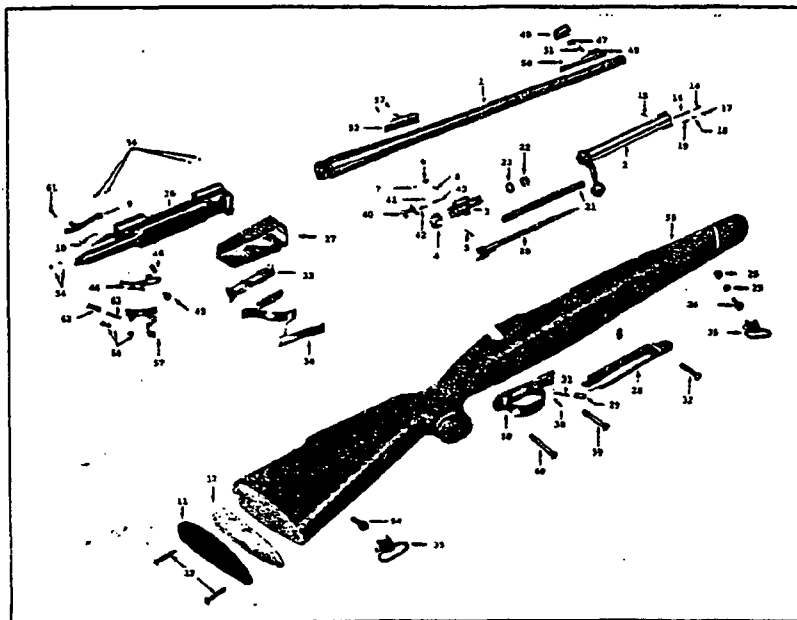
A good hunter is a safe hunter. He knows there is no place for horseplay in hunting. He learns and obeys the commandments of firearms safety and insists that his companions know and follow them, too.

Every hunter — whether novice or experienced outdoorsman — should review these commandments before each hunting season to be sure that his gun handling, both at home and in the field, sets a good example for others.

1. Treat every gun with the respect due a loaded gun.
2. Be sure of your target before you pull the trigger.
3. Always be sure that the barrel and action are clear of obstruction.
4. Never point your gun at anything you do not want to shoot.
5. Never leave your gun unattended unless you unload it first.
6. Avoid alcoholic beverages both before and during shooting.
7. Never carry a loaded gun when you climb a tree, cross a fence or go through areas where you are apt to slip or trip.
8. Never shoot at a hard, flat surface or the surface of water. Make sure you have a safe backstop.
9. Carry only empty guns, taken down or with the action open, into your camp, car or home.
10. Store guns and ammunition separately, beyond the reach of children.



It is recommended that SHOOTING GLASSES be worn at all times, and that EAR PROTECTION be utilized where practical.



WINCHESTER-Wealth  
275 WINCHESTER AVENUE, NEW HAVEN, CONNECTICUT 06510

Printed in U.S.A.

Form No. 7000-11

### MODEL 70 XTR NOMENCLATURE

Parts may be ordered directly from Winchester Product Service Department. Please specify part number, part name and serial number.

Reference Number	Part Description	Reference Number	Part Description	Reference Number	Part Description
**1	Barrel	24	Forearm Screw Eye	45	Sear Pin
**2	Breech Bolt	25	Forearm Screw Eye Washer	46	Sear Spring
13	Breech Bolt Sleeve	26	Forearm Screw Eye Escutcheon	47	Sight — Front
4	Breech Bolt Sleeve Cap	27	Magazine	48	Sight Cover — Front
5	Breech Bolt Sleeve Cap Pin	28	Magazine Cover Complete	49	Sight Ramp — Front
6	Breech Bolt Sleeve Lock	29	Magazine Cover Catch	50	Sight Ramp Screw — Short
7	Breech Bolt Sleeve Lock Pin	30	Magazine Cover Catch Pin	51	Sight Ramp Screw — Long
8	Breech Bolt Sleeve Lock Spring	31	Magazine Cover Catch Spring	52	Sight — Rear
9	Breech Bolt Stop	32	Magazine Cover Hinge Plate Screw	53	Sight Rear Screw (2 Required)
10	Breech Bolt Stop Spring	33	Magazine Follower	54	Stock Swivel Stud
11	Butt Plate	34	Magazine Spring	55	Stock
12	Butt Plate Spacer	35	Quick Detachable Swivel (2 Required)	56	Telescope Sight Base Plug Screw (5 Required)
13	Butt Plate Screws (2 Required)	**36	Receiver	**57	Trigger
14	Ejector	37	Recoil Pad (Not Shown)	58	Trigger Guard
15	Ejector Pin	38	Recoil Pad Spacer (Not Shown)	59	Trigger Guard Screw — Front
16	Ejector Spring	39	Recoil Pad Screws (Not Shown) 2 Required	60	Trigger Guard Screw — Rear
17	Extractor	140	Safety	61	Trigger Pin
18	Extractor Plunger	41	Safety Pin	62	Trigger Spring
19	Extractor Spring	42	Safety Plunger	63	Trigger Stop Screw
**20	Firing Pin	43	Safety Plunger Spring	64	Trigger Stop Screw Nut (3 Required)
21	Firing Pin Spring	**44	Sear		
22	Firing Pin Spring Retainer				
23	Firing Pin Spring Washer				

\* Sold only to gunsmiths who have executed an agreement with us — otherwise for factory installation only.

\*\* Sold for factory installation only — return complete firearm.

† Not sold to consumers. Installation must be made by a gunsmith. Orders from dealers and distributors will be accepted on the understanding that the parts will be fitted by a gunsmith.