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PROCEDURE FOR REPLACEMENT OF TRIGGER HOUSING
ASSEMBLY ON MODEL SEVEN LIGHTWEIGHT

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IMPORTANT NOTICE

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Absolutely no alterations or adjustments are to be made to the replacement trigger assembly. If any of the conditions listed below are encountered during replacement of the Trigger Assembly, return the complete rifle to the factory.

- o Difficulty assembling Stock to receiver with guard screws.
- o Trigger projecting beyond side of trigger guard.
- o Binding of sear in housing.
- o Trigger binding on trigger guard plate.
- o Trigger binding on trigger guard.

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MAKE SURE FIREARM IS NOT LOADED AND THE MAGAZINE IS EMPTY

To Disassemble Firearm:

- o Put safety switch to "S" position.
- o Remove bolt assembly from action (See Page 5 of Model Seven Instruction Book).
- o Turn rifle upside down, Barrel pointing to your left.
- o Open floor plate by pushing front of latch. (See Picture 1).
- o Completely loosen front guard screw. (See Picture 2)
- o Completely loosen rear guard screw. (See Picture 2)
- o Lift Stock away from the barreled action. The floor plate base assembly, trigger guard front and rear guard screws will remain with the Stock.
- o Remove magazine from Receiver.
- o Turn firearm with left side up and Barrel pointing left. (See Picture 3)
- o With the Safety switch in the "S" position, tap out the front and rear sear pins from left to right and remove the trigger assembly from the Receiver. (See Picture 3)

To Reassemble Firearm:

- o Insert the new trigger assembly (with slave pins intact) into the Receiver. Align holes in housing with holes in Receiver and tap in sear pins from left to right (chamfered end first). (See Picture 3)

Note: Front sear pin must not protrude into the bolt stop slot.

CAUTION:

- o After assembling, push the bolt stop release. (See Picture 4 upward; bolt stop must pivot freely.

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CAUTION: - Contd.

- o Put the safety switch in the "F" position, pull the trigger and hold. Depress the top rear of the safety cam to insure that the sear safety cam pivots freely and retracts without hesitation. (See Picture 5)
- o Push safety switch from "F" to "S" position several times to insure free movement with no binding and positive engagement of safety switch detents.
- o Restake both pins on the right side of the Receiver. Recheck to make sure bolt stop moves freely. (See Picture 6)
- o Reassemble the magazine into the Receiver. (See Picture 7)
- o Reassemble the Stock to the barreled action. This should include the floor plate base assembly trigger guard and front and rear guard screws if they were disassembled as a unit;
- o Be sure action is seated rearward in Stock.
- o Assemble front and rear guard screws to the Receiver. If any trouble is encountered in completing this step, return entire firearm to the factory.
- o Close floor plate.
- o Replace the bolt assembly.
- o After reassembling the rifle, check for clearance between the following parts; safety switch and stock, trigger and floor plate base.
- o Check for trigger projecting beyond side of trigger guard.
- o If any of these conditions are encountered, return the entire firearm to the factory.

SAFETY PERFORMANCE CHECK

The following checks for proper functioning of the safety must be made:

- o Close the bolt
- o Put the safety switch into the "S" position.

- o Pull the trigger (firing pin should not fall). Action of trigger pull must be smooth (no bind, drag, click, or catch).
- o Release the trigger (trigger must return forward to its original position).
- o Put the safety switch into the "F" position (firing pin must not fall).
- o Pull the trigger (firing pin must fall).
- o Repeat this test at least three time.
- o Push the safety switch from "F" to "S" position several times to insure free movement with no binding and positive engagement of safety switch detents.

CAUTION: IF "F" AND "S" POSITION ARE NOT POSITIVE, RETURN
COMPLETE RIFLE TO FACTORY FOR REPAIR

Check for "follow down" (firing pin moves to uncocked position as bolt is closed).

- o Put the safety switch into the "F" position.
- o Close the bolt smartly.
- o Firing pin must remain cocked. Pull the trigger to check. Firing pin must fall. Perform this operation several times.
- o If "follow down" occurs, RETURN THE RIFLE TO THE FACTORY.

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