

REMINGTON MODEL 700
FIELD SERVICE
GUNSMITH BULLETIN

INSTRUCTIONS FOR REMINGTON RECOMMENDED GUNSMITHS FOR REPLACEMENT OF
MODEL 700 TRIGGER ASSEMBLIES AND SELECTED TRIGGER ASSEMBLY PARTS

WARNING: TRIGGER ASSEMBLY PARTS NOT LISTED ARE NOT INTERCHANGEABLE.
REPLACE COMPLETE TRIGGER ASSEMBLY

BOLT STOP PIN
BOLT STOP
BOLT STOP SPRING

To Disassemble - Remove the bolt assembly, trigger guard or trigger guard assembly, magazine, magazine follower, spring and stock. Put the safety switch in "S" position. Tap out the bolt stop pin from left to right and remove the bolt stop and bolt stop spring.

To Reassemble - Place bolt stop spring into the recess in the bottom left side of the receiver with the long end of the spring facing forward and the bent end facing outward. The short, bent end of the spring sets in the receiver at the back of the trigger assembly. Place the bolt stop in slot with the contoured edge facing into the receiver and hole to the rear. Align the bolt stop, bolt stop spring and the trigger assembly holes with the bolt stop pin hole in the receiver. Insert the chamfered end of the bolt stop pin through bolt stop and bolt stop spring and tap pin into the receiver. Restake the bolt stop pin on the right side of the receiver.

CAUTION: After assembling the bolt stop - push bolt stop release upward, bolt stop must pivot freely. Push the safety switch to "F" position, pull the trigger and hold. Depress top rear of sear safety cam to insure that the cam pivots freely and retracts without hesitation.

Reassemble the magazine, magazine spring, follower, stock assembly, trigger guard and bolt assembly to the action. SEE SAFETY PERFORMANCE CHECK (PAGE 3).

SEAR PIN

To Disassemble - Remove the bolt assembly, trigger guard or trigger guard assembly, stock assembly, magazine, magazine follower, and spring. Put the safety switch in the "S" position. Tap out the bolt stop pin from left to right and remove the bolt stop and bolt stop spring. Tap out the sear pin from left to right.

To Reassemble - Align the sear safety cam and trigger assembly holes and tap in the sear pin from left to right (chamfered end first).

Remington Arms Company, Inc.

NOTE: Sear pin must not protrude into the bolt stop slot.

Reassemble the bolt stop spring, bolt stop and bolt stop pin. Restake both pins on the right side of the receiver.

CAUTION: After reassembling, push bolt stop release upward; bolt stop must pivot freely. Put the safety switch in the "F" position, pull the trigger and hold. Depress top rear of sear safety cam to insure that the safety cam pivots freely and retracts without hesitation.

Reassemble the magazine, magazine follower, spring, stock assembly, trigger guard and the bolt assembly to the action. SEE SAFETY PERFORMANCE CHECK (PAGE 3).

TRIGGER ASSEMBLY COMPLETE

To Disassemble: Remove the bolt assembly, trigger guard or trigger guard assembly, magazine, magazine follower and spring. Put the safety switch in the "S" position. Tap out the bolt stop pin from left to right and remove the bolt stop and bolt stop spring. Tap out the sear pin from left to right and remove the trigger assembly.

To Reassemble: Insert trigger assembly (with slave pin intact) into receiver. Align holes and tap in sear pin from left to right (chamfered end first).

NOTE: Sear pin must not protrude into the bolt stop slot.

Reassemble the bolt stop spring, bolt stop and bolt stop pin. Restake both pins on the right side of the receiver.

CAUTION: After reassembling, push the bolt stop release upward; bolt stop must pivot freely. Put the safety switch in the "F" position, pull the trigger and hold. Depress top rear of sear safety cam to insure that the sear safety cam pivots freely and retracts without hesitation. Push safety switch from "F" to "S" position several times to insure free movement with no binding and positive engagement of safety switch detents.

Reassemble the magazine, magazine follower, spring stock assembly, trigger guard and bolt assembly to the action.

SEE SAFETY PERFORMANCE CHECK (PAGE 3)

SAFETY SWITCH SNAP WASHER
SAFETY SWITCH DETENT SPRING
SAFETY SWITCH DETENT BALL
SAFETY SWITCH PIVOT PIN
BOLT STOP RELEASE

To Disassemble: Remove the bolt assembly, trigger guard, stock assembly, magazine, magazine spring and follower. Remove the safety switch snap washer, safety switch detent spring and safety switch detent ball. Push safety switch pivot pin from right to left and remove the safety switch and bolt stop release.

Remington Arms Company, Inc.

To Reassemble - Put the safety switch in the "S" position. Place the bolt stop release over the trigger pin on the left side of trigger assembly. Align holes in the bolt stop release, safety switch and trigger assembly. Push the safety switch pivot pin through the assembly from left to right. Set the safety switch detent ball into position in the safety switch. Place the safety switch detent spring over the safety switch. Make sure safety switch detent ball stays in position under the safety switch detent spring. Push the safety switch snap washer into position on the safety switch pivot pin on the right side of the trigger assembly.

CAUTION: After reassembly, push bolt stop release upward; bolt stop must pivot freely.

Put the safety switch in the "F" position, pull the trigger and hold. Depress top rear of sear safety cam to insure that the safety cam pivots freely and retracts without hesitation. Push the safety switch from "F" to "S" position several times to insure free movement with no binding and with positive engagement of safety switch detents.

Reassemble the magazine, magazine follower, spring stock assembly, trigger guard and bolt assembly into the action.

SAFETY PERFORMANCE CHECK

WARNING: CORRECT ALL MALFUNCTIONS 100% OR RETURN RIFLE TO FACTORY.

After reassembly, the following check for proper function of the safety must be made.

Close the bolt. Put the safety switch into the "S" position. Lift the bolt handle (bolt handle should not raise). Pull the trigger (firing pin should not fall). Action of the trigger pull must be smooth (no bind, drag, click or catch). Release the trigger (trigger must return to former position). Put the safety switch into the "F" position (firing pin must not fall). Pull the trigger (firing pin must fall). Repeat this test at least three (3) times. The safety switch must function in both of the two (2) positive positions; ON SAFE and FIRE. If the positions are not positive, check parts. Inspect the safety switch detent holes, safety switch snap washer, safety switch detent spring, safety switch detent ball and safety switch pivot pin for possible causes. Replace any worn or damaged parts.

CAUTION: IF STOP POSITIONS ARE NOT POSITIVE, REPLACE COMPLETE TRIGGER ASSEMBLY.

NOTE: Lubrication must not be used as a remedy for trigger assembly problems. The cause must be positively located and corrected.

After reassembling the stock assembly, check for clearance between the following parts: safety switch - stock; trigger - trigger guard; trigger - stock assembly.

Remington Arms Company, Inc.

Check for "Follow Down" (firing pin moves to uncocked position as bolt is closed). Put the safety switch into the "F" position. Close the bolt smartly. Firing pin must remain cocked (dry fire to check). If "Follow Down" occurs check for trigger being held back by interference between trigger and stock, trigger and trigger guard, or by the sear safety cam binding. Cause of "Follow Down" must be determined or the rifle should be returned to the factory.

WARNING: CORRECT ALL MALFUNCTIONS 100% OR RETURN RIFLE TO FACTORY

5/14/85
RLSTJ:sr

Remington Arms Company, Inc.

G-88

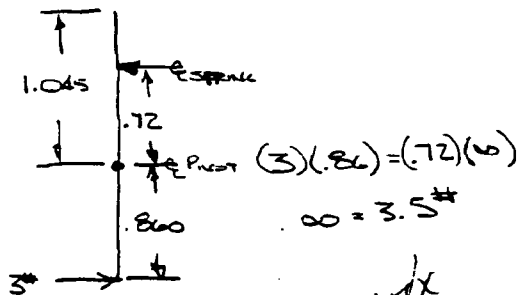
DON'T SAY IT—WRITE IT

To _____

Date _____

From _____

1.045 & To Top
 .720 & To &
 .860 & To Pull



$$\frac{.022}{1.045} = \frac{X}{.72}$$

X = .0152 SPRING TRAVEL

3.5 # SPRING FORCE

.112 DIA.
 .560 L₁
 .545 L₂

~~(3) (.86) = (.72) (3.5)~~
~~2.58 = 2.52~~
~~.06 = X~~
~~.863 = X / .661~~

"THE SAFE WAY IS THE SMART WAY"