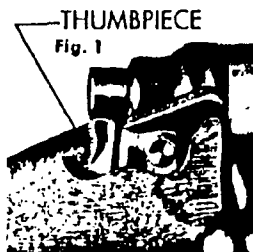


THREE POSITION SAFETY LOCK

Safe "S"

(Fig. 1)

Cock rifle then rotate safety lock thumbpiece fully rearward to "S" mark on receiver. Bolt is locked closed in this position and bolt handle cannot be raised.



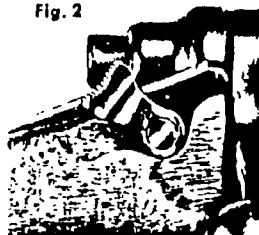
Unlock Position

(Fig. 2)

Rotate the safety lock thumbpiece to UNLOCK position between "S" and "F" (no mark). Bolt handle can then be raised and the bolt unlocked.

NOTE: Rifle cannot be fired when safety thumbpiece is set for unlock position.

Fig. 2

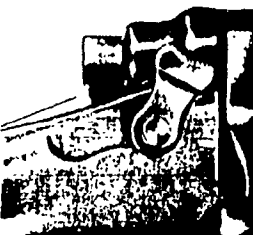


Fire "F"

(Fig. 3)

Rotate the safety lock thumbpiece fully forward to "F" mark on receiver.

Fig. 3



SIGHT ADJUSTMENTS

OPEN SIGHTS

The sights on the Remington 725 are targeted at 100 yards and carefully adjusted at the factory.

For Windage Adjustment the rear sight eyepiece may be moved to the left by turning the windage screw clockwise. By turning the windage screw counter clockwise the rear sight eyepiece may be moved to the right.

NOTE: The windage screw is located beneath the eyepiece.

For elevation or range adjustment the rear sight may be raised or lowered by adjusting the notched sight step beneath the rear sight eyepiece.

TELESCOPE or RECEIVER SIGHTS

The all-purpose stock on the Remington 725 is adapted for use with telescope or receiver sights as well as gun factory sights. The location and design of the rear sight holes are standard for most target telescope mounts. If rear sight is removed for receiver sighting clearance, the rear sight barrel screw holes may be filled with the receiver plug screws.

Shoot REMINGTON or PETERS Ammunition
for best results

The Remington 725 is calibered for high power center fire cartridges, and designed to deliver quality performance for your shooting pleasure.

A full choice of bullet weights and styles is available. Choose the cartridge best suited to your particular hunting needs.

"Kleanbore" is Reg. U.S. Pat. Off. by Remington Arms Company, Inc., Bridgeport 2, Conn. "Rustless" is a trade-mark of Peters Cartridge Division, Remington Arms Company, Inc., Bridgeport 2, Conn.

Remington



RD3339—Rev. 12 58

Remington

725

DELUXE

Bolt
Action

High
Power

REPEATING
RIFLE



Instruction
Folder

REMINGTON ARMS COMPANY, INC.
BRIDGEPORT 2, CONNECTICUT, U.S.A.

ATTACHMENT "A"

HOW to LOAD your REMINGTON 725

IMPORTANT: Before firing, always check barrel and remove any obstruction, grease or heavy oil from bore and cartridge chamber.

SINGLE LOAD

Rotate safety lock thumbpiece to UNLOCK position between "S" mark and "F" mark on receiver. Raise bolt handle and pull bolt assembly backward to bolt stop. Place cartridge on magazine follower, then push bolt forward to load cartridge into barrel (see Fig. 4). Turn bolt downward, to lock cartridge in barrel and cock rifle. Rotate safety lock thumbpiece to SAFE "S" mark, or if desired to fire rifle, rotate thumbpiece to FIRE "F" mark.

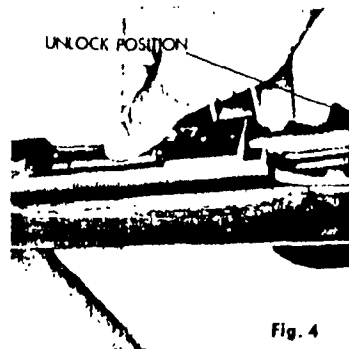


Fig. 4

MAGAZINE LOAD

Open Bolt—Load cartridges into top of magazine in conventional manner, if desired.

Closed Bolt—Rotate safety lock thumbpiece fully rearward to SAFE "S" mark on receiver. Turn rifle bottom upwards, and rotate floor plate latch forward. Lift unlatched floor plate and swing attached magazine follower and spring from magazine. Load cartridges into magazine opening (see Fig. 5). Close and latch floor plate against the staggered box column of loaded cartridges. **NOTE:** The first cartridge must be loaded to the right side of the open magazine.

Capacity—Load four (4) cartridges into magazine.

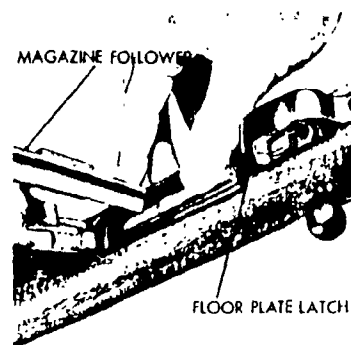


Fig. 5

UNLOAD MAGAZINE

With closed bolt:

Rotate safety lock thumbpiece fully rearward to SAFE "S" mark (bolt lock).

Turn rifle bottom upwards and unlatch floor plate from trigger guard.

Raise floor plate and remove live cartridges from magazine (see Fig. 6).

Close and latch floor plate.

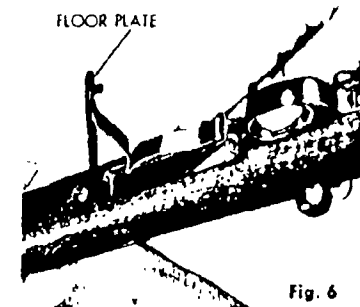


Fig. 6

UNLOAD BARREL

Rotate safety lock thumbpiece to UNLOCK position between "S" and "F" mark on receiver.

Raise bolt handle and pull bolt to rear slowly.

Lift live cartridge carefully from face of bolt as bullet end of cartridge clears the ejection port of receiver (see Fig. 7).

PRECAUTION: Make certain magazine is empty before closing bolt assembly. If live cartridge remains in magazine, return bolt forward to slide and raise cartridge free of magazine. Then pull bolt rearward again and carefully remove live cartridge from rifle.

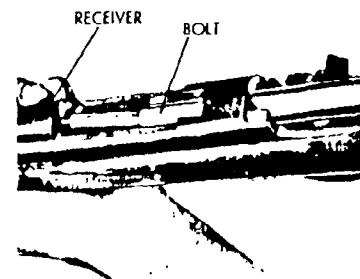
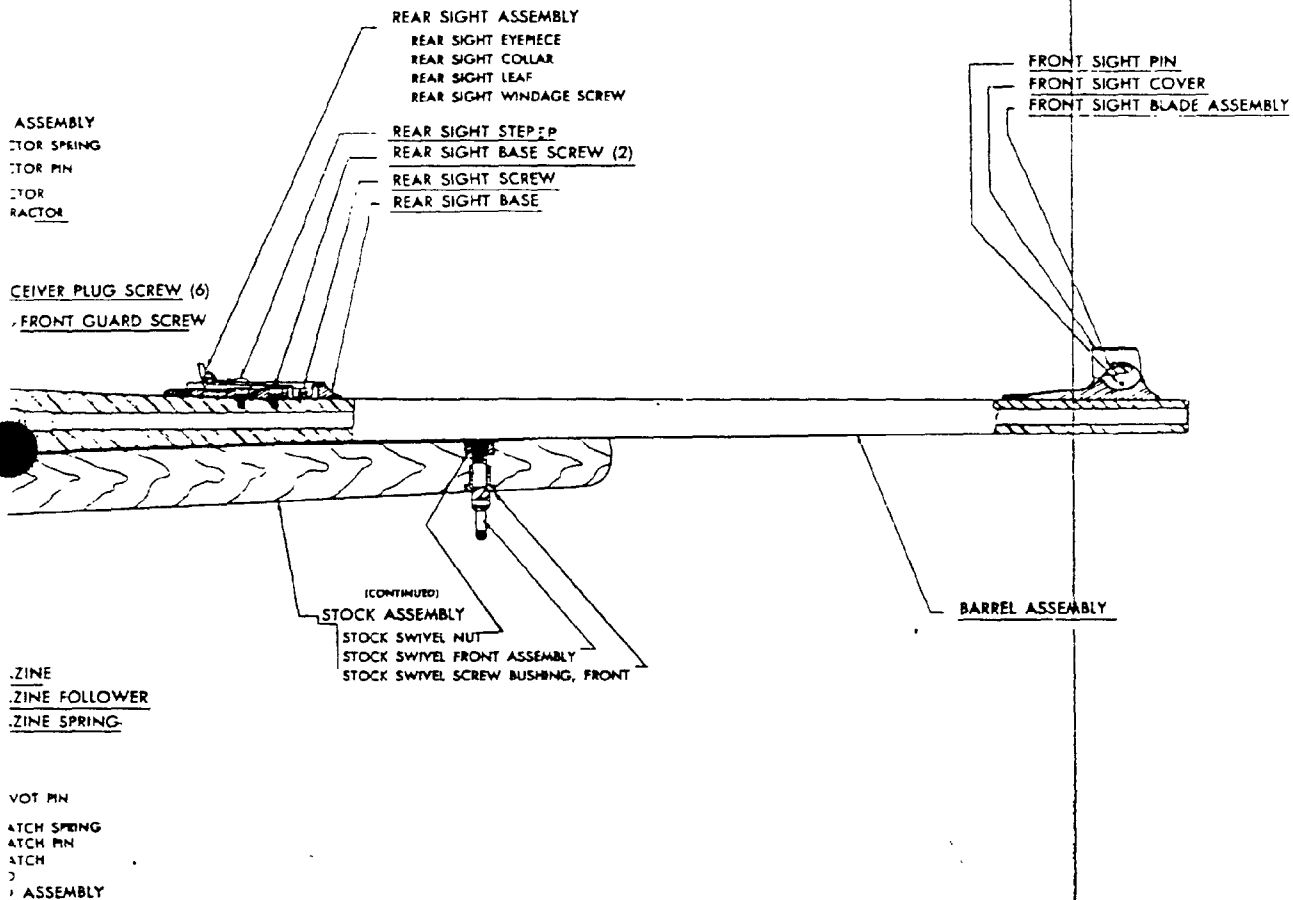
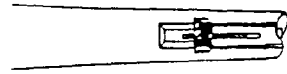


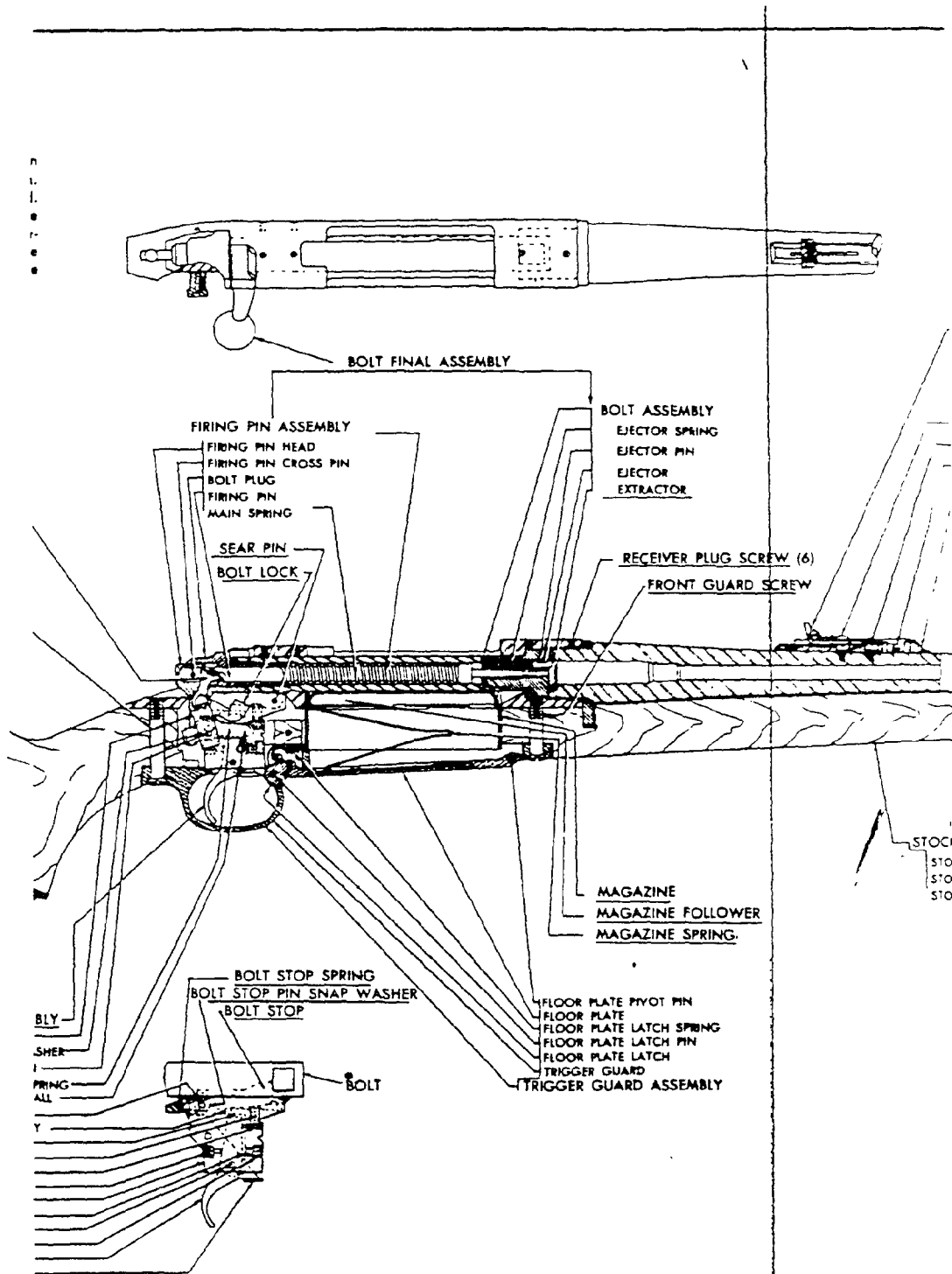
Fig. 7



Send all guns for factory service and inquiries or service and parts to
REMINGTON ARMS COMPANY, INC.
 Arms Service Division
 Ilion, New York

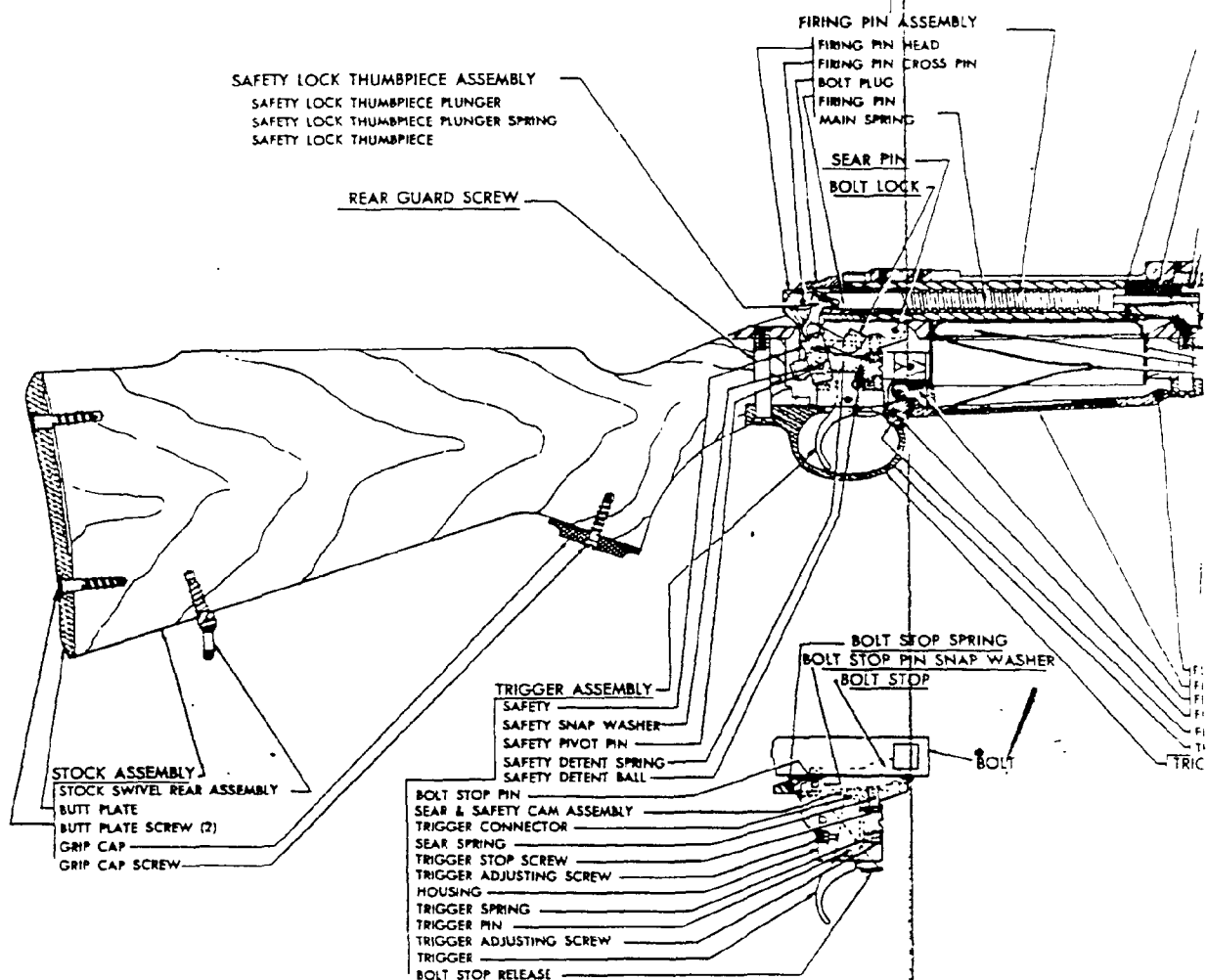
All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
 Bridgeport 2, Connecticut

ONAL VIEW



MODEL 725 SECTIONAL VIEW

REPLACEMENT PARTS: Prices for parts will be furnished upon application. When ordering parts specify model, caliber, part name and serial number of gun.
NOTE: The sale of barrel assemblies (includes receiver) and bolts is restricted. When these parts are needed for replacement, the arm must be returned to the factory as the use of special tools and gauges is required to assure proper operation. All other parts will be shipped as ordered but, since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.



MODEL 72

To keep the barrel bore in perfect condition, it is recommended that Remington Ammunition with KLEANBORE Priming, or Peters Ammunition with RUSTLESS Priming be used exclusively. These cartridges cannot cause rust or corrosion and cleaning is unnecessary other than passing an oiled patch through the bore to protect it against extreme moisture, or when the gun is laid away for some time. Also give the outside of your gun some attention after it has been

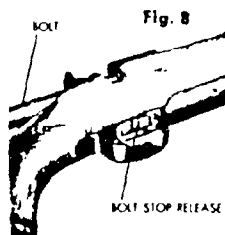
CARE OF RIFLE

handled. Wipe the gun with an oily cloth, since fingers leave invisible "prints" of moisture that may cause rust on metal unless removed. Should it be necessary to clean the action, it is recommended that the disassembly be made as instructed below. Wash with a petroleum solvent such as varnolene or kerosene, drain, and lubricate lightly. In freezing weather, oil should be removed and fine, dry graphite used as a lubricant.

To remove BOLT:

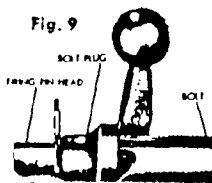
Rotate safety lock thumb-piece to UNLOCK position. Raise bolt handle and pull bolt rearward to bolt stop. Press upwards on bolt stop release (see Fig. 8) and pull bolt from receiver.

NOTE: It is not necessary to operate bolt lock release when replacing bolt.



To remove FIRING PIN ASSEMBLY:

Remove bolt from rifle. Pull firing pin head rearward until coin or similar tool can be inserted between it and bolt plug (see Fig. 9). Unscrew bolt plug to remove assembly from bolt.

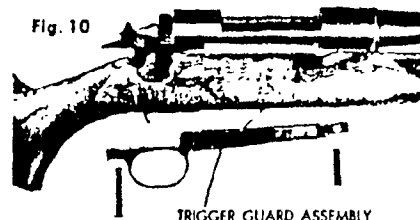


To remove STOCK:

Unscrew both guard screws and remove. Lift trigger guard assembly from rifle (see Fig. 10).

NOTE: Magazine follower, and magazine spring will also be removed from rifle when trigger guard is lifted free.

Lift stock from rifle. Separate magazine from stock.



NOTE: Before replacing stock, reassemble magazine first to receiver. Secondly, reassemble trigger guard assembly (with assembled magazine follower and spring) to stock. Then reassemble stock and trigger guard over assembled magazine and to receiver. Hold in position and replace trigger guard screws.

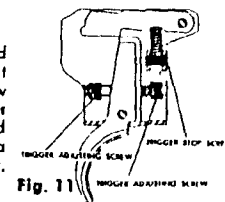
To adjust TRIGGER:

Remove trigger guard and stock. Cock bolt in receiver.

IMPORTANT: No adjustment or removal of the rear trigger adjusting screw is recommended unless replacement is necessary. The rear trigger adjusting screw is set at the factory to engage the trigger and provide the correct amount of supporting trigger connector surface beneath the sear (see Fig. 11).

Pull of Trigger:

Is adjusted to the desired weight by turning the front trigger adjusting screw clockwise for a heavier weight adjustment and counter clockwise for a lighter weight adjustment.



Travel of Trigger:

May be reduced by turning the trigger stop screw clockwise until the firing pin will not fall when the trigger is pulled. Then while keeping pressure on the trigger, back off the trigger stop screw, counter clockwise, until the firing pin falls. This method of adjustment will allow the least amount of trigger overtravel.

INSTRUCTIONS FOR ORDERING PARTS

(PLEASE READ CAREFULLY)

Please package carefully. Indicate part number and name, caliber, gauge, model and state whether on pump or cross-bolt. Identify parts from left picture or exploded view. Left interchangeable (if applicable) on separate order form to speed shipment.

Specify only one subject in letter or order. Do not order parts and give repair instructions in same letter.

Please do not ship spare parts if they may be identified otherwise. See shipping instructions below.

Part numbers listed for discontinued models. The most recent model will be applied over guns reported to us. Specify complete line parts list. **IMPORTANT** Do not continue Part Orders with Gun Service Orders. Please send Part Orders direct to:

REMINGTON ARMS COMPANY, INC.
PARTS DEPT
ARMS SERVICE DIVISION
Ilion, New York 13357

INSTRUCTIONS FOR FACTORY SERVICE

(PLEASE READ CAREFULLY)

Please package carefully. Use plenty of cushioning material to prevent movement of gun or parts in package. Please do not ship gun in a gun case or special container that must be returned. Return of gun or parts will be expedited if properly packaged in a throw-away carton. Clearly mark forwarding and return address on gun package as well as on attached letter.

Securely attach complete letter of information on outside of each package returned to factory for repairs. Please do not return gun accessories such as sling straps, quick release screws, special boots, covers, telescopes, mounts or any special equipment to factory with gun shipment. Give full details of contents. State if complete gun or part. List model number, part number and name, serial number and caliber or gauge. Give full condition of contents. Any parts missing or damaged, etc. This will enable us to accurately list needed repairs.

Do not order parts and give repair instructions in same letter. To avoid delay in starting work, please include in first order or letter the trouble to be corrected, changes desired or parts to be replaced. If an estimate is required please advise. Otherwise work will proceed and a statement of cost will be sent. This will speed service.

Unless specified otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages. Remington gun parts are not interchangeable with those of any other make. For this reason the Remington Arms Company, Inc. cannot service any gun not of its manufacture.

Repairs will be made on discontinued models as long as supply of parts is available. However, repairs cannot be made for models which are not listed in Complete Line Parts Lists.

IMPORTANT IT IS A FEDERAL OFFENSE TO SHIP FIREARMS AND AMMUNITION TOGETHER BEFORE PACKAGING FIREARMS FOR RETURN TO FACTORY, ALL LIVE AMMUNITION SHOULD BE REMOVED

If live ammunition is included in package shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail. Please send repairs direct to:

REMINGTON ARMS COMPANY, INC.
ARMS SERVICE DIVISION
Ilion, New York 13357

For instructions on how to dress, ship and deliciously cook wild game, send for the Remington "Wild Game" Cookbook \$3.95 — Remington Sportsmen's Library, P.O. Box 432, Bridgeport, Connecticut 06601.

Printed in U.S.A.

Form RD 5558
Rev. 1181

Remington



ATTACHMENT "D"

BARBER - PRESALE R 0122866

BARBER - PRESALE R 0122866 R2523854

HIGH POWER RIFLE

THE REMINGTON MODEL 788 is a high power rifle with an extremely strong action. The full length stock has a form fitting pistol grip. The receiver is fitted with removable plug screws for telescope mounts. The bolt can be removed easily for take-down.

TO PUT BOLT IN RIFLE - Your model 788 is shipped from the factory with bolt removed from rifle. Place bolt into receiver with bolt handle in 2 o'clock position. Push bolt forward into rifle.

TO COCK BOLT — Bolt must remain cocked to put into rifle. If bolt "uncocks", firing pin head will snap forward into cocking cam in rear of bolt. To cock bolt, hold firing pin head (Fig. 2) firmly to prevent movement. Use vise jaws if available. Raise bolt handle. Bolt will cam cocking surface (beneath handle) against firing pin head. Continue raising handle until cocking detent on rear of bolt engages firing pin head. Bolt is then cocked and ready for re-entry to rifle.

TO REMOVE BOLT - Raise bolt handle to unlock bolt and pull bolt rearward to bolt stop. Rotate and hold safety forward and withdraw bolt from rifle.



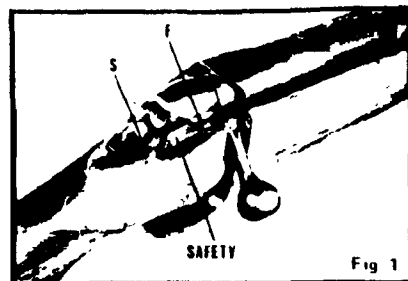
SAFETY (Fig. 1) — Close bolt and push safety to rear stop position, marked "S" on receiver. Trigger cannot be pulled to fire rifle.

FIRE — Push safety to front stop position marked "F" on receiver. Trigger can be pulled to fire rifle.



TO SINGLE LOAD - Place safety On Safe. Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load cartridge directly into chamber. Close bolt and lower bolt handle to lock action closed. Rifle is now ready to fire.

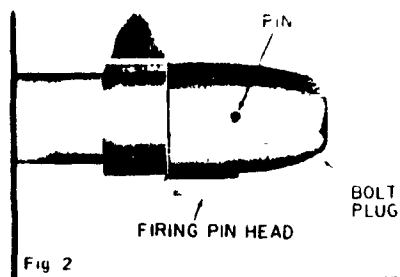
TO UNLOAD CHAMBER - Place safety On Safe. Pull bolt rearward carefully until bullet tip clears chamber. Lift cartridge from rifle.



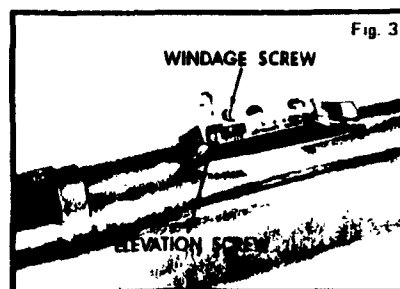
TO MAGAZINE LOAD— Grasp front and rear of magazine between thumb and forefinger. Press magazine release and pull magazine from rifle. Load cartridges into magazine. Magazine capacity for all calibers other than 222 or 223 Rem. is three (3) cartridges. When fully loaded, 222 or 223 Rem. magazine will hold four (4) cartridges. To replace magazine, press magazine evenly into rifle until it clicks into position.

TO UNLOAD MAGAZINE — Place safety On Safe. Lift bolt handle, pull bolt rearward and remove cartridge from chamber. Leave bolt in open (rear) position and remove magazine from rifle. Carefully slide cartridges forward and out of magazine.

SIGHT ADJUSTMENT — Factory sights on Remington high power rifles are targeted at 100 yards and carefully adjusted at factory for average shooters. If your rifle does not appear to shoot accurately it does not necessarily mean that sights are improperly aligned. Individual differences in eyesight or method of shooting may require sight realignment. Before attempting to re-align sights it should be realized that the greater the group size the more difficult it becomes to determine where rifle is shooting (center of impact). A consistent method of holding rifle, aiming and squeezing trigger will aid in obtaining a small group size. Different sight settings are required for each cartridge type, bullet type and weight, barrel length, each range and wind condition and, most likely, each individual shooter. To test rifle for accuracy place large target in safe area at desired range. (Before testing at a longer range it is advisable to fire a few rounds at 50 yards. At this range, bullets will generally hit somewhere on target.) Shoot from a prone



or sitting position giving body and elbows solid support. Fire four or five shots ~~and group~~, using ammunition with which you plan to hunt. Shoot carefully and deliberately. If groups are at desired point, sights are correctly adjusted, if not, you should adjust sights. If shots are too high, loosen elevation screw and lower rear sight. If shots are too low, rear sight should be raised. If rifle shoots left, rear sight (Fig. 3) should be moved right. Should rifle shoot to right, move rear sight to left. (Turn windage screw to loosen sight leaf.) Always move rear sight in direction you want rifle to shoot. Information about trajectory or ballistics of your favorite load may be found in the Remington Firearms and Ammunition Catalog. A free copy may be obtained from Remington dealers or by writing to Remington Arms Co., Inc., 939 Barnum Ave., Bridgeport, Conn. 06600.



CLEANING AND CARE - Caution: Before cleaning make sure rifle contains no live ammunition. To make cleaning of barrel and bolt easier, bolt should be removed from rifle. To clean barrel use lightly oiled, soft cloth and clean from breech to muzzle. Scrub barrel bore and cartridge chamber with a good bore solvent, if necessary. Wipe dry and re oil bore and chamber very lightly. Brush face of bolt to remove shooting residue. Wipe dry and re oil very lightly. Additional care and cleaning of bolt parts can be done, if necessary.

ACTION CARE AND DISASSEMBLY - Remove stock and bolt if necessary, to clean action or replace parts. Unscrew 2 front and rear guard screws. Turn on the

TO DISASSEMBLE BOLT PARTS — The assembly may be cleaned and oiled as a unit. Should disassembly be required, proceed as follows. With bolt cocked (handle down), insert pin (close fitting) through holes in the sides of bolt plug (Fig. 2). Lift handle and move bolt from rifle. Unscrew and remove bolt plug firing pin assembly. To reassemble, screw assembly into bolt until firing pin contacts rear of bolt. Back off (counter-clockwise) until firing pin head snaps into detent at rear edge of bolt. Replace bolt into rifle. With handle down, remove pin from bolt plug.

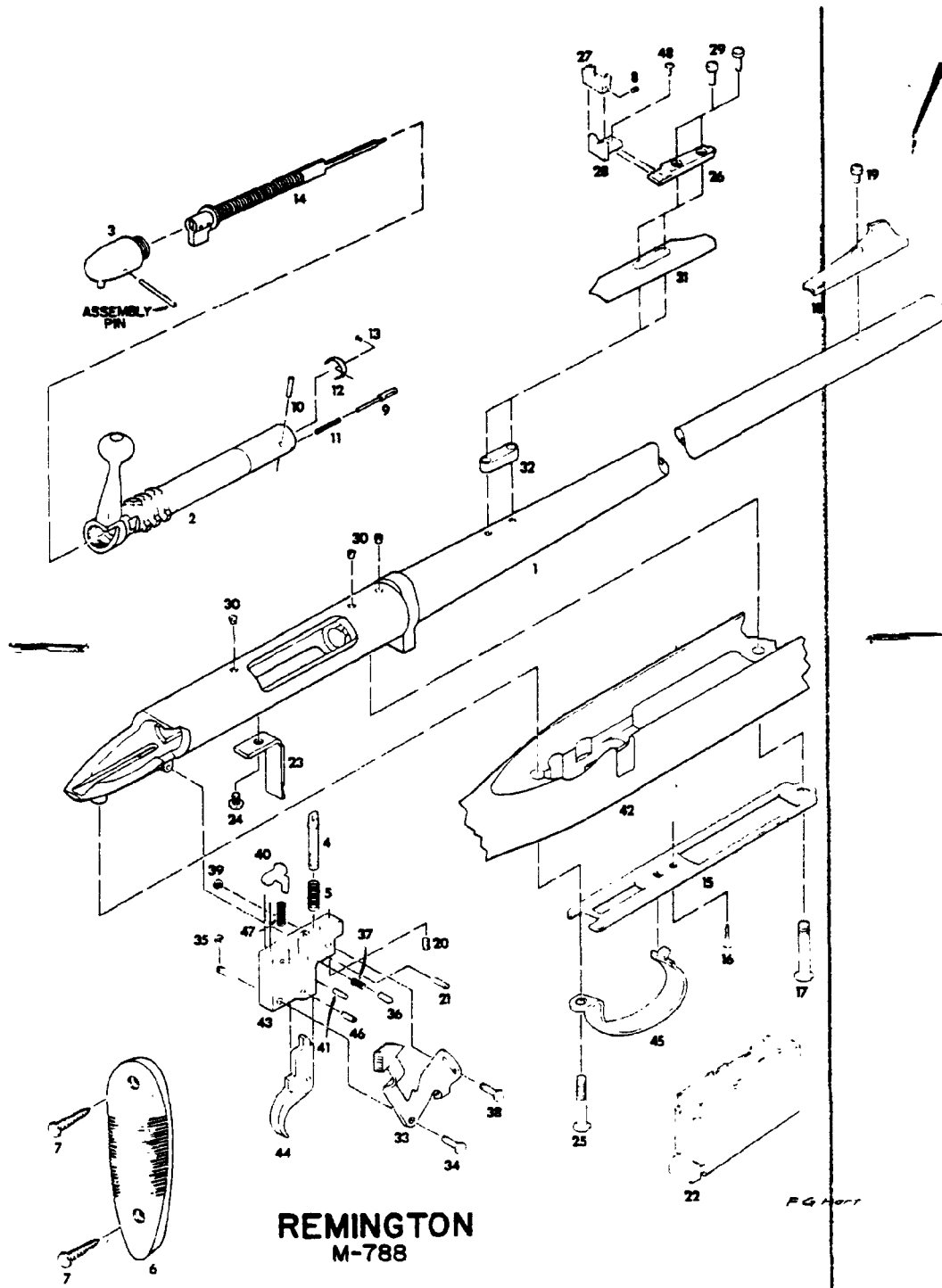
LUBRICATION — Your Remington Model 760 will remain clean longer if little or no oil is used on parts of action. Lubricate cam surfaces on bolt to prevent wear. Wash action and breech parts with a good grade of petroleum solvent, dry and re-oil very lightly. After handling, wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed. After using in wet weather, dry and wipe steel parts with oil to prevent rusting. Abrupt changes in temperature can cause condensation and wetness. Therefore, special care is needed to interior steel parts to prevent rust. When shooting in freezing weather, remove excess oil for better results. Use dry graphite if necessary to lubricate metal parts.

MAINTENANCE — Rifle should be checked periodically by a competent gunsmith to ensure proper inspection and any necessary replacement of worn or damaged parts.

IMPORTANT — Remington firearms are designed, manufactured and proof tested to standards based on factory loaded ammunition. Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

This gun has been manufactured to Remington specifications and shipped from the factory suitable for use. Remington does not recommend and is not responsible for any alteration or modification to the gun not made by Remington factory personnel, nor the placement of worn or damaged parts with the rest of Remington manufacture.

MODEL 788 BOLT ACTION HIGH POWER RIFLE



Send all guns for factory service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

MODEL 788

BOLT ACTION
HIGH POWERED RIFLE

PARTS LIST

NOTE: Prices for barrels and bolts will be quoted upon application. Factory assembly required.

SEE INSTRUCTIONS FOR ORDERING PARTS

View No.	Part No.	NAME OF PART	View No.	Part No.	NAME OF PART
NOTE: Basic 308 caliber listed below. For other caliber parts and numbers see additional calibers list.			ADDITIONAL CALIBERS		
			NOTE: Parts not listed same as 308 caliber.		
1		Barrel Assembly. (Restricted)			Barrel Assembly.
2		Bolt Assembly. (Restricted)			Bolt Assembly.
		Bolt Final Assembly. (Restricted)			Bolt Final Assembly.
3	91336	Bolt Plug.	14210		Ejector, 222, 223 Rem.
4	14246	Bolt Stop.	15850		Extractor, 222, 223 Rem.
5	14024	Bolt Stop Spring.	27342		Extractor Rivet, 222, 223 Rem.
6	14245	Butt Plate.	34350		Firing Pin Assembly, 222, 223 & 22/250 Rem.
7	25410	Butt Plate Screw.	29310		Floor Plate, 222, 223 Rem.
8	14236	Elevation Screw.	29311		Floor Plate, 22/250 Rem.
9	14211	Ejector.	29402		Front Sight, 222, 223 Rem.
10	17676	Ejector Pin.	29535		Magazine Assembly, 222 Rem.
11	14214	Ejector Spring.	29542		Magazine Assembly, 223 Rem.
12	14669	Extractor.	29536		Magazine Assembly, 22/250 Rem.
13	27340	Extractor Rivet.	29540		Magazine Assembly, 243 Win.
14	34351	Firing Pin Assembly.	29543		Magazine Assembly, 7mm 08.
15	29314	Floor Plate.	29345		Magazine Guide Bar, 222, 223 Rem.
16	14099	Floor Plate Screw.	34890		Stock Assembly, 222, 223 & 22/250 Rem.
17	14224	Front Guard Screw.			
18	29400	Front Sight (also .22 /250 Rem.)			
19	29396	Front Sight Screw.			
	14250	Front Sight Washer.			
20	14027	Housing Lock Screw.			
21	14031	Housing Pin.			
22	29539	Magazine Assembly.			
23	29346	Magazine Guide Bar.			
24	14234	Magazine Guide Bar Screw.			
25	14235	Rear Guard Screw.			
	29350	Rear Sight Assembly.			
26	14237	Rear Sight Base.			
27	14238	Rear Sight Eyepiece.			
28	15728	Rear Sight Leaf.			
29	29395	Rear Sight Screw.			
30	14242	Receiver Plug Screw.			
31	91041	Rib (Rear Sight).			
32	14244	Rib Spacer (Rear Sight).			
33	29370	Safety Assembly.			
34	14015	Safety Pivot Pin.			
35	14044	Safety Pivot Pin Retaining Washer.			
36	14497	Safety Detent.	14217		Bolt Plug (old style).
37	14498	Safety Detent Spring.	29295		Firing Pin Assembly, 222/223 & 22/250 Rem.
38	91370	Safety Retainer Pin.			(old style).
39	14044	Safety Retainer Pin Retaining Washer.	29298		Firing Pin Assembly, 308, 243 Win., 6mm Rem.
40	14503	Sear.			(old style).
41	24477	Sear Pin.			Bolt Assembly, LH (old style).
42	34891	Stock Assembly.	14467		Bolt Final Assembly, LH (old style).
	29365	Trigger Housing Assembly.	29971		Bolt Plug, LH (old style).
43	14026	Trigger Housing. (Restricted)			Firing Pin Final Assembly, LH (old style).
44	14033	Trigger. (Restricted)			
45	14971	Trigger Guard.			
46	14031	Trigger Pin.			
47	14045	Trigger Spring.			
48	14240	Windage Screw.			
			SERVICE PARTS		
			Bolt Assembly, 222/223 Rem. (old style).		
			Bolt Assembly, 22/250 Rem. (old style).		
			Bolt Assembly, 308 Win., 243 Win., 6mm Rem. (old style).		
			Bolt Final Assembly, 222/223 Rem. (old style).		
			Bolt Final Assembly, 22/250 Rem. (old style).		
			Bolt Final Assembly, 308 Win., 243 Win., 6mm Rem. (old style).		
			Bolt Plug (old style).		
			Firing Pin Assembly, 222/223 & 22/250 Rem. (old style).		
			Firing Pin Assembly, 308, 243 Win., 6mm Rem. (old style).		
			Bolt Assembly, LH (old style).		
			Bolt Final Assembly, LH (old style).		
			Bolt Plug, LH (old style).		
			Firing Pin Final Assembly, LH (old style).		
			ACCESSORY		
			25571		Sling Strap Assembly & Mountings, Complete.

REPLACES RANGE WITHOUT NOTICE

REPLACES RANGE WITHOUT NOTICE

Remington

BOLT ACTION PISTOL

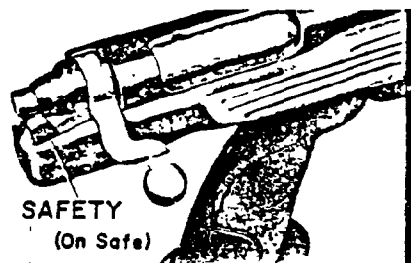
SINGLE SHOT • AUTOMATIC EJECTION

221 Rem. "Fireball"

**MOD
XP-1**
CENTER FIRE • HIGH POWER CALIBER

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1



The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "fire" pistol. When safety is ON SAFE, bolt handle cannot be raised to open action.

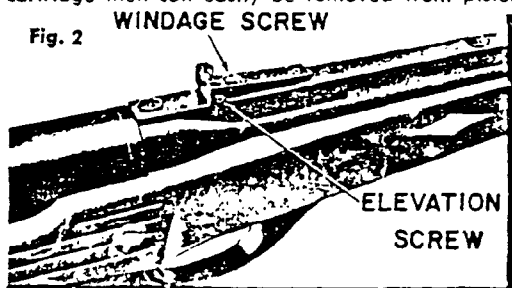
FIRE — Rotate safety with thumb to front stop position. Trigger can be pulled to fire pistol. Bolt handle can be raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any obstruction.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

Fig. 2



SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in bore with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

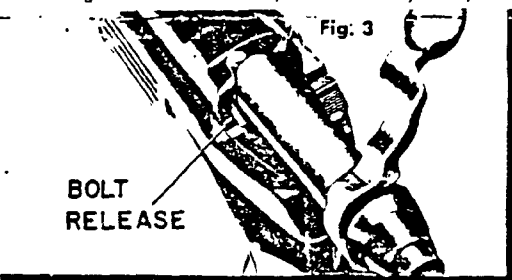


Fig. 3

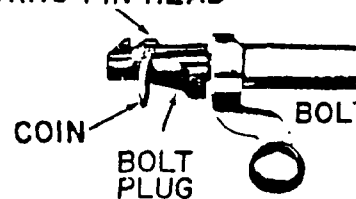
CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Small flat key or screwdriver. Allow bolt to slide back and disassemble as stop pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surface of bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until a coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

Fig. 4

FIRING PIN HEAD



TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

REMINGTON ARMS COMPANY, INC.
MILTON, NEW YORK, U.S.A.

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

Model XP-100 Bolt Action Pistol Owner's Manual

WARNING

The Trigger Balance and Trigger Balance Spring are integral parts of the Trigger mechanism which help protect against accidental discharge if the pistol is dropped.

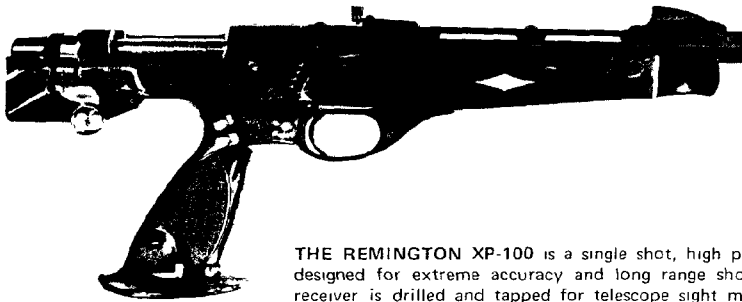
Do not use this pistol without these parts.

Do not install the barreled action on a new stock without these parts.

Remington

MODEL XP-100 BOLT ACTION PISTOL

221 REM.



THE REMINGTON XP-100 is a single shot, high power pistol designed for extreme accuracy and long range shooting. The receiver is drilled and tapped for telescope sight mounts. The receiver is fitted with removable plug screws that may be removed for mounting receiver sights or telescope mounts. Trigger

adjustment is factory sealed to provide correct weight of trigger pull.

SAFETY (Fig. 1) — The safety is located on right rear of receiver. To operate, rotate safety rearward to the ON SAFE position. With safety in this position, trigger cannot be pulled to fire pistol. Bolt handle can be raised to open action.

FIRE — Rotate safety fully forward. Trigger can be pulled to fire pistol and bolt handle raised to open action.

TO LOAD — Before loading pistol make sure barrel is clear, free of heavy oil, grease or any obstruction. Open action. Place safety ON SAFE. Load cartridge upon loading incline in receiver, close bolt and lower bolt handle to lock action.

TO UNLOAD — Raise bolt handle and carefully open action to extract cartridge from barrel chamber. Cartridge can then be easily removed.

SIGHT ADJUSTMENT — The XP-100 has a front sight of the fixed blade type that is not adjustable. The rear sight may be adjusted for both windage and elevation (Fig. 2). A small wrench is supplied with the pistol for this purpose.

WINDAGE — Loosen windage screw and move rear sight leaf to left or right to desired position. Tighten screw. Moving leaf to right will move bullet impact on target to right. Moving to left will move bullet impact to left.

ELEVATION — Loosen elevation screw, raise or lower rear sight eyepiece to desired position and tighten screw. Raising eyepiece will increase range or raise bullet impact on target. Lowering eyepiece will decrease range or lower bullet impact on target.

CLEANING AND CARE — **Caution:** Before cleaning make sure there is no cartridge in the barrel chamber. Cleaning of barrel or bolt is more easily done with bolt removed. To remove bolt, press down on front of bolt release with a small, flat key or screwdriver. Bolt release is located in left rear of bolt channel in receiver. (Fig. 3) Withdraw bolt from receiver. When cleaning barrel use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber

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Fig. 1

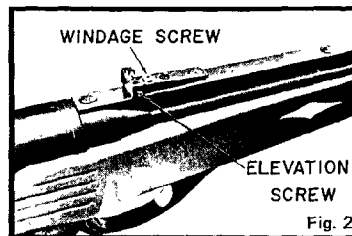


Fig. 2

To replace bolt into receiver push safety forward, align bolt lugs to receiver and push bolt forward.

After handling, wipe all steel parts. Moist fingerprints can cause rusting unless removed. After using in wet weather always wipe steel parts with oil. Abrupt temperature changes can cause condensation and wetness; therefore, special care is needed — especially to inside metal parts. For best results when shooting in freezing weather, remove excess oil. Use dry graphite if necessary to lubricate metal parts.



Fig. 3

FORE-END WEIGHTS (Fig. 5) — Five (5) cavities are provided inside fore-end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights. **To Remove Barrel and Action:** Remove bolt. Unscrew and disassemble forward and rear receiver screws. See exploded view. Lift barrel and action from stock. Insert weights and reassemble barrel and action to stock. Make certain nylon receiver screw washers (forward and rear) are in correct position against receiver during reassembly. Also that trigger balance remains centrally positioned on its pin in stock. This will enable top of balance to re-enter slot in trigger link easily. Make certain both receiver screws properly re-enter metal screw escutcheons in stock and tighten action securely.

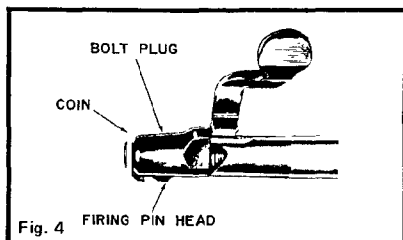


Fig. 4

MAINTENANCE — Gun should be checked periodically by a competent gunsmith to ensure proper inspection and any necessary replacement of worn or damaged parts.

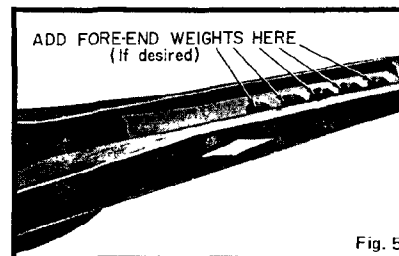
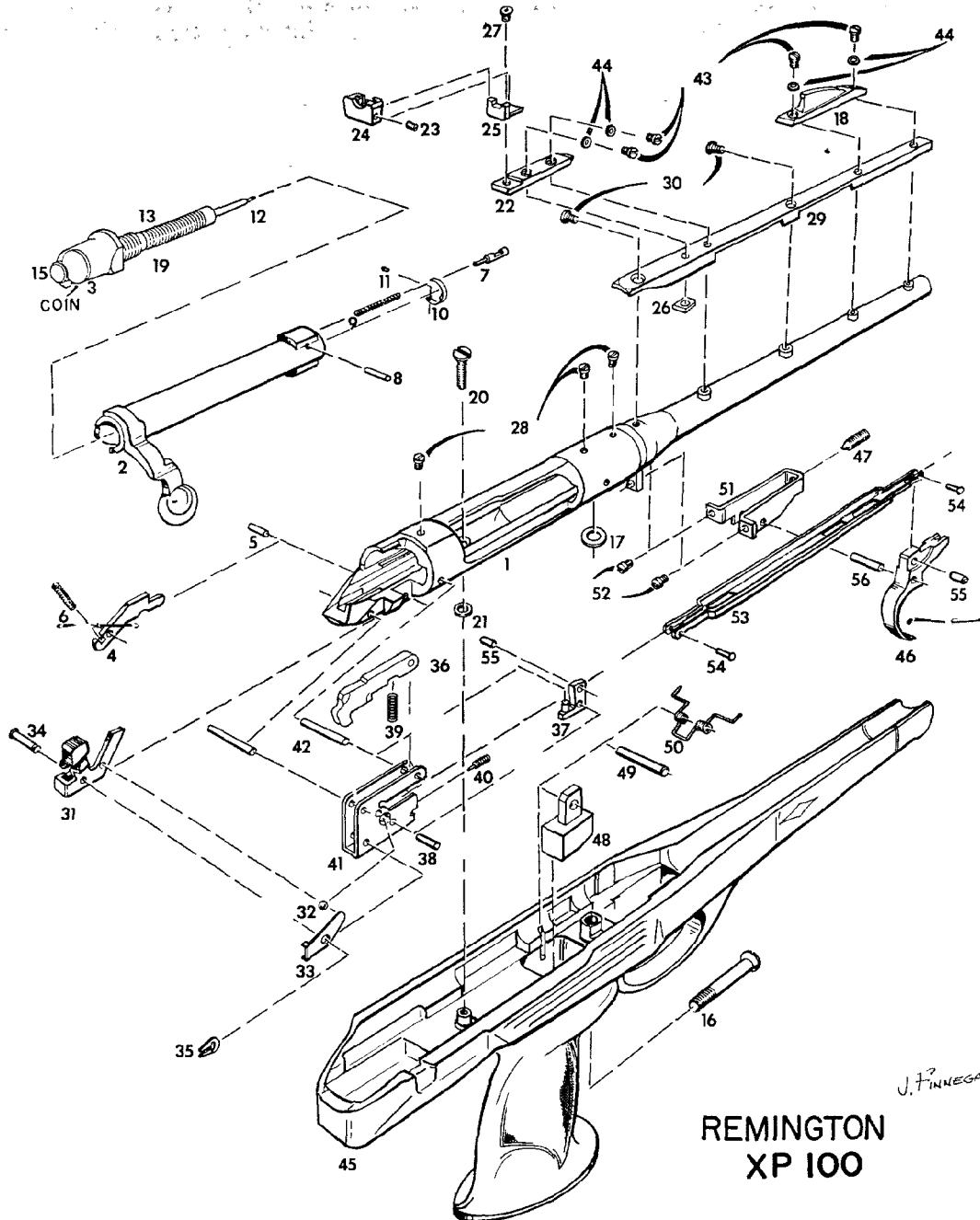


Fig. 5

IMPORTANT — Remington firearms are designed, manufactured and proof tested to standards based on factory loaded ammunition. Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

MODEL XP-100 BOLT ACTION PISTOL



REMINGTON
XP 100

Send all guns for factory service and inquiries on
service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

PARTS LIST

MODEL XP-100
BOLT ACTION PISTOL

221 REM.

NOTE: SEE INSTRUCTIONS FOR ORDERING PARTS

View No.	Part No.	NAME OF PART	List Price	View No.	Part No.	NAME OF PART	List Price
1		Barrel Assembly, 221 Rem. "Fireball" ----- (Restricted)		46	15457	Trigger-----	\$ 1.95
2		Bolt Assembly, 221 Rem. "Fireball" ----- (Restricted)		47	15469	Trigger Adjustment Screw-----	.50
		Bolt Final Assembly, 221 Rem. "Fireball" (Restricted)		48	15470	Trigger Balance-----	1.00
3	15676	Bolt Plug-----	\$ 3.85	49	15471	Trigger Balance Pin-----	.75
4	15446	Bolt Stop-----	1.05	50	15472	Trigger Balance Spring-----	.75
5	24484	Bolt Stop Pin-----	.40	51	15473	Trigger Housing-----	4.45
6	15413	Bolt Stop Spring-----	.50	52	15474	Trigger Housing Screw-----	.40
7	17017	Ejector-----	1.50	53	15458	Trigger Link-----	1.65
8	17019	Ejector Spring-----	.40	54	15459	Trigger Link Pin-----	.60
9	17676	Ejector Pin-----	.40	55	15460	Trigger Link Roller-----	.60
10	15850	Extractor-----	2.35		26800	Trigger Link Assembly-----	10.90
11	27342	Extractor Rivet-----	.50	56	24483	Trigger Pin-----	.40
12		Firing Pin----- (Restricted)					
13	28600	Firing Pin Assembly-----	13.85				
15		Firing Pin Head----- (Restricted)					
16	15447	Forward Receiver Screw-----	1.00				
17	15485	Forward Receiver Screw Washer-----	.40				
18	15449	Front Sight-----	1.95				
19	15411	Main Spring-----	.70				
20	15450	Rear Receiver Screw-----	.60				
21	5484	Rear Receiver Screw Washer-----	.40				
	26840	Rear Sight Assembly-----	5.95				
22	15727	Rear Sight Base-----	1.00				
23	15733	Rear Sight Elevation Screw-----	.60				
24	15725	Rear Sight Eyepiece-----	2.80				
25	15728	Rear Sight Leaf-----	.75				
26	15418	Rear Sight Nut-----	.50				
27	15732	Rear Sight Windage Screw-----	.60				
	15778	Rear Sight Wrench (not shown)-----	.40				
28	17034	Receiver Plug Screw-----	.40				
29	26785	Rib-----	2.45				
30	15417	Rib Screw-----	.40				
31	91496	Safety Assembly-----	2.60				
32	26850	Safety Detent Ball-----	.40				
33	15432	Safety Detent Spring-----	.70				
34	17043	Safety Pivot Pin-----	.50				
35	17044	Safety Snap Washer-----	.40				
36	14269	Sear Safety Cam-----	1.95				
37	26845	Sear Block Assembly-----	4.95				
38	24477	Sear Block Pin-----	.40				
39	15456	Sear Block Spring-----	.50				
40	17053	Sear Block Stop Screw-----	.50				
41	15452	Sear Housing-----	3.85				
42	24476	Sear Pin-----	.40				
43	15416	Sight Screw-----	.40				
44	16968	Sight Washer-----	.40				
45	26805	Stock Assembly-----	21.70				

SUPERSEDED and SERVICE PARTS

3089	Carrying Case-----	\$ 12.85
20467	Extractor-----	3.85
15448	Forward Receiver Screw Escutcheon-----	1.75
15451	Rear Receiver Screw Escutcheon-----	1.20

DELIVERIES ARE F.O.B. ILION, N. Y.

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE

INSTRUCTIONS FOR ORDERING PARTS

(PLEASE READ CAREFULLY)

Please give model number, part number and name. Give serial number and state caliber or gauge and choke. Identify parts from list, picture or exploded view. List interchangeable shotgun barrels on separate order form to speed shipment.

Cover only one subject in letter or order. Do not order parts and give repair instructions in same letter.

Please do not ship sample parts if they may be identified otherwise. See shipping instructions below.

The sale of center fire rifle barrels, bolts and receivers is restricted. Special tools and gauges are required for assembly.

Parts will be supplied for discontinued models if available. Parts cannot be supplied nor guns repaired if not listed in complete line parts list. Parts, being made to close dimensions, may require slight adjustment or fitting to assure proper function of arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders. Please send Part Orders direct to

REMINGTON ARMS COMPANY, INC.
PARTS DEPT.
ARMS SERVICE DIVISION
Ilion, New York 13357

INSTRUCTIONS FOR FACTORY SERVICE

(PLEASE READ CAREFULLY)

Please package carefully. Use plenty of cushioning material to prevent movement of gun or parts in package. Please do not ship gun in a gun case, or special container that must be returned. Return of gun or parts will be speeded if properly packaged in a throw-away carton. Clearly mark forwarding and return address on gun package as well as on attached letter.

Securely attach complete letter of information on outside of each package returned to factory for repairs. Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to factory with gun shipment. Give full details of contents. State if complete gun or part. List model number, part number and name, serial number and caliber or gauge. Give full condition of contents — any parts missing or damaged, etc. This will enable us to accurately list needed repairs.

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IMPORTANT: IT IS A FEDERAL OFFENSE TO SHIP FIREARMS AND AMMUNITION TOGETHER. BEFORE PACKAGING FIREARMS FOR RETURN TO FACTORY, ALL LIVE AMMUNITION SHOULD BE REMOVED.

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ARMS SERVICE DIVISION
Ilion, New York 13357

For instructions on how to dress, ship and deliciously cook wild game, send for the Remington "Wild Game" Cookbook \$3.95—Remington Sportsmen's Library, P.O. Box 432, Bridgeport, Connecticut 06601.

Printed in U.S.A.

Form RD 5469
Rev. 678

Model XP-100 Bolt Action Pistol Owner's Manual

IMPORTANT

This XP-100 Pistol has been fitted with a new safety assembly. One difference of the new assembly from the old is that the bolt can be opened and the chambered cartridge unloaded when the safety lever is in either the ON or OFF position. The old safety assembly enabled the bolt to be opened only when the safety lever was in the OFF position.

Read this new Owner's Manual completely before using your modified XP-100 Pistol. Pay particular attention to the Safety Section and Figure 1 on Page 1.

Remington.

MODEL XP-100 BOLT ACTION PISTOL

221 REM.



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SAFETY (Fig. 1) — The safety is located on right rear of receiver. To operate, rotate safety rearward to the ON SAFE position. With safety in this position, trigger cannot be pulled to fire pistol. Bolt handle can be raised to open action.

FIRE — Rotate safety fully forward. Trigger can be pulled to fire pistol and bolt handle raised to open action.

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TO UNLOAD — Raise bolt handle and carefully open action to extract cartridge from barrel chamber. Cartridge can then be easily removed.

SIGHT ADJUSTMENT — The XP-100 has a front sight of the fixed blade type that is not adjustable. The rear sight may be adjusted for both windage and elevation (Fig. 2). A small wrench is supplied with the pistol for this purpose.

WINDAGE — Loosen windage screw and move rear sight leaf to left or right to desired position. Tighten screw. Moving leaf to right will move bullet impact on target to right. Moving to left will move bullet impact to left.

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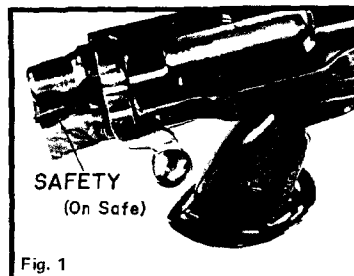


Fig. 1

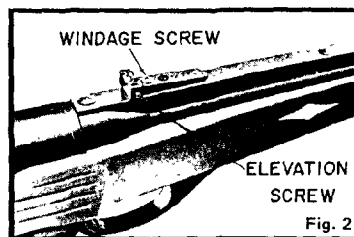


Fig. 2

To replace bolt into receiver push safety forward, align bolt lugs to receiver and push bolt forward.

After handling, wipe all steel parts. Most fingerprints can cause rusting unless removed. After using in wet weather always wipe steel parts with oil. Abrupt temperature changes can cause condensation and wetness, therefore, special care is needed — especially to inside metal parts. For best results when shooting in freezing weather, remove excess oil. Use dry graphite if necessary to lubricate metal parts.

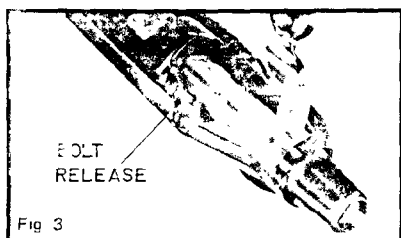


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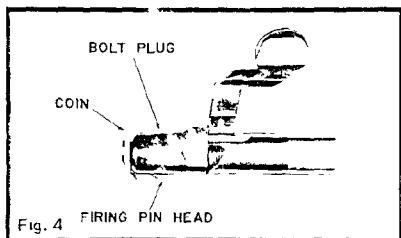


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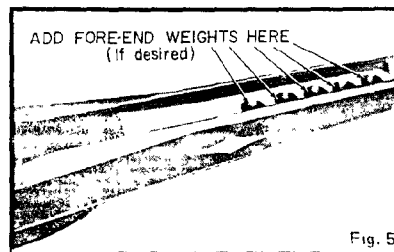
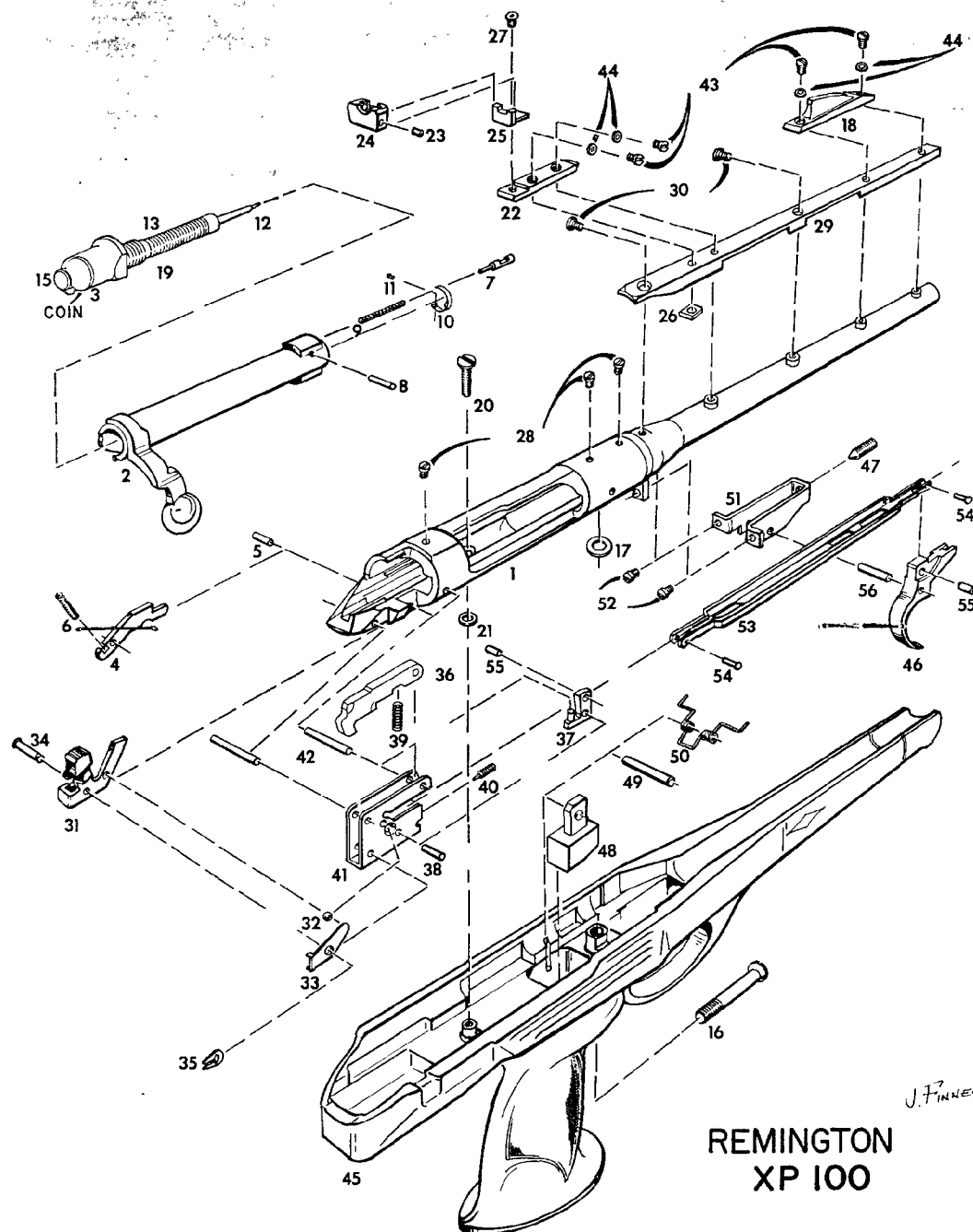


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MODEL XP-100 BOLT ACTION PISTOL



REMINGTON
XP 100

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Ilion, New York 13357

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Printed in U.S.A.

Form RD 5469
Rev. 678

**Model XP-100
Bolt Action Pistol
Owner's Manual**

Remington

MODEL XP-100 BOLT ACTION PISTOL

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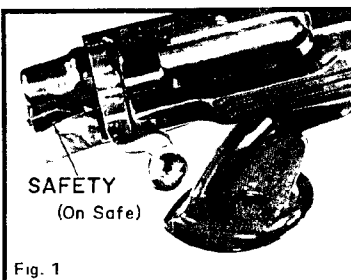


Fig. 1

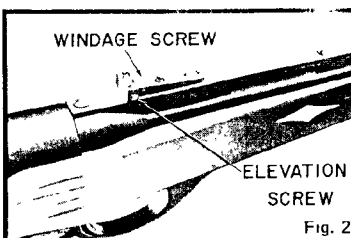


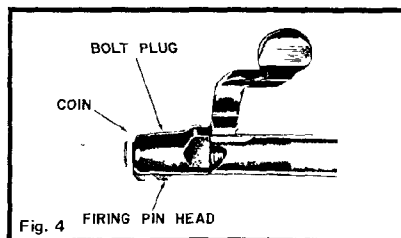
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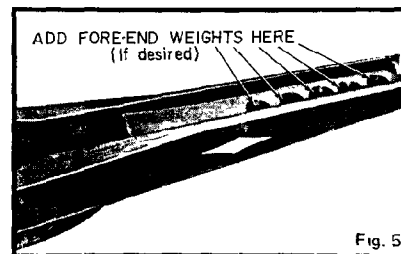
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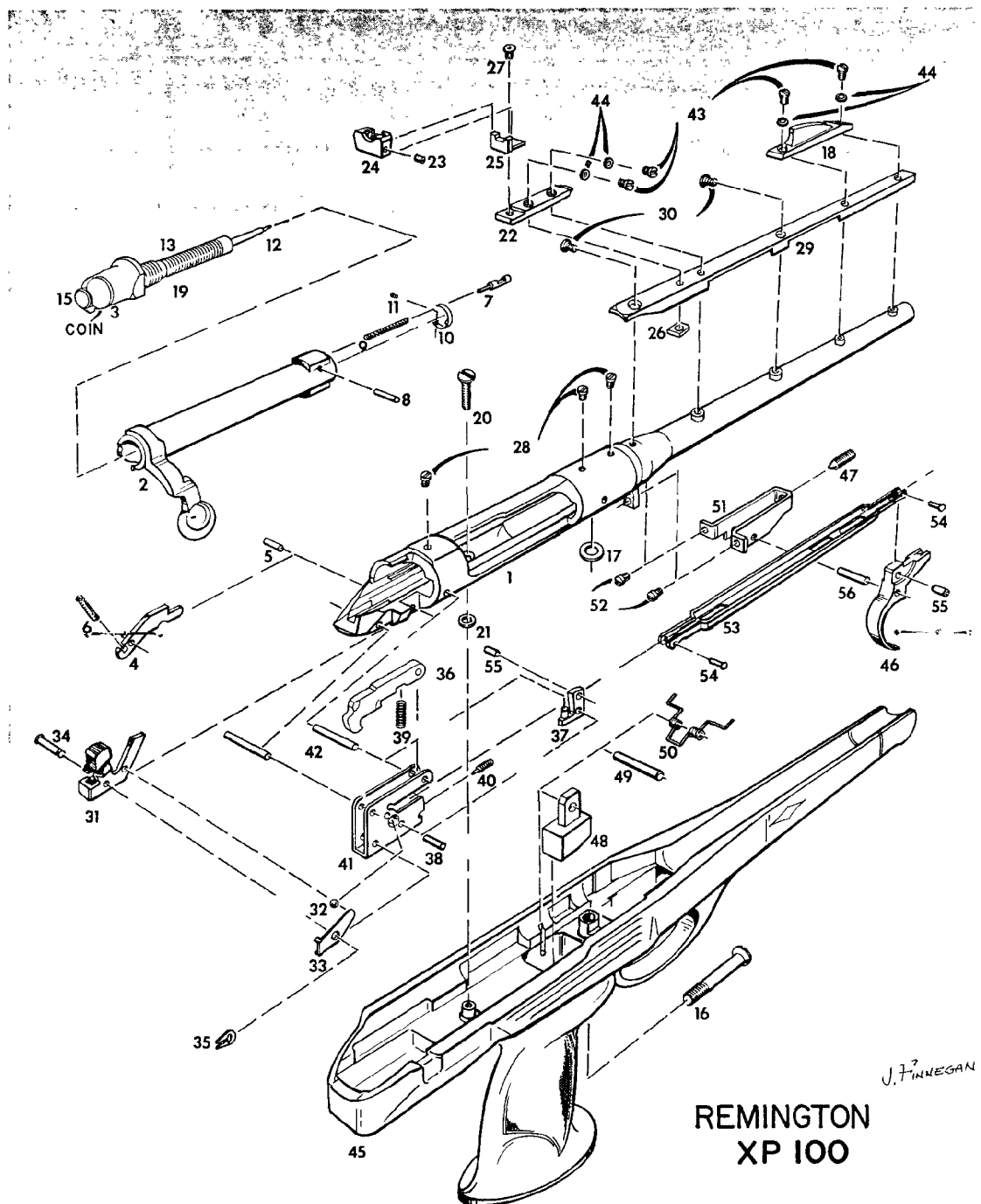


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MODEL XP-100 BOLT ACTION PISTOL



REMINGTON
XP 100

Send all guns for factory service and inquiries on
service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

INSTRUCTIONS FOR ORDERING PARTS

(PLEASE READ CAREFULLY)

Please give model number, part number and name. Give serial number and state caliber or gauge and choke. Identify parts from list, picture or exploded view. List interchangeable shotgun barrels on separate order form to speed shipment.

Cover only one subject in letter or order. Do not order parts and give repair instructions in same letter.

Please do not ship sample parts if they may be identified otherwise. See shipping instructions below.

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REMINGTON ARMS COMPANY, INC.
PARTS DEPT.
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Printed in U.S.A.

Form RD 5469
Rev. 678

Model XP-100 Bolt Action Pistol Owner's Manual

WARNING

The Trigger Balance and Trigger Balance Spring are integral parts of the Trigger mechanism which help protect against accidental discharge if the pistol is dropped.

Do not use this pistol without these parts.

Do not install the barreled action on a new stock without these parts.

IMPORTANT

This XP-100 Pistol has been fitted with a new safety assembly. One difference of the new assembly from the old is that the bolt can be opened and the chambered cartridge unloaded when the safety lever is in either the ON or OFF position. The old safety assembly enabled the bolt to be opened only when the safety lever was in the OFF position.

Read this new Owner's Manual completely before using your modified XP-100 Pistol. Pay particular attention to the Safety Section and Figure 1 on Page 1

Remington®

MODEL XP-100 BOLT ACTION PISTOL

221 REM.



THE REMINGTON XP-100 is a single shot, high power pistol designed for extreme accuracy and long range shooting. The receiver is drilled and tapped for telescope sight mounts. The receiver is fitted with removable plug screws that may be removed for mounting receiver sights or telescope mounts. Trigger

adjustment is factory sealed to provide correct weight of trigger pull.

SAFETY (Fig. 1) — The safety is located on right rear of receiver. To operate, rotate safety rearward to the ON SAFE position. With safety in this position, trigger cannot be pulled to fire pistol. Bolt handle can be raised to open action.

FIRE — Rotate safety fully forward. Trigger can be pulled to fire pistol and bolt handle raised to open action.

TO LOAD — Before loading pistol make sure barrel is clear, free of heavy oil, grease or any obstruction. Open action. Place safety ON SAFE. Load cartridge upon loading incline in receiver, close bolt and lower bolt handle to lock action.

TO UNLOAD — Raise bolt handle and carefully open action to extract cartridge from barrel chamber. Cartridge can then be easily removed.

SIGHT ADJUSTMENT — The XP-100 has a front sight of the fixed blade type that is not adjustable. The rear sight may be adjusted for both windage and elevation (Fig. 2). A small wrench is supplied with the pistol for this purpose.

WINDAGE — Loosen windage screw and move rear sight leaf to left or right to desired position. Tighten screw. Moving leaf to right will move bullet impact on target to right. Moving to left will move bullet impact to left.

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Fig. 1

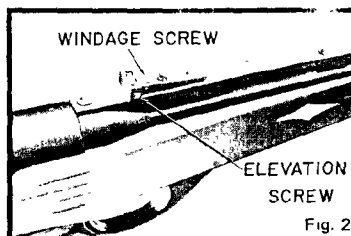


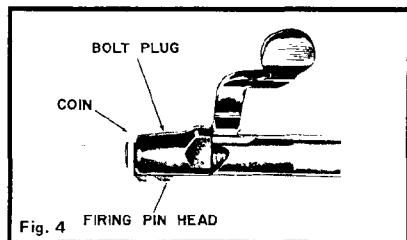
Fig. 2

To replace bolt into receiver push safety forward, align bolt lugs to receiver and push bolt forward.

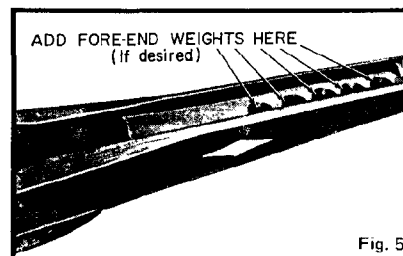
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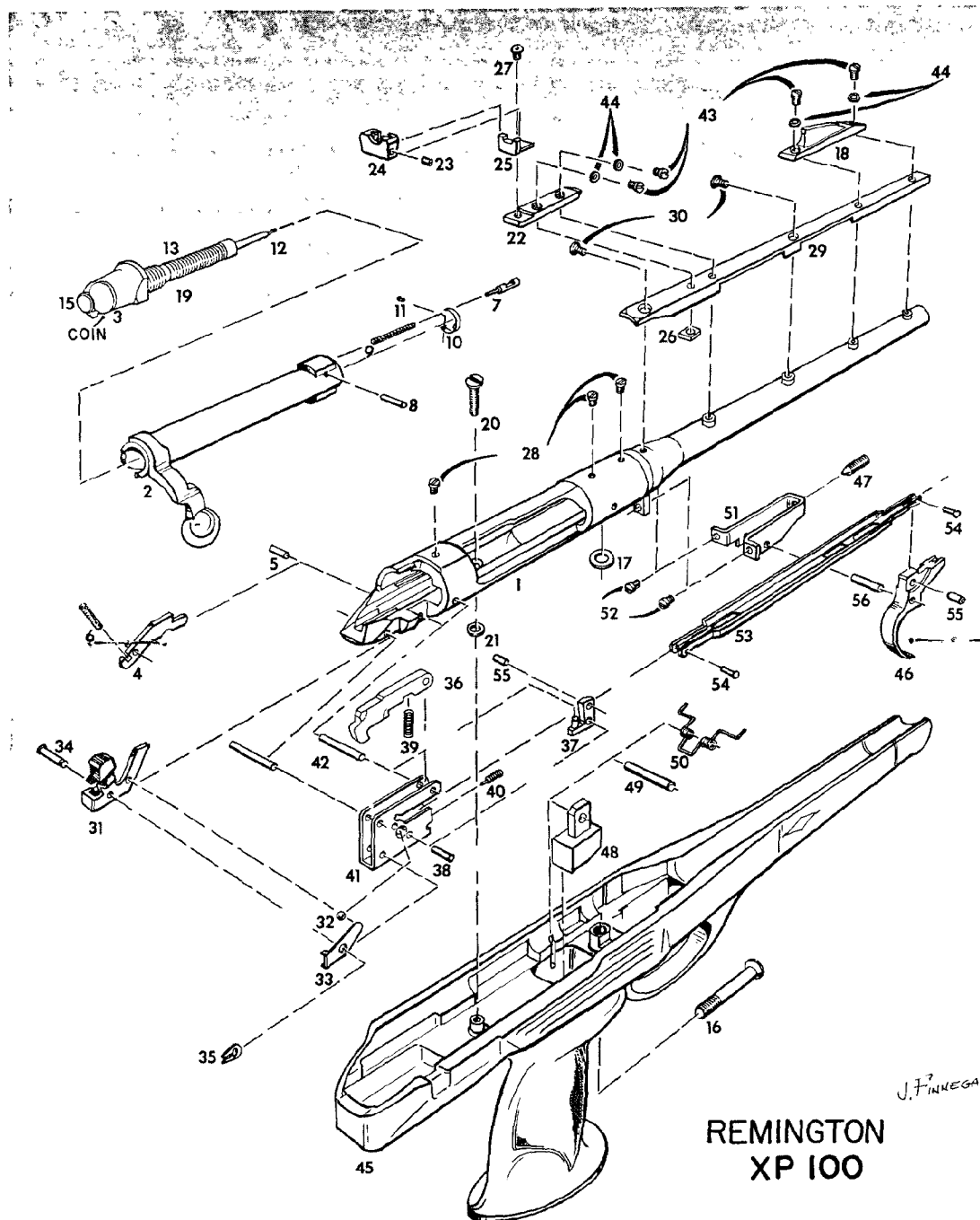


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MODEL XP-100 BOLT ACTION PISTOL



REMINGTON
XP 100

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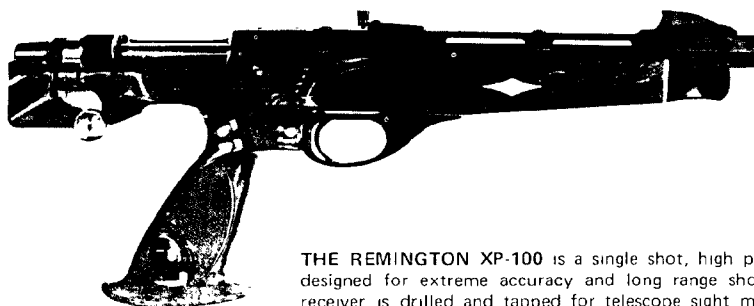
Form RD 5469
Rev. 678

**Model XP 100
Bolt Action Pistol
Owner's Manual**

Remington

MODEL XP-100 BOLT ACTION PISTOL

221 REM.



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See exploded view.

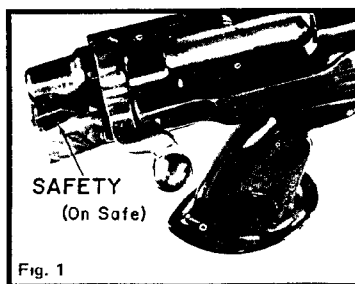


Fig. 1

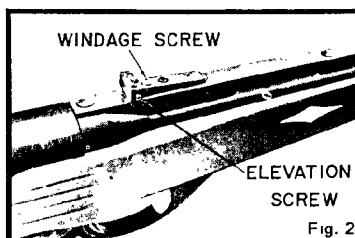


Fig. 2

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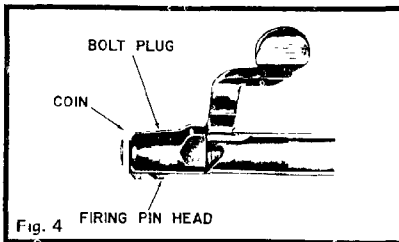


Fig. 4

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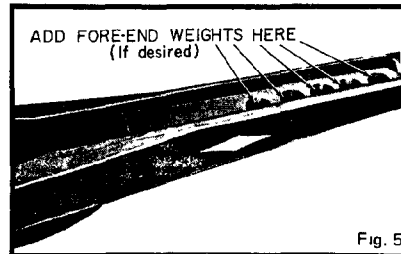
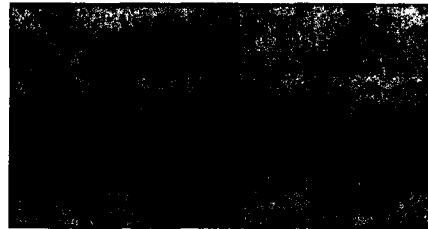
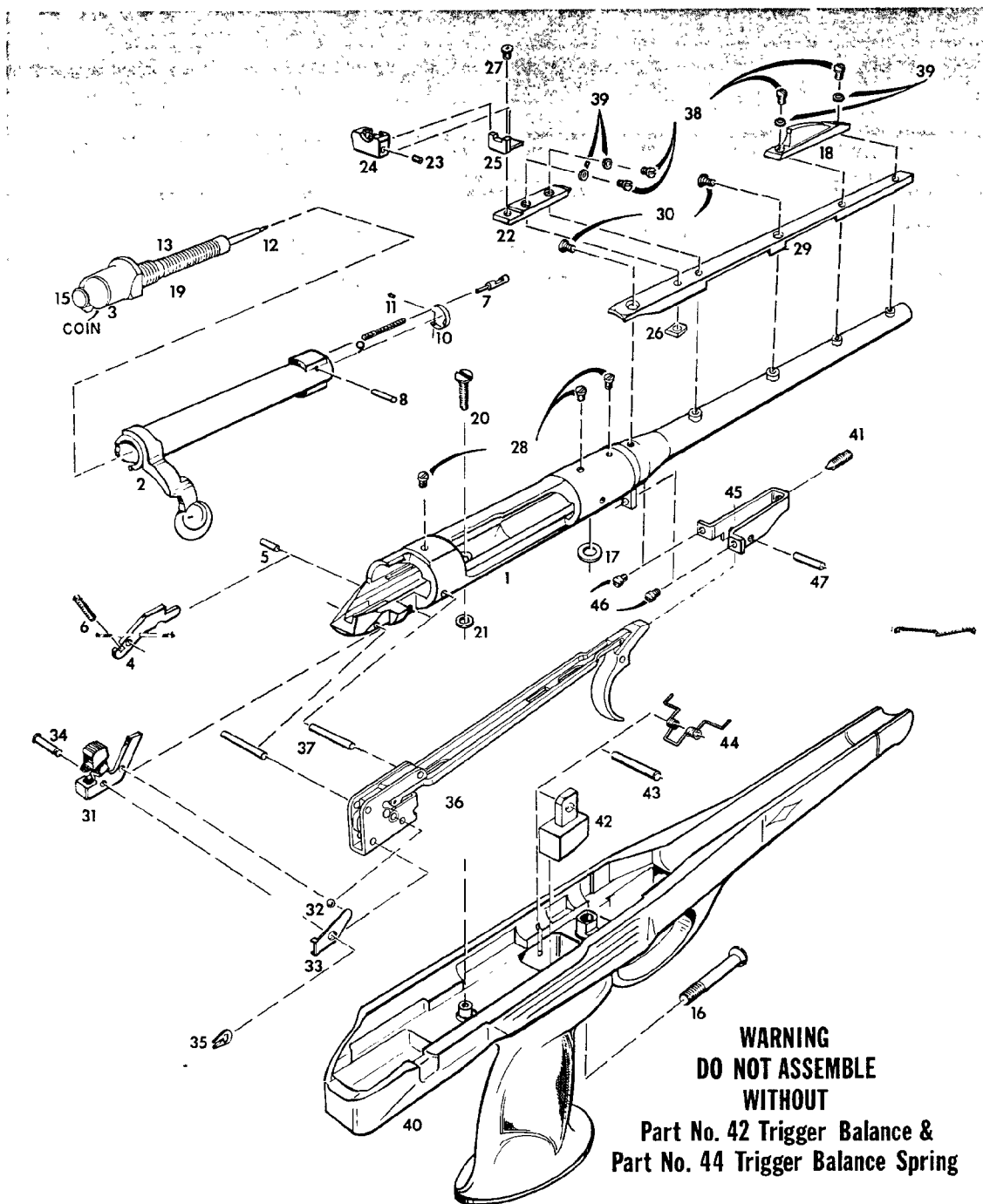


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MODEL XP-100 BOLT ACTION PISTOL



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PARTS LIST

**MODEL XP-100
BOLT ACTION PISTOL**

221 REM.

NOTE: SEE INSTRUCTIONS FOR ORDERING PARTS.

View No.	Part No.	NAME OF PART	List Price	View No.	Part No.	NAME OF PART	List Price
1		Barrel Assembly, 221 Rem. "Fireball" (Restricted)		41	15470	Trigger Balance	1.00
2		Bolt Assembly, 221 Rem. "Fireball" (Restricted)		42	15471	Trigger Balance Pin	.75
		Bolt Final Assembly, 221 Rem. "Fireball" (Restricted)		43	15472	Trigger Balance Spring	.75
3	15676	Bolt Plug	\$ 3.85	44	15473	Trigger Housing	4.45
4	15446	Bolt Stop	1.05	45	15469	Trigger Housing Screw Front	.50
5	24484	Bolt Stop Pin	.40	46	15474	Trigger Housing Screw Rear	.40
6	15413	Bolt Stop Spring	.50	47	24483	Trigger Pin	.40
7	17017	Ejector	1.50				
8	17019	Ejector Spring	.40				
9	17676	Ejector Pin	.40				
10	15850	Extractor	2.35				
11	27342	Extractor Rivet	.50				
12		Firing Pin (Restricted)					
13	28600	Firing Pin Assembly	13.85				
15		Firing Pin Head (Restricted)					
16	15447	Forward Receiver Screw	1.00				
17	15485	Forward Receiver Screw Washer	.40				
18	15449	Front Sight	1.95				
19	15411	Main Spring	.70				
20	15450	Rear Receiver Screw	.60				
21	15484	Rear Receiver Screw Washer	.40				
	26840	Rear Sight Assembly	5.95				
22	15727	Rear Sight Base	1.00				
23	15733	Rear Sight Elevation Screw	.60				
24	15725	Rear Sight Eyepiece	2.80				
25	15728	Rear Sight Leaf	.75				
26	15418	Rear Sight Nut	.50				
27	15732	Rear Sight Windage Screw	.60				
	15778	Rear Sight Wrench (not shown)	.40				
28	17034	Receiver Plug Screw	.40				
29	26785	Rib	2.45				
30	15417	Rib Screw	.40				
31	91496	Safety Assembly	2.60				
32	26850	Safety Detent Ball	.40				
33	15432	Safety Detent Spring	.70				
34	17043	Safety Pivot Pin	.50				
35	17044	Safety Snap Washer	.40				
36	26790	Sear Housing Assembly					
37	24476	Sear Pin	.40				
38	15416	Sight Screw	.40				
39	16968	Sight Washer	.40				
40	26805	Stock Assembly	21.70				

DELIVERIES ARE F.O.B. ILION, N. Y.

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE

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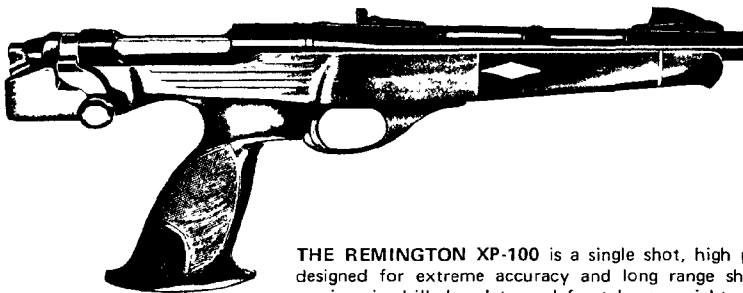
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Remington

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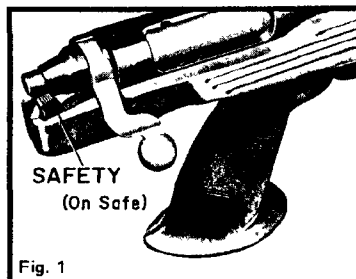


Fig. 1

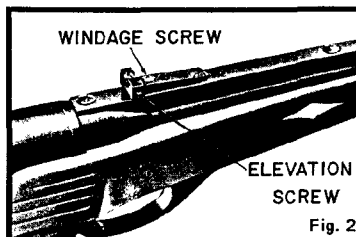


Fig. 2

To replace bolt into receiver push safety forward, align bolt lugs to receiver and push bolt forward.

After handling, wipe all steel parts. Moist fingerprints can cause rusting unless removed. After using in wet weather always wipe steel parts with oil. Abrupt temperature changes can cause condensation and wetness; therefore, special care is needed — especially to inside metal parts. For best results when shooting in freezing weather, remove excess oil. Use dry graphite if necessary to lubricate metal parts.



Fig. 3

FORE-END WEIGHTS (Fig. 5) — Five (5) cavities are provided inside fore-end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights. **To Remove Barrel and Action:** Remove bolt. Unscrew and disassemble forward and rear receiver screws. See exploded view. Lift barrel and action from stock. Insert weights and reassemble barrel and action to stock. Make certain nylon receiver screw washers (forward and rear) are in correct position against receiver during reassembly. Also that trigger balance remains centrally positioned on its pin in stock. This will enable top of balance to re-enter slot in trigger link easily. Make certain both receiver screws properly re-enter metal screw escutcheons in stock and tighten action securely.

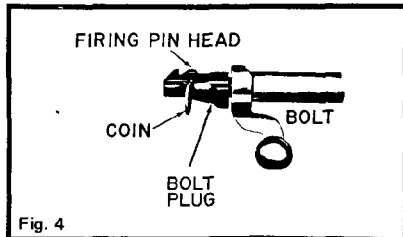


Fig. 4

MAINTENANCE — Gun should be checked periodically by a competent gunsmith to ensure proper inspection and any necessary replacement of worn or damaged parts.

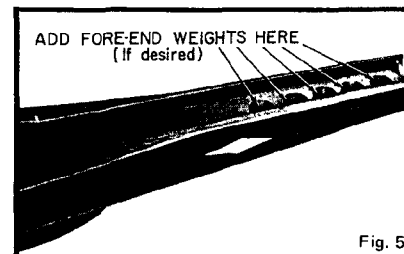
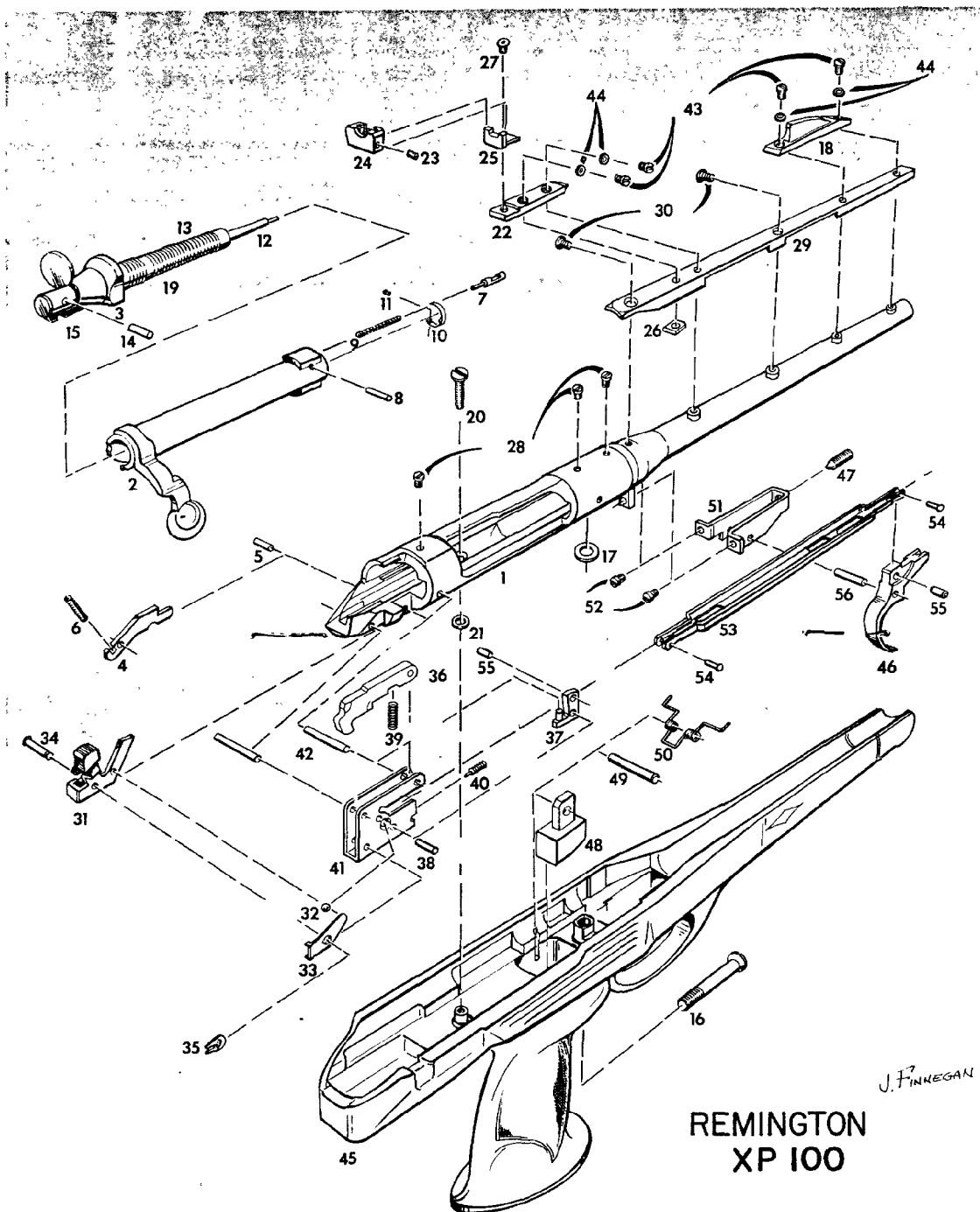


Fig. 5

IMPORTANT — Remington firearms are designed, manufactured and proof tested to standards based on factory loaded ammunition. Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

MODEL XP-100 BOLT ACTION PISTOL



REMINGTON
XP 100

Send all guns for factory service and inquiries on
service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport, Connecticut 06602

PARTS LIST

MODEL XP-100
BOLT ACTION PISTOL

221 REM.

NOTE: SEE INSTRUCTIONS FOR ORDERING PARTS.

View No.	Part No.	NAME OF PART	List Price	View No.	Part No.	NAME OF PART	List Price
1		Barrel Assembly, 221 Rem. "Fireball" (Restricted)		46	15457	Trigger	\$ 1.70
2		Bolt Assembly, 221 Rem. "Fireball" (Restricted)		47	15469	Trigger Adjustment Screw	.40
		Bolt Final Assembly, 221 Rem. "Fireball" (Restricted)		48	15470	Trigger Balance	.85
3	15676	Bolt Plug	\$ 3.35	49	15471	Trigger Balance Pin	.65
4	15446	Bolt Stop	.90	50	15472	Trigger Balance Spring	.65
5	24484	Bolt Stop Pin	.35	51	15473	Trigger Housing	3.85
6	15413	Bolt Stop Spring	.40	52	15474	Trigger Housing Screw	.35
7	17017	Ejector	1.30	53	15458	Trigger Link	1.40
8	17019	Ejector Spring	.35	54	15459	Trigger Link Pin	.50
9	17676	Ejector Pin	.35	55	15460	Trigger Link Roller	.50
10	15850	Extractor	2.05		26800	Trigger Link Assembly	9.45
11	27342	Extractor Rivet	.40	56	24483	Trigger Pin	.35
12		Firing Pin (Restricted)		SUPERSEDED and SERVICE PARTS			
13	28600	Firing Pin Assembly	12.05				
14	17022	Firing Pin Cross Pin	.35	3089	Carrying Case	\$ 11.15	
15		Firing Pin Head (Restricted)		20467	Extractor	3.35	
16	15447	Forward Receiver Screw	.85	15448	Forward Receiver Screw Escutcheon	1.50	
17	15485	Forward Receiver Screw Washer	.35	15451	Rear Receiver Screw Escutcheon	1.05	
18	15449	Front Sight	1.70				
19	15411	Main Spring	.60				
20	15450	Rear Receiver Screw	.50				
21	5484	Rear Receiver Screw Washer	.35				
	26840	Rear Sight Assembly	5.15				
22	15727	Rear Sight Base	.85				
23	15733	Rear Sight Elevation Screw	.50				
24	15725	Rear Sight Eyepiece	2.40				
25	15728	Rear Sight Leaf	.65				
26	15418	Rear Sight Nut	.40				
27	15732	Rear Sight Windage Screw	.50				
	15778	Rear Sight Wrench (not shown)	.35				
28	17034	Receiver Plug Screw	.35				
29	26785	Rib	2.10				
30	15417	Rib Screw	.35				
31	26795	Safety Assembly	2.25				
32	26850	Safety Detent Ball	.35				
33	15432	Safety Detent Spring	.60				
34	17043	Safety Pivot Pin	.40				
35	17044	Safety Snap Washer	.35				
36	14269	Sear Safety Cam	1.70				
37	26845	Sear Block Assembly	4.30				
38	24477	Sear Block Pin	.35				
39	15456	Sear Block Spring	.40				
40	17053	Sear Block Stop Screw	.40				
41	15452	Sear Housing	3.35				
42	24476	Sear Pin	.35				
43	15416	Sight Screw	.35				
44	16968	Sight Washer	.35				
45	26805	Stock Assembly	18.85				

DELIVERIES ARE F.O.B. ILION, N. Y.

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE

INSTRUCTIONS FOR ORDERING PARTS

(PLEASE READ CAREFULLY)

Please give model number, part number and name. Give serial number and state caliber or gauge and choke. Identify parts from list, picture or exploded view. List interchangeable shotgun barrels on separate order form to speed shipment.

Cover only one subject in letter or order. Do not order parts and give repair instructions in same letter.

Please do not ship sample parts if they may be identified otherwise. See shipping instructions below.

The sale of center fire rifle barrels, bolts and receivers is restricted. Special tools and gauges are required for assembly.

Parts will be supplied for discontinued models if available. Parts cannot be supplied nor guns repaired if not listed in complete line parts list. Parts, being made to close dimensions, may require slight adjustment or fitting to assure proper function of arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders. Please send Part Orders direct to

REMINGTON ARMS COMPANY, INC.
PARTS DEPT.
ARMS SERVICE DIVISION
Ilion, New York 13357

INSTRUCTIONS FOR FACTORY SERVICE

(PLEASE READ CAREFULLY)

Please package carefully. Use plenty of cushioning material to prevent movement of gun or parts in package. Please do not ship gun in a gun case, or special container that must be returned. Return of gun or parts will be speeded if properly packaged in a throw-away carton. Clearly mark forwarding and return address on gun package as well as on attached letter.

Securely attach complete letter of information on outside of each package returned to factory for repairs. Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to factory with gun shipment. Give full details of contents. State if complete gun or part. List model number, part number and name, serial number and caliber or gauge. Give full condition of contents — any parts missing or damaged, etc. This will enable us to accurately list needed repairs.

Do not order parts and give repair instructions in same letter. To avoid delay in starting work, please include in first order or letter the trouble to be corrected, changes desired or parts to be replaced. If an estimate is required please advise. Otherwise work will proceed and a statement of cost will be sent. This will speed service.

Unless specified otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages. Remington gun parts are not interchangeable with those of any other make. For this reason the Remington Arms Company, Inc., cannot service any gun not of its manufacture.

Repairs will be made on discontinued models as long as supply of parts is available. However, repairs cannot be made for models which are not listed in Complete Line Parts Lists.

IMPORTANT: IT IS A FEDERAL OFFENSE TO SHIP FIREARMS AND AMMUNITION TOGETHER. BEFORE PACKAGING FIREARMS FOR RETURN TO FACTORY, ALL LIVE AMMUNITION SHOULD BE REMOVED.

If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail. Please send repairs direct to:

REMINGTON ARMS COMPANY, INC.
ARMS SERVICE DIVISION
Ilion, New York 13357

For instructions on how to dress, ship and deliciously cook wild game, send for the Remington "Wild Game" Cookbook \$3.95—Remington Sportsmen's Library, P. O. Box 432, Bridgeport, Connecticut 06601.

Remington**CENTER FIRE • HIGH POWER CALIBER**

BOLT ACTION PISTOL

SINGLE SHOT • AUTOMATIC EJECTION

221 Rem. "Fireball"

**MODEL
XP-100**

OPK:

The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "fire" pistol. When safety is ON SAFE, bolt handle cannot be raised to open action.

FIRE — Rotate safety with thumb to front stop position. Trigger can be pulled to fire pistol. Bolt handle can be raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any obstruction.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless care or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

REMINGTON ARMS COMPANY, INC.

ILION, NEW YORK, U.S.A.

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn

CF 33

**MODEL
XP-100**

**Bolt Action Pistol
SINGLE SHOT**

ALWAYS ORDER BY PART NAME AND PART NUMBER

Part No.	NAME OF PART	Part No.	NAME OF PART
26750	Barrel Assembly, 221 Rem. "Fireball" (includes Barrel, Barrel Bracket, Barrel Stud (4), Receiver)	15778	Rear Sight Wrench (not shown)
26775	Bolt Assembly, 221 Rem. "Fireball" (includes Bolt Body Assembly and Bolt Handle)	17034	Receiver Plug Screw
26770	Bolt Final Assembly, 221 Rem. "Fireball" (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Firing Pin Assembly) (not shown)	26785	Rib
15409	Bolt Plug	15417	Rib Screw
15446	Bolt Stop	26795	Safety Assembly (includes Safety, Safety Thumbpiece)
24484	Bolt Stop Pin	26850	Safety Detent Ball
15413	Bolt Stop Spring	15432	Safety Detent Spring
17639	Ejector	17043	Safety Pivot Pin
17019	Ejector Spring	17044	Safety Snap Washer
17676	Ejector Pin	26735	Sear and Safety Cam Assembly (includes Safety Cam, Sear)
20467	Extractor	26845	Sear Block Assembly (includes Sear Block, Sear Block Stud)
15410	Firing Pin	24477	Sear Block Pin
26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	15456	Sear Block Spring
17022	Firing Pin Cross Pin	17053	Sear Block Stop Screw
23321	Firing Pin Head	15452	Sear Housing
15447	Forward Receiver Screw	24476	Sear Pin
15485	Forward Receiver Screw Washer	15416	Sight Screw
15449	Front Sight	26805	Stock Assembly (includes Fore-end Tip, Fore-end Tip Spacer, Fore-end Diamond, Forward Receiver Screw Escutcheon, Grip Diamond, Rear Receiver Screw Escutcheon, Stock Half, Left; Stock Half, Right; Trigger Guard)
5411	Main Spring	15457	Trigger
15450	Rear Receiver Screw	15469	Trigger Adjusting Screw
15484	Rear Receiver Screw Washer	15470	Trigger Balance
26840	Rear Sight Assembly (includes Rear Sight Base, Rear Sight Elevation Screw, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw) (not shown)	15471	Trigger Balance Pin
15727	Rear Sight Base	15472	Trigger Balance Spring
15733	Rear Sight Elevation Screw	15473	Trigger Housing
15725	Rear Sight Eyepiece	15474	Trigger Housing Screw
15728	Rear Sight Leaf	15458	Trigger Link
15418	Rear Sight Nut	15459	Trigger Link Pin
15732	Rear Sight Windage Screw	15460	Trigger Link Roller
		26800	Trigger Link Assembly (includes Trigger, Trigger Link, Trigger Link Pin, Trigger Link Roller, Sear Block Assembly) (not shown)
		24483	Trigger Pin

DELIVERIES ARE F.O.B. ILION, N. Y.

INSTRUCTIONS FOR ORDERING PARTS**(Please read carefully)**

When ordering parts — please order by part number and part name. Give also model name and number of gun, serial number (if any), and state caliber or gauge. Please identify from the component parts, picture or section view.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

Please do not ship sample parts to Firearms Factory unless it is impossible to identify from the Parts List or Instruction Folder. See shipping instructions concerning FACTORY SERVICE.

We will furnish parts for discontinued models as long as the supply is available. We are unable to supply parts for models or repair guns not listed in the Parts List.

The sale of the following parts and certain other parts is restricted because special tools and gauges are required during assembly to make sure the firearms will operate properly.

• Barrel • Breech Block or Bolt • Receiver

All parts will be shipped as ordered, but since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders.

Please send Part Orders direct to:

REMINGTON ARMS COMPANY, INC.

PARTS DEPT.

ARMS SERVICE DIVISION

Ilion, New York

INSTRUCTIONS FOR FACTORY SERVICE

**Please read carefully before making
shipment to the Firearms Plant at
ILION, NEW YORK**

Please do not ship gun in a gun case, or special container that must be returned from the factory. The return of your gun or parts will be greatly speeded if properly packaged in a throw-away carton.

All shipments should have forwarding and return address clearly marked on gun package as well as on attached letter.

To further improve service — please attach complete letter of information securely on outside of each package returned to the factory for repairs.

Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to the factory with the gun shipment.

Give full details of the contents of the shipment — state whether complete gun or part. List model name and model number, serial number (if any), and caliber or gauge.

Give full condition of contents — stock and fore-end damage (if any), metal damage (if any), barrel bent or damaged (if any), parts missing, etc. A full description will enable us to more accurately list the needed repairs.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

THEN — to avoid all possible delay in starting work on your gun or parts, please include in your first order or letter the trouble you wish corrected, any changes you desire, or parts you wish replaced.

If an estimate is required before the work is started, please advise. Otherwise we will proceed with the necessary work and send a statement of the cost to you. In this manner we can reshipe your gun or parts at the earliest possible date.

Unless you specify otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages.

Remington gun parts are not interchangeable with those of any other make of gun. For this reason the Remington Arms Company, Inc. cannot service any gun not of our manufacture.

We will make repairs on discontinued models as long as the supply of parts is available. However, we cannot make repairs for models which are not listed in the Parts List.

IMPORTANT: Before packaging guns for return to factory, ALL LIVE AMMUNITION SHOULD BE REMOVED.

If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail, Express, Motor Transport, or Freight.

Please send repairs direct to:

REMINGTON ARMS COMPANY, INC.

ARMS SERVICE DIVISION

Ilion, New York

SECTIONAL VIEW**MODEL
XP-100****REPLACEMENT PARTS** — IDENTIFY COMPONENTS BY PART NUMBER FROM VIEW BELOW

Send all guns for factory service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
Arms Service Division
Ilion, New York

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
Bridgeport 2, Connecticut

REPLACEMENT PARTS

When ordering parts specify model, caliber, part name and serial number of the gun.

NOTE: The sale of barrel assemblies and breech bolts is restricted. When these parts are needed for replacement, the arm must be returned to the factory as the use of

special tools and gauges is required to assure proper operation. All other parts will be shipped as ordered but, since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.

CF 35



BOLT ACTION PISTOL

SINGLE SHOT • AUTOMATIC EJECTION

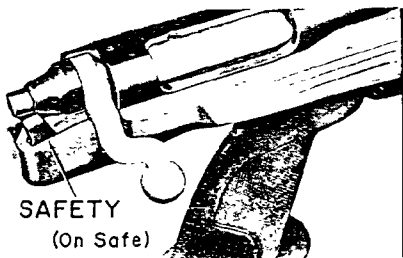
221 Rem. "Fireball"

MODEL
XP-100

CENTER FIRE • HIGH POWER CALIBER

INSTRUCTION FOLDER and PARTS LIST

Fig. 1



The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and to ON SAFE position. Side lever to right rear of receiver. With safety trigger cannot be pulled to "fire" ON SAFE, bolt handle cannot be

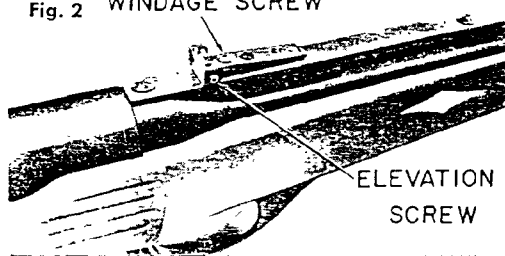
FIRE — Rotate safety with thumb to. Trigger can be pulled to fire pistol raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

Fig. 2 WINDAGE SCREW



SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

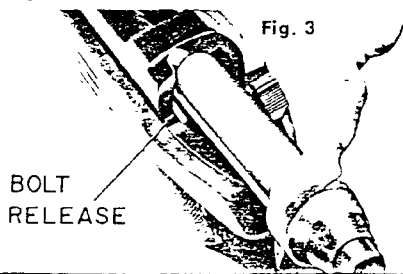


Fig. 3

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

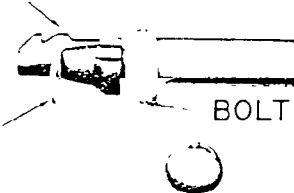
EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

Fig. 4

FIRING PIN HEAD

COIN

BOLT



REMINGTON ARMS COMPANY, INC.
 ILION, NEW YORK, U.S.A.

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn

CF 33

Remington

PRESALE R 0122912

**BOLT ACTION PISTOL
SINGLE SHOT • AUTOMATIC EJECTION****MODEL
XP-100****221 Rem. "Fireball"
CENTER FIRE • HIGH POWER CALIBER****INSTRUCTION FOLDER and PARTS LIST****Fig. 1**

The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

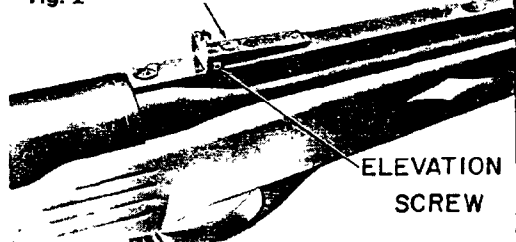
SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "fire" pistol. When safety is ON SAFE, bolt handle cannot be raised to open action.

FIRE — Rotate safety with thumb to front stop position. Trigger can be pulled to fire pistol. Bolt handle can be raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any obstruction.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

Fig. 2 WINDAGE SCREW

SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

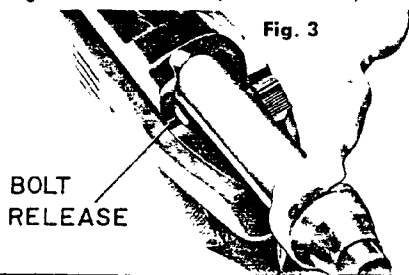
RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

**Fig. 3**

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

Fig. 4**FIRING PIN HEAD****REMINGTON ARMS COMPANY, INC.****ILION, NEW YORK, U.S.A.**

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

CF 33

**MODEL
XP-100**

**Bolt Action Pistol
SINGLE SHOT**

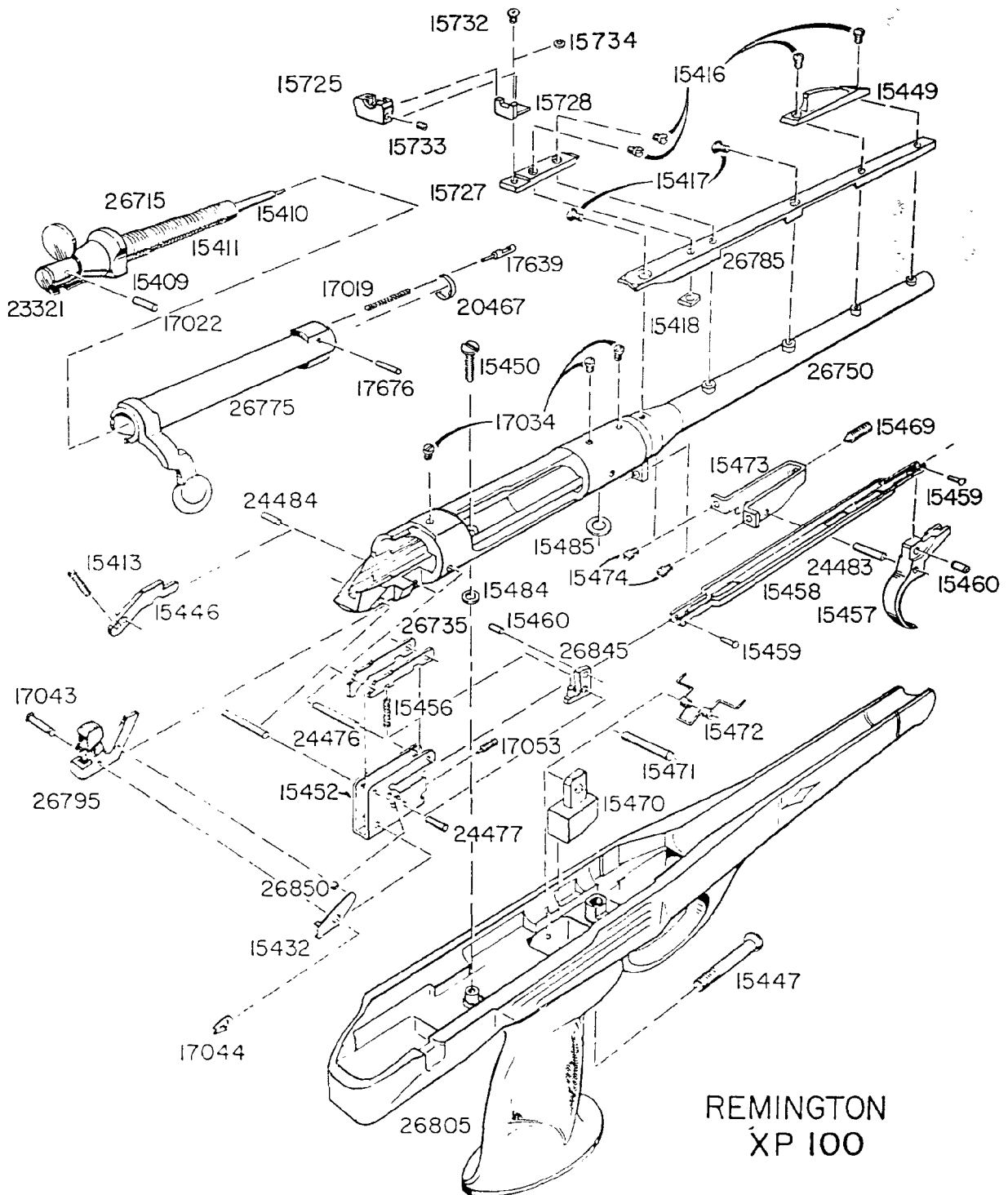
ALWAYS ORDER BY PART NAME AND PART NUMBER

Part No.	NAME OF PART	Part No.	NAME OF PART
26750	Barrel Assembly, 221 Rem. "Fireball" (includes Barrel, Barrel Bracket, Barrel Stud (4), Receiver)	15778	Rear Sight Wrench (not shown)
26775	Bolt Assembly, 221 Rem. "Fireball" (includes Bolt Body Assembly and Bolt Handle)	17034	Receiver Plug Screw
26770	Bolt Final Assembly, 221 Rem. "Fireball" (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Firing Pin Assembly) (not shown)	26785	Rib
15409	Bolt Plug	15417	Rib Screw
15446	Bolt Stop	26795	Safety Assembly (includes Safety, Safety Thumbpiece)
24484	Bolt Stop Pin	26850	Safety Detent Ball
15413	Bolt Stop Spring	15432	Safety Detent Spring
17639	Ejector	17043	Safety Pivot Pin
17019	Ejector Spring	17044	Safety Snap Washer
17676	Ejector Pin	26735	Sear and Safety Cam Assembly (includes Safety Cam, Sear)
20467	Extractor	26845	Sear Block Assembly (includes Sear Block, Sear Block Stud)
15410	Firing Pin	24477	Sear Block Pin
26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	15456	Sear Block Spring
17022	Firing Pin Cross Pin	17053	Sear Block Stop Screw
23321	Firing Pin Head	15452	Sear Housing
15447	Forward Receiver Screw	24476	Sear Pin
15485	Forward Receiver Screw Washer	15416	Sight Screw
15449	Front Sight	26805	Stock Assembly (includes Fore-end Tip, Fore-end Tip Spacer, Fore-end Diamond, Forward Receiver Screw Escutcheon, Grip Diamond, Rear Receiver Screw Escutcheon, Stock Half, Left; Stock Half, Right; Trigger Guard)
15411	Main Spring	15457	Trigger
15450	Rear Receiver Screw	15469	Trigger Adjusting Screw
15484	Rear Receiver Screw Washer	15470	Trigger Balance
26840	Rear Sight Assembly (includes Rear Sight Base, Rear Sight Elevation Screw, Rear Sight Eye-piece, Rear Sight Leaf, Rear Sight Windage Screw) (not shown)	15471	Trigger Balance Pin
15727	Rear Sight Base	15472	Trigger Balance Spring
15733	Rear Sight Elevation Screw	15473	Trigger Housing
15725	Rear Sight Eye-piece	15474	Trigger Housing Screw
15728	Rear Sight Leaf	15458	Trigger Link
15418	Rear Sight Nut	15459	Trigger Link Pin
15732	Rear Sight Windage Screw	15460	Trigger Link Roller
		26800	Trigger Link Assembly (includes Trigger, Trigger Link, Trigger Link Pin, Trigger Link Roller, Sear Block Assembly) (not shown)
		24483	Trigger Pin

DELIVERIES ARE F.O.B. ILION, N. Y.

SECTIONAL VIEW**MODEL
XP-100**

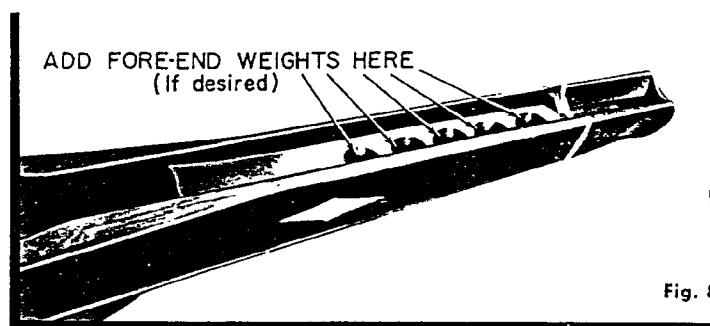
REPLACEMENT PARTS — IDENTIFY COMPONENTS BY PART NUMBER FROM VIEW BELOW

**REMINGTON
XP 100**

Send all inquiries for technical service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
 Arms Service Division
 Ilion, New York

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
 Bridgeport 2, Connecticut

FORE-END WEIGHTS (Fig. 5) — Five (5) Cavities are provided inside fore-end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights. **To Remove Barrel and Action:** Push Safety ON SAFE. Remove bolt. Unscrew and disassemble forward and rear receiver screws. See sectional view. Lift barrel and action from stock. Insert weights and reassemble barrel and action to stock. Make certain nylon receiver screw washers (forward and rear) are in correct position against receiver during reassembly. Also that trigger balance remains centrally positioned on its pin in stock. This will enable top of balance to re-enter slot in trigger link easily. Make certain both receiver screws properly re-enter metal screw escutcheons in stock and tighten action securely.



INSTRUCTIONS FOR ORDERING PARTS

(Please read carefully)

When ordering parts — please order by part number and part name. Give also model name and number of gun, serial number (if any), and state caliber or gauge. Please identify from the component parts, picture or section view.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

Please do not ship sample parts to Firearms Factory unless it is impossible to identify from the Parts List or Instruction Folder. See shipping instructions concerning FACTORY SERVICE.

We will furnish parts for discontinued models as long as the supply is available. We are unable to supply parts for models or repair guns not listed in the Parts List.

The sale of the following parts and certain other parts is restricted because special tools and gauges are required during assembly to make sure the firearms will operate properly.

- Barrel • Breech Block or Bolt • Receiver

All parts will be shipped as ordered, but since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders.

Please send Part Orders direct to:

REMINGTON ARMS COMPANY, INC.

PARTS DEPT.

ARMS SERVICE DIVISION

Ilion, New York

INSTRUCTIONS FOR FACTORY SERVICE

Please read carefully before making
shipment to the Firearms Plant at
ILION, NEW YORK

All shipments should have forwarding and return address clearly marked on gun package as well as on attached letter.

To further improve service — please attach complete letter of information securely on outside of each package returned to the factory for repairs.

Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to the factory with the gun shipment.

Give full details of the contents of the shipment — state whether complete gun or part. List model name and model number, serial number (if any), and caliber or gauge.

Give full condition of contents — stock and fore-end damage (if any), metal damage (if any), barrel bent or damaged (if any), parts missing, etc. A full description will enable us to more accurately list the needed repairs.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

THEN — to avoid all possible delay in starting work on your gun or parts, please include in your first order or letter the trouble you wish corrected, any changes you desire, or parts you wish replaced.

If an estimate is required before the work is started, please advise. Otherwise we will proceed with the necessary work and send a statement of the cost to you. In this manner we can reship your gun or parts at the earliest possible date.

Unless you specify otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages.

Remington gun parts are not interchangeable with those of any other make of gun. For this reason the Remington Arms Company, Inc. cannot service any gun not of our manufacture.

We will make repairs on discontinued models as long as the supply of parts is available. However, we cannot make repairs for models which are not listed in the Parts List.

IMPORTANT: When returning pistols for Factory Service, shipment by express is recommended. This will avoid any involvement with postal regulations.

CAUTION: Before packaging guns for return to factory, ALL LIVE AMMUNITION SHOULD BE REMOVED.

If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail, Express, Motor Transport, or Freight.

Please send repairs direct to

REMINGTON ARMS COMPANY, INC.

ARMS SERVICE DIVISION

Ilion, New York



BOLT ACTION PISTOL
SINGLE SHOT • AUTOMATIC EJECTION
221 Rem. "Fireball"

MODEL
XP-100

CENTER FIRE • HIGH POWER CALIBER

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1



The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "ON SAFE, bolt handle cannot

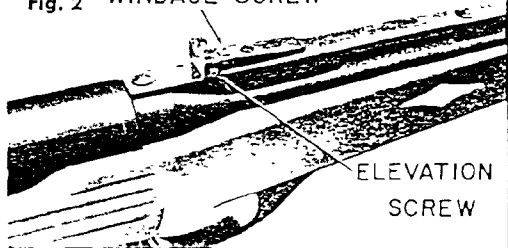
FIRE — Rotate safety with the Trigger can be pulled to fire raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, etc.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge then can easily be removed from pistol.

Fig. 2 WINDAGE SCREW



SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

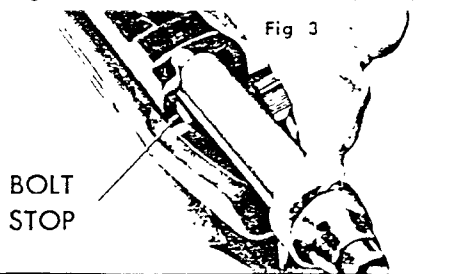


Fig. 3

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

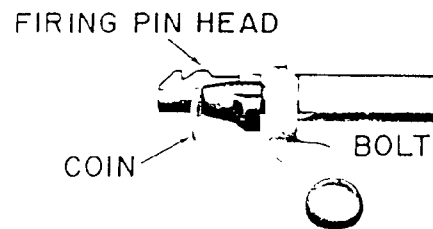
TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to insulate metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

Fig. 4



REMINGTON ARMS COMPANY, INC.
ILION, NEW YORK, U.S.A.

Fireball is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

CF 33

Remington

PRESALE R 0122917

BOLT ACTION PISTOL**MODEL****SINGLE SHOT • AUTOMATIC EJECTION****XP-100****221 Rem. "Fireball"****CENTER FIRE • HIGH POWER CALIBER**

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1

The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

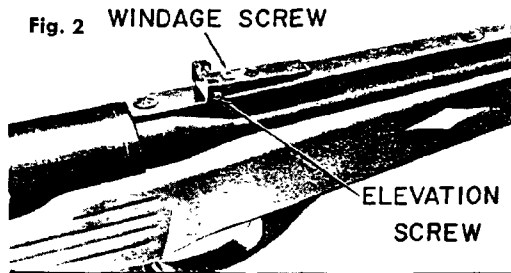
SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "fire" pistol. When safety is ON SAFE, bolt handle cannot be raised to open action.

FIRE — Rotate safety with thumb to front stop position. Trigger can be pulled to fire pistol. Bolt handle can be raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any obstruction.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

Fig. 2 WINDAGE SCREW

SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

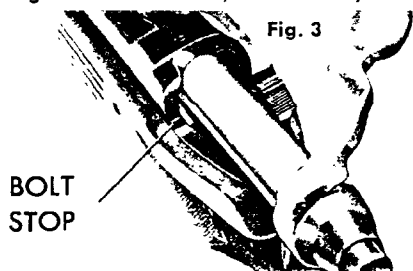
RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

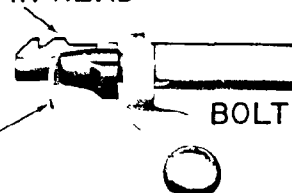
CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

Fig. 3

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

Fig. 4**FIRING PIN HEAD****COIN****BOLT**

TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

REMINGTON ARMS COMPANY, INC.**ILION, NEW YORK, U.S.A.**

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

CF 33

**MODEL
XP-100**

**Bolt Action Pistol
SINGLE SHOT**

ALWAYS ORDER BY PART NAME AND PART NUMBER

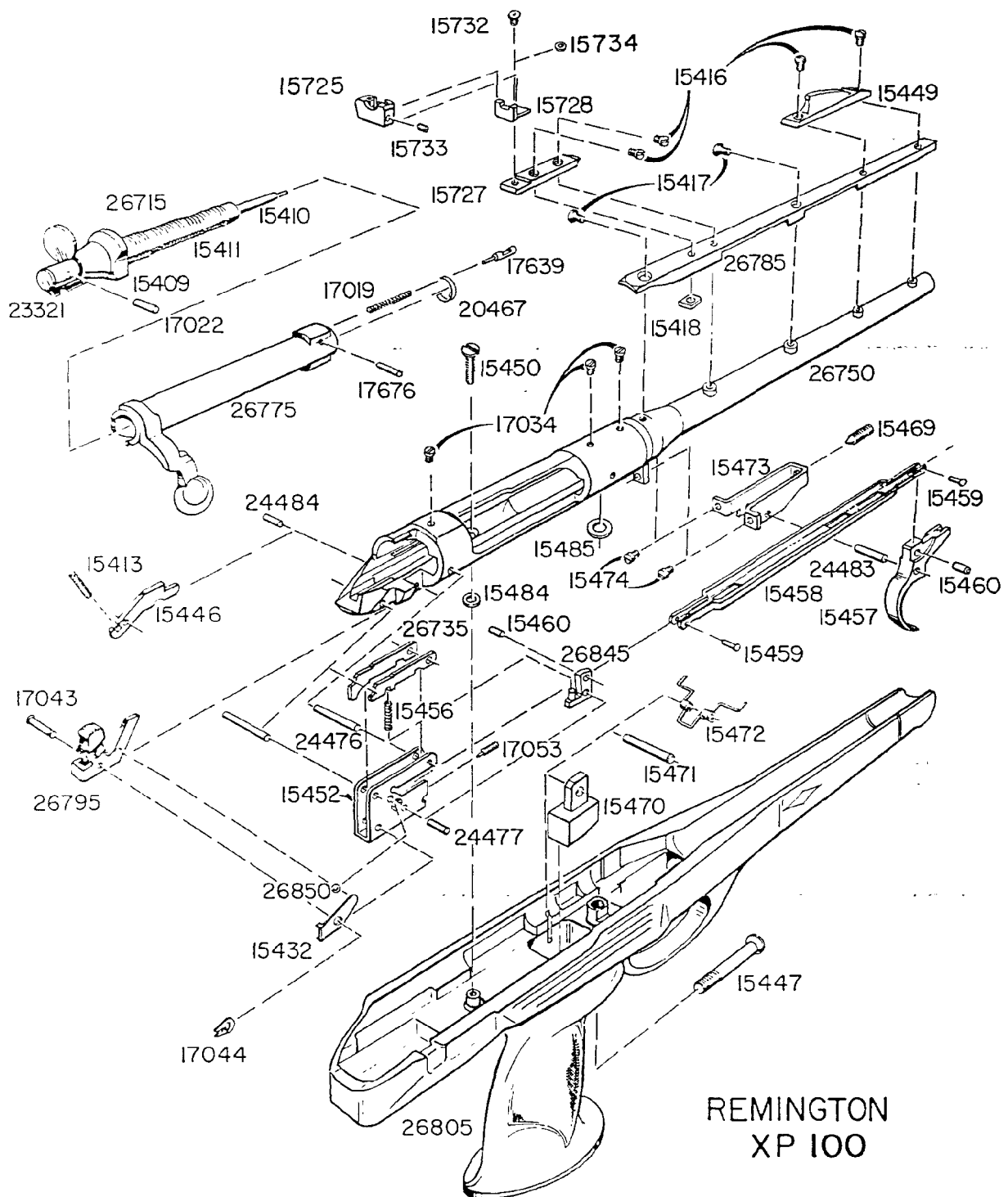
Part No.	NAME OF PART	List Price	Part No.	NAME OF PART	List Price
26750	Barrel Assembly, 221 Rem. "Fireball" (includes Barrel, Barrel Bracket, Barrel Stud (4), Receiver)		15778	Rear Sight Wrench (not shown)	\$.25
26775	Bolt Assembly, 221 Rem. "Fireball" (includes Bolt Body Assembly and Bolt Handle)		17034	Receiver Plug Screw25
26770	Bolt Final Assembly, 221 Rem. "Fireball" (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Firing Pin Assembly) (not shown)		26785	Rib	1.50
			15417	Rib Screw25
15409	Bolt Plug	\$ 2.40	26795	Safety Assembly (includes Safety, Safety Thumbpiece)	1.20
15446	Bolt Stop50	26850	Safety Detent Ball25
24484	Bolt Stop Pin25	15432	Safety Detent Spring35
15413	Bolt Stop Spring25	17043	Safety Pivot Pin25
17639	Ejector55	17044	Safety Snap Washer25
17019	Ejector Spring25	26735	Sear and Safety Cam Assembly (includes Safety Cam, Sear)	2.40
17676	Ejector Pin25	26845	Sear Block Assembly (includes Sear Block, Sear Block Stud)	2.10
20467	Extractor	1.65	24477	Sear Block Pin25
15410	Firing Pin	2.70	15456	Sear Block Spring25
26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	7.50	17053	Sear Block Stop Screw25
17022	Firing Pin Cross Pin25	15452	Sear Housing	1.80
23321	Firing Pin Head	1.00	24476	Sear Pin25
15447	Forward Receiver Screw50	15416	Sight Screw25
15485	Forward Receiver Screw Washer25	26805	Stock Assembly (includes Fore-end Tip, Fore-end Tip Spacer, Fore-end Diamond, Forward Receiver Screw Escutcheon, Grip Diamond, Rear Receiver Screw, Escutcheon, Stock Half, Left; Stock Half, Right; Trigger Guard)	10.50
15449	Front Sight90	15457	Trigger90
15411	Main Spring35	15469	Trigger Adjusting Screw25
15450	Rear Receiver Screw35	15470	Trigger Balance50
15484	Rear Receiver Screw Washer25	15471	Trigger Balance Pin50
26840	Rear Sight Assembly (includes Rear Sight Base, Rear Sight Elevation Screw, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw) (not shown)	3.00	15472	Trigger Balance Spring35
15727	Rear Sight Base50	15473	Trigger Housing	2.10
15733	Rear Sight Elevation Screw35	15474	Trigger Housing Screw25
15725	Rear Sight Eyepiece	1.50	15458	Trigger Link90
15728	Rear Sight Leaf60	15459	Trigger Link Pin35
15418	Rear Sight Nut25	15460	Trigger Link Roller25
15732	Rear Sight Windage Screw35	26800	Trigger Link Assembly (includes Trigger, Trigger Link, Trigger Link Pin, Trigger Link Roller, Sear Block Assembly) (not shown)	5.25
			24483	Trigger Pin25

PRICES SUBJECT TO CHANGE WITHOUT NOTICE

DELIVERIES ARE F.O.B. ILION, N. Y.

SECTIONAL VIEW

REPLACEMENT PARTS — IDENTIFY COMPONENTS BY PART NUMBER FROM VIEW BELOW

**MODEL
XP-100****REMINGTON
XP 100**

Send all guns for factory service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
 Arms Service Division
 Ilion, New York

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
 Bridgeport 2, Connecticut

FORE-END WEIGHTS (Fig. 5) Five (5) Cavities are provided inside fore-end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights. **To Remove Barrel and Action:** Remove bolt. Unscrew and disassemble forward and rear receiver screws. See sectional view. Lift barrel and action from stock. Insert weights and reassemble barrel and action to stock. Make certain nylon receiver screw washers (forward and rear) are in correct position against receiver during reassembly. Also that trigger balance remains centrally positioned on its pin in stock. This will enable top of balance to re-enter slot in trigger link easily. Make certain both receiver screws properly re-enter metal screw escutcheons in stock and tighten action securely.

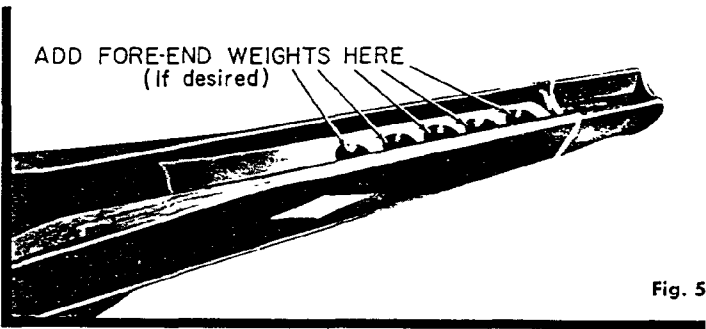


Fig. 5

INSTRUCTIONS FOR ORDERING PARTS

(Please read carefully)

When ordering parts — please order by part number and part name. Give also model name and number of gun, serial number (if any), and state caliber or gauge. Please identify from the component parts, picture or section view.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

Please do not ship sample parts to Firearms Factory unless it is impossible to identify from the Parts List or Instruction Folder. See shipping instructions concerning FACTORY SERVICE.

We will furnish parts for discontinued models as long as the supply is available. We are unable to supply parts for models or repair guns not listed in Complete Line Parts List.

The sale of the following parts and certain other parts is restricted because special tools and gauges are required during assembly to make sure the firearms will operate properly.

- Barrel • Breech Block or Bolt • Receiver

All parts will be shipped as ordered, but since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders.

Please send Part Orders direct to:

REMINGTON ARMS COMPANY, INC.
PARTS DEPT.
ARMS SERVICE DIVISION
Ilion, New York

INSTRUCTIONS FOR FACTORY SERVICE

Please read carefully before making
shipment to the Firearms Plant at
ILION, NEW YORK

Please package carefully when shipping firearms to factory. Use plenty of cushioning material to prevent movement of gun or gun parts in package during transit.

All shipments should have forwarding and return address clearly marked on gun package as well as on attached letter.

To further improve service — please attach complete letter of information securely on outside of each package returned to the factory for repairs.

Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to the factory with the gun shipment.

Give full details of the contents of the shipment — state whether complete gun or part. List model name and model number, serial number (if any), and caliber or gauge.

Give full condition of contents — stock and fore-end damage (if any), metal damage (if any), barrel bent or damaged (if any), parts missing, etc. A full description will enable us to more accurately list the needed repairs.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

THEN — to avoid all possible delay in starting work on your gun or parts, please include in your first order or letter the trouble

you wish corrected, any changes you desire, or parts you wish replaced.

If an estimate is required before the work is started, please advise. Otherwise we will proceed with the necessary work and send a statement of the cost to you. In this manner we can reship your gun or parts at the earliest possible date.

Unless you specify otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages.

Remington gun parts are not interchangeable with those of any other make of gun. For this reason the Remington Arms Company, Inc. cannot service any gun not of our manufacture.

We will make repairs on discontinued models as long as the supply of parts is available. However, we cannot make repairs for models which are not listed in the Complete Line Parts List.

IMPORTANT: When returning pistols for Factory Service, shipment by express is recommended. This will avoid any involvement with postal regulations.

CAUTION: Before packaging guns for return to factory, ALL LIVE AMMUNITION SHOULD BE REMOVED.

If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail, Express, Motor Transport, or Freight.

Please send repairs direct to

REMINGTON ARMS COMPANY, INC.
ARMS SERVICE DIVISION
Ilion, New York



BOLT ACTION PISTOL
SINGLE SHOT • AUTOMATIC EJECTION
221 Rem. "Fireball"

MODEL
XP-100

CENTER FIRE • HIGH POWER CALIBER

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1



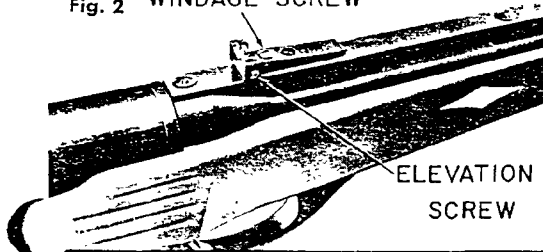
The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in ON position, trigger cannot be pulled. When safety is rotated to open action.

Fill — Front stop position. Bolt handle can be

Caution — Before firing make sure barrel is clear, f
TO LOAD — Raise bolt handle to unlock bolt. Pull i
upon loading incline in receiver, close bolt to chambe
TO UNLOAD — Raise bolt handle and open action car
cartridge then can easily be removed from pistol.

Fig. 2 WINDAGE SCREW



SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

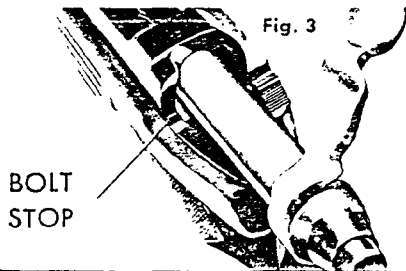


Fig. 3

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

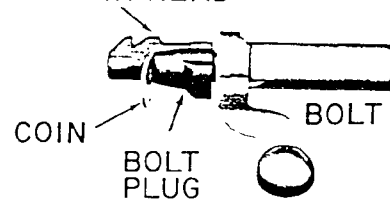
TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

Fig. 4

FIRING PIN HEAD



REMINGTON ARMS COMPANY, INC.
ILION, NEW YORK, U.S.A.

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

CF 33

Remington-UMC R 0122922

SINGLE SHOT • AUTOMATIC EJECTION

221 Rem. "Fireball"

MODEL
XP-100



CENTER FIRE • HIGH POWER CALIBER

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1



The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "fire" pistol. When safety is ON SAFE, bolt handle cannot be raised to open action.

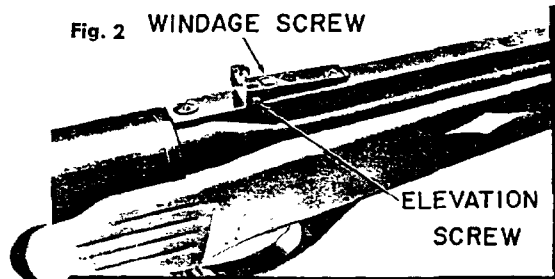
FIRE — Rotate safety with thumb to front stop position. Trigger can be pulled to fire pistol. Bolt handle can be raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any obstruction.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

Fig. 2 WINDAGE SCREW



SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten

in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

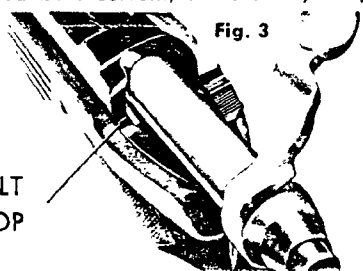


Fig. 3

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

Fig. 4

FIRING PIN HEAD



TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

REMINGTON ARMS COMPANY, INC.

ILION, NEW YORK, U.S.A.

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

CF 33

**MODEL
XP-100**

**Bolt Action Pistol
SINGLE SHOT**

ALWAYS ORDER BY PART NAME AND PART NUMBER

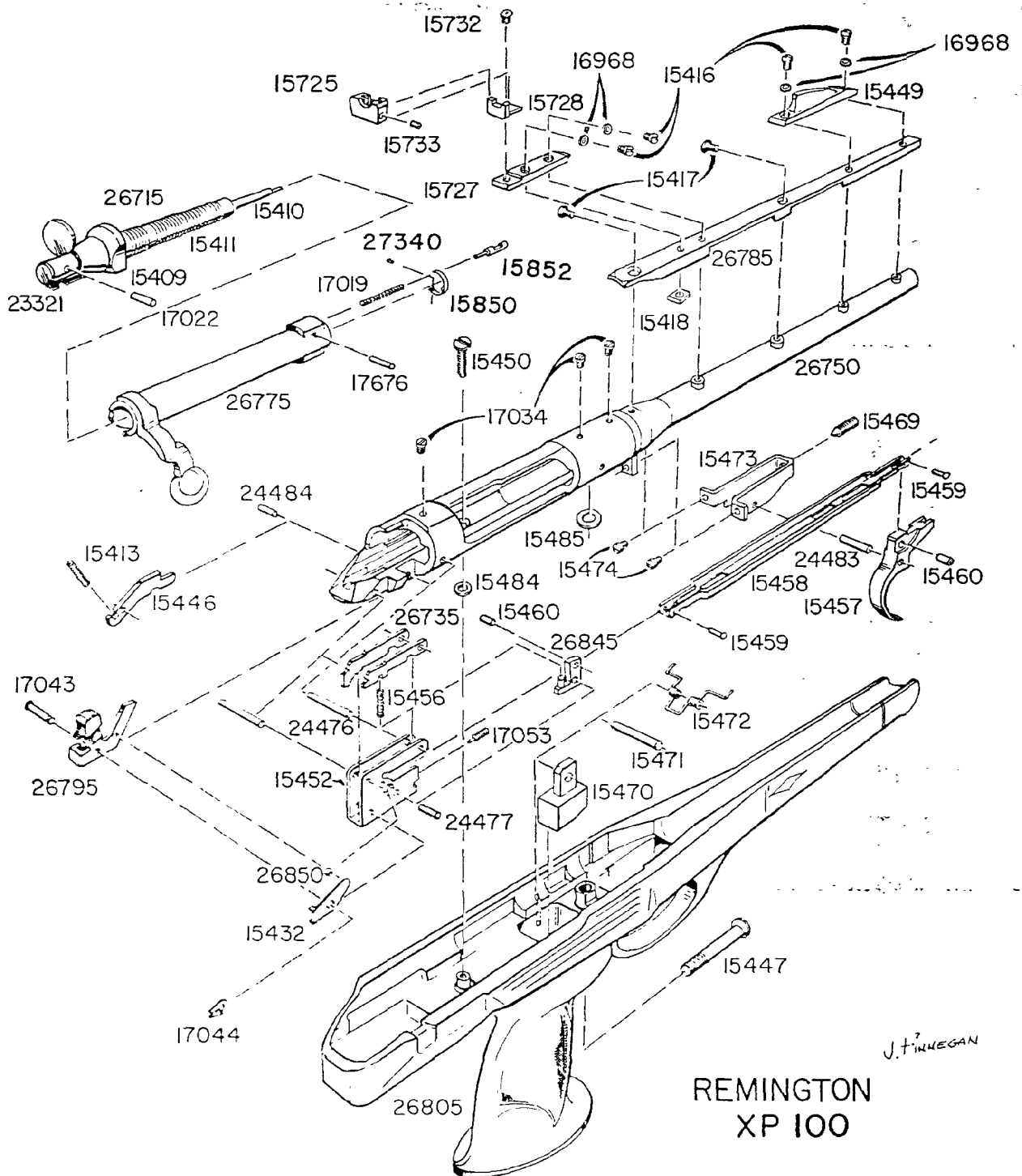
Part No.	NAME OF PART	List Price	Part No.	NAME OF PART	List Price
26750	Barrel Assembly, 221 Rem. "Fireball" (includes Barrel, Barrel Bracket, Barrel Stud (4), Receiver)	Price on Application	15778	Rear Sight Wrench (not shown)	\$.25
26775	Bolt Assembly, 221 Rem. "Fireball" (includes Bolt Body Assembly and Bolt Handle)		17034	Receiver Plug Screw25
26770	Bolt Final Assembly, 221 Rem. "Fireball" (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Firing Pin Assembly) (not shown)		26785	Rib	1.50
15409	Bolt Plug		15417	Rib Screw25
15446	Bolt Stop50	26795	Safety Assembly (includes Safety, Safety Thumbpiece)	1.20
24484	Bolt Stop Pin25	26850	Safety Detent Ball25
15413	Bolt Stop Spring25	15432	Safety Detent Spring35
15852	Ejector55	17043	Safety Pivot Pin25
17019	Ejector Spring25	17044	Safety Snap Washer25
17676	Ejector Pin25	26735	Sear and Safety Cam Assembly (includes Safety Cam, Sear)	2.40
15850	Extractor	1.65	26845	Sear Block Assembly (includes Sear Block, Sear Block Stud)	2.10
27340	Extractor Rivet25	24477	Sear Block Pin25
15410	Firing Pin	2.70	15456	Sear Block Spring25
26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	7.50	17053	Sear Block Stop Screw25
17022	Firing Pin Cross Pin25	15452	Sear Housing	1.80
23321	Firing Pin Head	1.00	24476	Sear Pin25
15447	Forward Receiver Screw50	15416	Sight Screw25
15485	Forward Receiver Screw Washer25	16968	Sight Washer25
15449	Front Sight90	26805	Stock Assembly (includes Fore-end Tip, Fore-end Tip Spacer, Fore-end Diamond, Forward Receiver Screw, Escutcheon, Grip Diamond, Rear Receiver Screw, Escutcheon, Stock Half, Left; Stock Half, Right; Trigger Guard)	10.50
15411	Main Spring35	15457	Trigger90
15450	Rear Receiver Screw35	15469	Trigger Adjusting Screw25
15484	Rear Receiver Screw Washer25	15470	Trigger Balance50
26840	Rear Sight Assembly (includes Rear Sight Base, Rear Sight Elevation Screw, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw) (not shown)	3.00	15471	Trigger Balance Pin50
15727	Rear Sight Base50	15472	Trigger Balance Spring35
15733	Rear Sight Elevation Screw35	15473	Trigger Housing	2.10
15725	Rear Sight Eyepiece	1.50	15474	Trigger Housing Screw25
15728	Rear Sight Leaf60	15458	Trigger Link90
15418	Rear Sight Nut25	15459	Trigger Link Pin35
15732	Rear Sight Windage Screw35	15460	Trigger Link Roller25
			26800	Trigger Link Assembly (includes Trigger, Trigger Link, Trigger Link Pin, Trigger Link Roller, Sear Block Assembly) (not shown)	5.25
			24483	Trigger Pin25

PRICES SUBJECT TO CHANGE WITHOUT NOTICE

DELIVERIES ARE F.O.B. ILION, N. Y.

SECTIONAL VIEW**MODEL
XP-100**

REPLACEMENT PARTS—IDENTIFY COMPONENTS BY PART NUMBER FROM VIEW BELOW



Send all requests for parts, service and information on service and parts to
REMINGTON ARMS COMPANY, INC.
 Arms Service Division
 Ilion, New York

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
 Bridgeport 2, Connecticut

FORE-END WEIGHTS (Fig. 5) The 137 Cavities are provided inside fore-end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights. **To Remove Barrel and Action:** Remove bolt. Unscrew and disassemble forward and rear receiver screws. See sectional view. Lift barrel and action from stock. Insert weights and reassemble barrel and action to stock. Make certain nylon receiver screw washers (forward and rear) are in correct position against receiver during reassembly. Also that trigger balance remains centrally positioned on its pin in stock. This will enable top of balance to re-enter slot in trigger link easily. Make certain both receiver screws properly re-enter metal screw escutcheons in stock and tighten action securely.

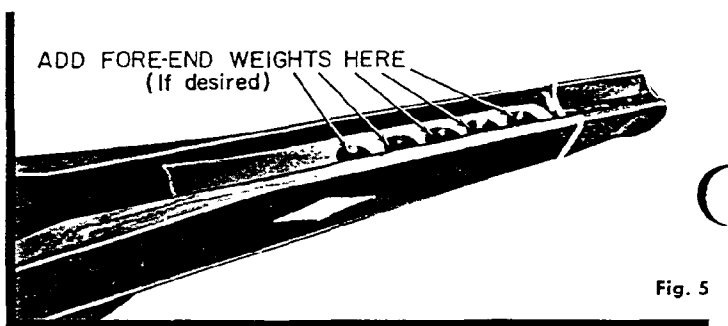


Fig. 5

INSTRUCTIONS FOR ORDERING PARTS

(Please read carefully)

When ordering parts — please order by part number and part name. Give also model name and number of gun, serial number (if any), and state caliber or gauge. Please identify from the component parts, picture or section view.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

Please do not ship sample parts to Firearms Factory unless it is impossible to identify from the Parts List or Instruction Folder. See shipping instructions concerning **FACTORY SERVICE**.

We will furnish parts for discontinued models as long as the supply is available. We are unable to supply parts for models or repair guns not listed in Complete Line Parts List.

The sale of the following parts and certain other parts is restricted because special tools and gauges are required during assembly to make sure the firearms will operate properly.

- Barrel • Breech Block or Bolt • Receiver

All parts will be shipped as ordered, but since they are made to close dimensions, the particular part may require slight adjustment or fitting to assure proper functioning of the arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders.

Please send Part Orders direct to:

REMINGTON ARMS COMPANY, INC.
PARTS DEPT.
ARMS SERVICE DIVISION
Ilion, New York

INSTRUCTIONS FOR FACTORY SERVICE

Please read carefully before making
shipment to the Firearms Plant at
ILION, NEW YORK

Please package carefully when shipping firearms to factory. Use plenty of cushioning material to prevent movement of gun or gun parts in package during transit.

All shipments should have forwarding and return address clearly marked on gun package as well as on attached letter.

To further improve service — please attach complete letter of information securely on outside of each package returned to the factory for repairs.

Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to the factory with the gun shipment.

Give full details of the contents of the shipment — state whether complete gun or part. List model name and model number, serial number (if any), and caliber or gauge.

Give full condition of contents — stock and fore-end damage (if any), metal damage (if any), barrel bent or damaged (if any), parts missing, etc. A full description will enable us to more accurately list the needed repairs.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — this delays service.

THEN — to avoid all possible delay in starting work on your gun or parts, please include in your first order or letter the trouble

you wish corrected, any changes you desire, or parts you wish replaced.

If an estimate is required before the work is started, please advise. Otherwise we will proceed with the necessary work and send a statement of the cost to you. In this manner we can reship your gun or parts at the earliest possible date.

Unless you specify otherwise, shipments will be made by way of Parcel Post on small packages, Express on larger packages.

Remington gun parts are not interchangeable with those of any other make of gun. For this reason the Remington Arms Company, Inc. cannot service any gun not of our manufacture.

We will make repairs on discontinued models as long as the supply of parts is available. However, we cannot make repairs for models which are not listed in the Complete Line Parts List.

IMPORTANT: When returning pistols for Factory Service, shipment by express is recommended. This will avoid any involvement with postal regulations.

CAUTION: Before packaging guns for return to factory, ALL LIVE AMMUNITION SHOULD BE REMOVED.

If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail, Express, Motor Transport, or Freight.

Please send repairs direct to:

REMINGTON ARMS COMPANY, INC.
ARMS SERVICE DIVISION
Ilion, New York



BOLT ACTION PISTOL
SINGLE SHOT • AUTOMATIC EJECTION
221 Rem. "Fireball"

MODEL
XP-100

CENTER FIRE • HIGH POWER CALIBER

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1



The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

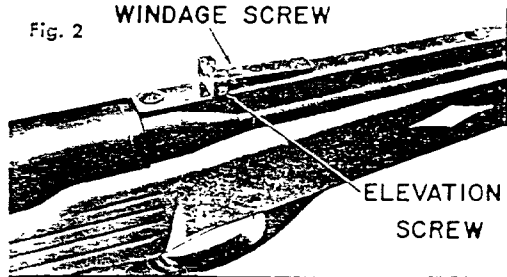
SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position trigger cannot be pulled to fire. ON SAFE, bolt handle cannot be raised to open action.

FIRE — Rotate safety with the trigger can be pulled to fire raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or dirt.
TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to closed position.
TO UNLOAD — Raise bolt handle and open action carefully. This will extract and eject cartridge then can easily be removed from pistol.

Fig. 2

WINDAGE SCREW



ELEVATION SCREW

SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

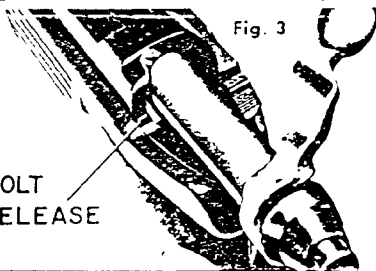


Fig. 3

BOLT RELEASE

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

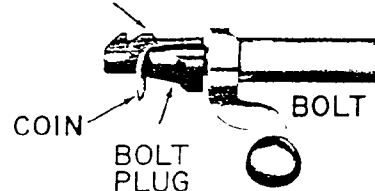
TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

Fig. 4

FIRING PIN HEAD



REMINGTON ARMS COMPANY, INC.
 ILION, NEW YORK, U.S.A.

Fireball is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn.

Remington**CENTER FIRE • HIGH POWER CALIBER****BOLT ACTION PISTOL
SINGLE SHOT • AUTOMATIC EJECTION****221 Rem. "Fireball"****MODEL
XP-100**

INSTRUCTION FOLDER and PARTS PRICE LIST

Fig. 1



The Remington XP-100 is a single shot high power pistol for extreme accuracy and long range shooting.

SAFETY (Fig. 1) — Close bolt and rotate safety rearward to ON SAFE position. Side lever type safety is located at right rear of receiver. With safety in rear stop position, trigger cannot be pulled to "fire" pistol. When safety is ON SAFE, bolt handle cannot be raised to open action.

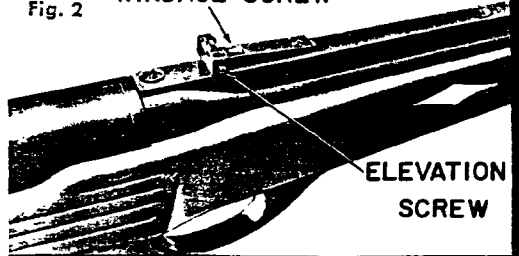
FIRE — Rotate safety with thumb to front stop position. Trigger can be pulled to fire pistol. Bolt handle can be raised to open action.

Caution — Before firing make sure barrel is clear, free of heavy oil, grease, or any obstruction.

TO LOAD — Raise bolt handle to unlock bolt. Pull bolt handle back to open action. Load single cartridge upon loading incline in receiver, close bolt to chamber cartridge, lower bolt handle to lock action closed.

TO UNLOAD — Raise bolt handle and open action carefully. This will extract cartridge from barrel, live cartridge then can easily be removed from pistol.

Fig. 2

WINDAGE SCREW**ELEVATION
SCREW**

SIGHT ADJUSTMENT — The Remington XP-100 has a ventilated rib on barrel. The front sight is positive "fixed" design and not adjustable. Rear sight adjusts for both windage and elevation or range. See Fig. 2. A small sight wrench is supplied with each pistol.

WINDAGE — Turn windage screw to loosen sight leaf. Move sight leaf to right or left, tighten in desired position with windage screw. Moving sight leaf to right will move bullet impact at target to right. Moving to left will move bullet impact to left.

RANGE — Turn elevation screw to loosen rear sight eyepiece on sight leaf. Raise or lower eyepiece and tighten in desired position with elevation screw. Raising eyepiece will increase range or raise bullet impact at target. With eyepiece lowered range will lessen or range decrease.

RECEIVER SIGHTING — The receiver is drilled and tapped for telescope mounts. Receiver plug screws can be removed when mount is assembled on receiver.

PISTOL CLEANING AND CARE

To make cleaning of barrel or bolt easier — remove bolt from pistol (Fig. 3). Removal of stock is not recommended unless fore-end weights or replacement of fire control parts is necessary. See Sectional View.

TRIGGER ADJUSTMENT — Is sealed at factory. This adjustment provides the proper amount of trigger pull and weight.

CLEANING OF BARREL — Use lightly oiled, soft cloth. Clean from breech to muzzle. Scrub barrel bore and cartridge chamber in barrel with a good bore solvent, if necessary. Wipe dry and re-oil bore and chamber very lightly.

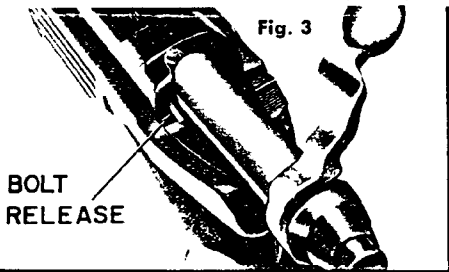


Fig. 3

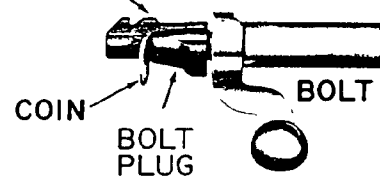
**BOLT
RELEASE**

CLEANING OF BOLT — Remove from pistol by pressing bolt stop (Fig. 3). Press down on front of bolt stop. Bolt stop is located in left rear of bolt channel in receiver. Use small flat key or screwdriver. Allow bolt to slide back and disassemble as stop is pressed. Pull bolt from pistol. Clean bolt, or bolt parts, with a good petroleum solvent. Brush bolt face to remove shooting residue. Re-oil lightly and lubricate cam surfaces on bolt to prevent wear.

Additional care and cleaning of bolt parts can be done, if necessary. See below.

TO DISASSEMBLE BOLT PARTS — Pull bolt from pistol. Pull firing pin head back until coin or similar piece can be inserted (Fig. 4). Hold bolt handle and turn bolt plug until entire firing pin assembly can be pulled from bolt assembly. Reassemble in reverse order.

Fig. 4

FIRING PIN HEAD**COIN****BOLT
PLUG****BOLT**

TO PUT BOLT IN PISTOL — With safety forward, simply align bolt lugs to receiver properly, then push bolt forward in pistol.

HANDLING — Wipe barrel, receiver and all steel parts to prevent rusting. Invisible "prints" of moisture can cause rust unless removed.

EXPOSURE — After using in wet weather, always wipe steel parts with oil. Abrupt changes in temperature can also cause condensation and wetness. Therefore, special care is needed, especially to inside metal parts to prevent rust. When shooting in freezing weather, remove excess oil for best results. Use dry graphite if necessary to lubricate metal parts.

REMINGTON ARMS COMPANY, INC.**ILION, NEW YORK, U.S.A.**

"Fireball" is Trade Mark of Remington Arms Company, Inc., Bridgeport 2, Conn

**MODEL
XP-100****Bolt Action Pistol
SINGLE SHOT****When ordering parts — Model No., Part No. and Part Name must be given.**

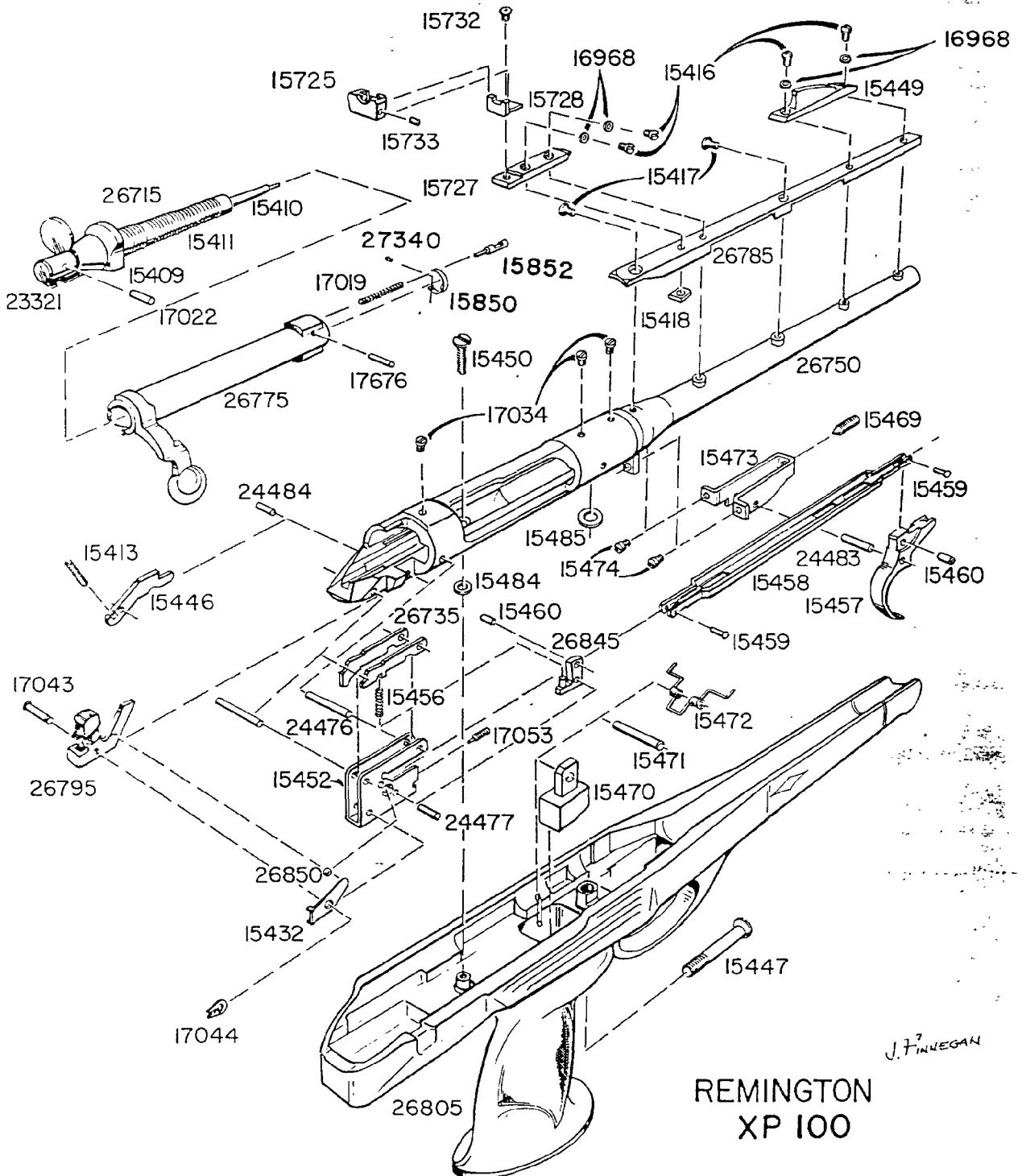
Part No.	NAME OF PART	List Price	Part No.	NAME OF PART	List Price
26750	Barrel Assembly, 221 Rem. "Fireball" (includes Barrel, Barrel Bracket, Barrel Stud (4), Receiver)	Price on Application	26785	Rib	\$ 1.80
26775	Bolt Assembly, 221 Rem. "Fireball" (includes Bolt Body Assembly and Bolt Handle)		15417	Rib Screw30
26770	Bolt Final Assembly, 221 Rem. "Fireball" (includes Bolt Assembly, Ejector, Ejector Pin, Ejector Spring, Extractor, Firing Pin Assembly) (not shown)		26795	Safety Assembly (includes Safety, Safety Thumbpiece)	1.45
15409	Bolt Plug		26850	Safety Detent Ball30
15446	Bolt Stop55	15432	Safety Detent Spring40
24484	Bolt Stop Pin30	17043	Safety Pivot Pin30
15413	Bolt Stop Spring30	17044	Safety Snap Washer30
15852	Ejector	1.10	14269	Sear Safety Cam	2.90
17019	Ejector Spring30	26845	Sear Block Assembly (includes Sear Block, Sear Block Stud)	2.55
17676	Ejector Pin30	24477	Sear Block Pin30
15850	Extractor	1.65	15456	Sear Block Spring30
27342	Extractor Rivet30	17053	Sear Block Stop Screw30
15410	Firing Pin	3.25	15452	Sear Housing	2.20
26715	Firing Pin Assembly (includes Bolt Plug, Firing Pin, Firing Pin Cross Pin, Firing Pin Head, Main Spring)	9.00	24476	Sear Pin30
17022	Firing Pin Cross Pin30	15416	Sight Screw30
15673	Firing Pin Head	1.20	16968	Sight Washer30
15447	Forward Receiver Screw55	26805	Stock Assembly (includes Fore-end Tip, Fore-end Tip Spacer, Fore-end Diamond, Forward Receiver Screw Escutcheon, Grip Diamond, Rear Receiver Screw, Escutcheon, Stock Half, Left; Stock Half, Right; Trigger Guard)	12.60
15485	Forward Receiver Screw Washer30	15457	Trigger	1.10
15449	Front Sight	1.10	15469	Trigger Adjustment Screw30
15411	Main Spring40	15470	Trigger Balance55
15450	Rear Receiver Screw40	15471	Trigger Balance Pin55
15484	Rear Receiver Screw Washer30	15472	Trigger Balance Spring40
26840	Rear Sight Assembly (includes Rear Sight Base, Rear Sight Elevation Screw, Rear Sight Eyepiece, Rear Sight Leaf, Rear Sight Windage Screw) (not shown)	3.60	15473	Trigger Housing	2.55
15727	Rear Sight Base55	15474	Trigger Housing Screw30
15733	Rear Sight Elevation Screw40	15458	Trigger Link	1.10
15725	Rear Sight Eyepiece	1.80	15459	Trigger Link Pin40
15728	Rear Sight Leaf75	15460	Trigger Link Roller30
15418	Rear Sight Nut30	26800	Trigger Link Assembly (includes Trigger, Trigger Link, Trigger Link Pin, Trigger Link Roller, Sear Block Assembly) (not shown)	6.30
15732	Rear Sight Windage Screw40	24483	Trigger Pin30
15778	Rear Sight Wrench (not shown)30	SUPERSEDED and SERVICE PARTS		
17034	Receiver Plug Screw30	20467	Extractor	\$2.90

DELIVERIES ARE F.O.B. ILION, N. Y.

PARTS AND PRICES SUBJECT TO CHANGE WITHOUT NOTICE

SECTIONAL VIEW**MODEL
XP-100**

REPLACEMENT PARTS — IDENTIFY COMPONENTS BY PART NUMBER FROM VIEW BELOW



Send all guns for factory service and inquiries on service and parts to
REMINGTON ARMS COMPANY, INC.
 Arms Service Division
 Ilion, New York 13357

All other inquiries are to be addressed to
REMINGTON ARMS COMPANY, INC.
 Bridgeport, Connecticut 06602

FORE-END WEIGHTS (Fig. 5) — Five (5) Cavities are provided inside fore-end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights. **To Remove Barrel and Action:** Remove bolt. Unscrew and disassemble forward and rear receiver screws. See sectional view. Lift barrel and action from stock. Insert weights and reassemble barrel and action to stock. Make certain nylon receiver screw washers (forward and rear) are in correct position against receiver during reassembly. Also that trigger balance remains centrally positioned on its pin in stock. This will enable top of balance to re-enter slot in trigger link easily. Make certain both receiver screws properly re-enter metal screw escutcheons in stock and tighten action securely.

MAINTENANCE — Gun should be checked periodically by a competent gunsmith to ensure proper inspection and any necessary replacement of worn or damaged parts.

IMPORTANT — Remington firearms are designed, manufactured and proof tested to standards based on factory loaded ammunition. Improperly loaded handloads can be dangerous. Remington Arms Company, Inc. cannot assume responsibility for damages or injury caused by handloads or reloaded ammunition.

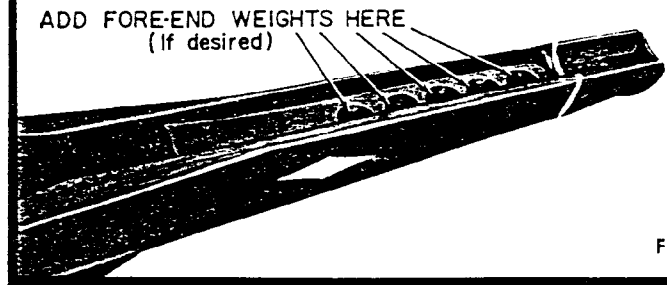


Fig. 5

INSTRUCTIONS FOR ORDERING PARTS

(Please read carefully)

WHEN ORDERING PARTS . . . MODEL NUMBER, PART NUMBER and PART NAME MUST BE GIVEN. Give also serial number, and state caliber or gauge and choke needed. Please identify from the component parts, picture or exploded view. When ordering interchangeable shotgun barrels, please list on separate order form. This will speed up shipment.

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — This delays service.

Please do not ship sample parts to Firearms Factory unless it is impossible to identify from the Parts List or Instruction Folder. See shipping instructions concerning **FACTORY SERVICE**

The sale of barrels, bolts and receivers is restricted. Special tools and gauges are required for assembly.

Parts will be furnished for discontinued models as long as the supply is available. It is not possible to supply parts for models or repair any guns not listed in Complete Line Parts Lists.

All parts will be shipped as ordered. Since parts are made to close dimensions, a particular part may require slight adjustment or fitting to assure proper function of the arm.

IMPORTANT: Do not combine Part Orders with Gun Service Orders. Please send Part Orders direct to

REMINGTON ARMS COMPANY, INC.
PARTS DEPT.
ARMS SERVICE DIVISION
Ilion, New York 13357

INSTRUCTIONS FOR FACTORY SERVICE

Please read carefully before making
shipment to the Firearms Plant at
ILION, NEW YORK

Please package carefully when shipping firearms to factory. Use plenty of cushioning material to prevent movement of gun or gun parts in package during transit.

Please do not ship gun in a gun case, or special container that must be returned from factory. The return of gun or parts will be greatly speeded if properly packaged in a throw-away carton

All shipments should have forwarding and return address clearly marked on gun package as well as on attached letter.

To further improve service — please attach complete letter of information securely on outside of each package returned to factory for repairs.

Please do not return gun accessories such as sling straps, quick release swivels, special boots, covers, telescopes, mounts or any special equipment to factory with gun shipment.

Give full condition of contents — stock and fore-end damage (if any), metal damage (if any), barrel bent or damaged (if any), parts missing, etc. A full description will make possible a more accurate list of needed repairs

Cover only one subject in letter or order. Do not order spare parts and give instructions on repair of a gun or guns in the same letter — This delays service.

To avoid all possible delay in starting work on gun or parts, please include in first order or letter the trouble to be corrected, any changes desired or parts to be replaced.

If an estimate is required before work is started, please advise. Otherwise we will proceed with necessary work and send you a statement of the cost. In this manner, gun or parts can be reshipped at the earliest possible date.

Remington gun parts are not interchangeable with those of any other make. For this reason the Remington Arms Company, Inc. cannot service any gun not of our manufacture.

Repairs will be made on discontinued models as long as supply of parts is available. However, repairs cannot be made for models which are not listed in complete line Parts Lists

IMPORTANT: Before packaging guns for return to factory, **ALL LIVE AMMUNITION SHOULD BE REMOVED.**

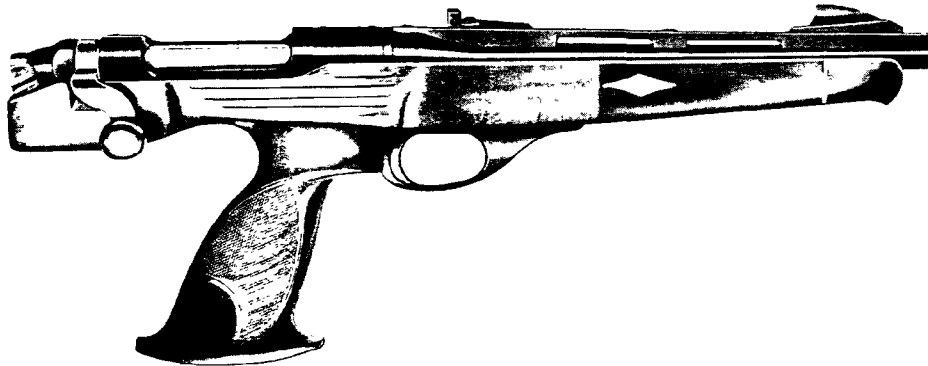
If live ammunition is included in package, shipment cannot be made by Insured Mail. All other shipments may be made by Insured Mail, Express, Motor Transport, or Freight.

Please send repairs direct to

REMINGTON ARMS COMPANY, INC.
ARMS SERVICE DIVISION
Ilion, New York 13357

REMINGTON
FIELD SERVICE MANUAL

The Remington XP-100 is a single shot, high power, bolt action pistol for extreme accuracy and long range shooting. The basic operations of bolt, loading, extracting and ejection are similar to most bolt action rifles.



The Instruction Folder RD-5469 is packaged with each new pistol shipped from the factory. Folders may also be obtained from the dealer or retailer. The folder outlines the operating instructions and instructions for care and maintenance of the pistol.

When handling pistol for servicing and shipping make certain that pistol is empty with no rounds in barrel chamber.

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BOLT FINAL ASSEMBLY:

To Disassemble - With safety lever forward, lift bolt handle upward as far as it will go and pull bolt rearward until it is blocked by the bolt stop. Insert small tool into space between bolt and receiver and push down against angle on bolt stop. When bolt stop is depressed pull bolt rearward from receiver.

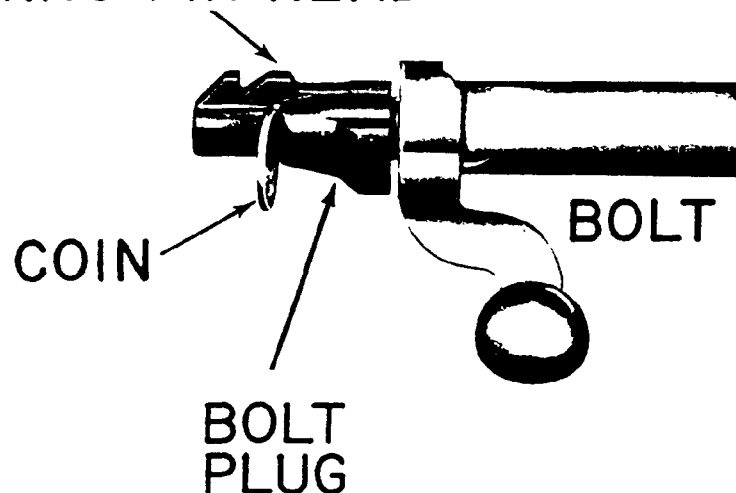
To Replace - Bolt assembly components of BOLT FINAL ASSEMBLY includes bolt body assembly and bolt handle. Return rifle to factory for selective assembly of bolt assembly to barrel. Remaining components of BOLT FINAL ASSEMBLY include ejector, ejector pin, ejector spring, extractor and firing pin assembly and may be replaced with no factory adjustment required. Return rifle to factory if replacement of BOLT FINAL ASSEMBLY is necessary.

To Reassemble - With safety lever in forward position, align bolt lugs with slots in receiver with bolt handle facing up. Push bolt forward as far as it will go and rotate bolt handle downward completely.

BOLT COMPONENTS:

To Disassemble - Pull firing pin head rearward until a coin can be inserted between it and the bolt plug. (see sketch below) This can be done by catching the notch in the firing pin head on a sharp corner or placing it in a vise. Unscrew the bolt plug to remove the firing pin assembly.

FIRING PIN HEAD



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Drive out firing pin cross pin (see sketch above) with a punch, leaving punch in the hole to hold parts together to prevent mainspring tension from stripping off firing pin head and bolt plug forcefully. Compress the mainspring with the bolt plug until coin, punch and firing pin head can be removed. Release mainspring tension carefully, removing firing pin head, bolt plug and mainspring. Drive out ejector pin. Leave punch in hole. Compress ejector spring by pressing on ejector. Remove punch. Release ejector slowly until tension is relieved from spring. Remove ejector and spring.

With pointed tweezers inserted in holes provided in end of extractor, compress ends together until extractor can be removed from face of bolt.

To Replace - See page 1.

To Reassemble - With pointed tweezers inserted in extractor holes, compress ends together with extractor hook facing bolt face. Assemble extractor in bolt face. Do not attempt to assemble by forcing extractor into bolt face with fingers.

Assemble ejector spring and ejector with stem end in spring. Align ejector with ejector pin hole, compress ejector, insert punch and drive in ejector pin.

Assemble mainspring and bolt plug. Grasp bolt plug and compress mainspring. Assemble firing pin head, align holes in firing pin head and firing pin, and insert punch. Insert coin between front end of firing pin head and rear end of bolt plug. Drive in firing pin cross pin.

Assemble firing pin assembly in rear end of bolt.

STOCK ASSEMBLY: (with bolt removed)

To Disassemble - Unscrew forward receiver screw from bottom of stock. Unscrew rear receiver screw up through receiver and remove stock assembly.

To Replace - All parts completely interchangeable with no factory adjustment required. Replace as an assembly. Stock assembly is a welded nylon unit factory-listed to include: Fore end tip, fore end tip spacer, fore end diamond, forward receiver screw escutcheon, grip diamond, rear receiver screw escutcheon; stock half, left; stock half, right; trigger guard.

Five (5) cavities are provided inside fore end (under barrel) for adding weights. Each cavity will hold a .38 caliber, metal case, 130 grain bullet (nose down). Barrel and action must be removed from stock to add weights.

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To Reassemble - Make sure that front and rear receiver screw washers (nylon) are in place in bottom of receiver and that trigger balance is in place and central in stock assembly. Insert forward receiver screw into stock from bottom to align forward escutcheon. Reassemble stock assembly to pistol, making certain receiver and barrel are well seated into stock and tighten forward receiver screw. Trigger should work freely. Should trigger not be central with clearance slot in trigger guard, loosen forward receiver screw and rotate receiver assembly slightly until trigger clears in slot. Retighten forward receiver screw. Insert and tighten rear receiver screw.

TRIGGER BALANCE: (with stock removed)

To Disassemble - Grasp top of trigger balance between thumb and forefinger and, lifting up, remove from stock assembly. Disassemble trigger balance pin and spring from trigger balance.

To Replace - All parts interchangeable -- no factory adjustment required.

To Reassemble - Hold trigger balance with stem facing up and large angle on bottom facing forward. Hook trigger balance spring around stem of trigger balance so that opening in spring faces forward and coils are face up. (See Sectional View on last page) Align holes in spring with hole in trigger balance and slide in trigger balance pin. Reassemble trigger balance into stock assembly. Both ends of trigger balance pin should be seated in slots (about 1" rearward of forward receiver screw escutcheon) in stock. Bent ends of spring should face against walls ahead of trigger balance pin and tension should force bottom of trigger balance forward.
IMPORTANT: Make sure trigger balance is central with stock assembly.

REAR SIGHT ASSEMBLY:

To Disassemble - Unscrew the two sight screws from rear sight base and remove rear sight assembly. The rear sight nut is used to secure the rearmost rear sight screw to the rib. This nut is located between rib and barrel, accessible only when rib is removed from barrel. See instructions for rib. Unscrew rear sight elevation screw from right side of rear sight eyepiece and remove eyepiece. Unscrew small rear sight windage screw from top of rear sight leaf and remove rear sight leaf from rear sight base. The small socket wrench shipped with each pistol is used for this purpose.

To Replace - All parts interchangeable -- no factory adjustment required.

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To Reassemble - Place rear sight leaf on rear of rear sight base, align holes and screw in rear sight windage screw. Line up slot in rear sight eyepiece with rear sight leaf and slide eyepiece down on leaf and screw in rear sight elevation screw. For easiest reassembly of rear sight assembly the rib should be removed.

FRONT SIGHT:

To Disassemble - Unscrew and remove two sight screws and remove front sight.

To Replace - Interchangeable -- no factory adjustment required.

To Reassemble - Follow reverse order.

RIB (with sights removed)

To Disassemble - Unscrew two rib screws and remove rib and rear sight nut from barrel.

To Replace - All parts interchangeable -- no factory adjustment required.

To Reassemble - Place rear sight nut in recess provided in bottom of rib, place rear sight assembly on top of rib so that rear hole aligns with small hole in rib and rear sight nut, and screw lightly together. Do not tighten at this time. Place rib over studs on barrel. Screw two rib screws (lightly) through rib and into studs on barrel behind and ahead of rear sight assembly. Do not tighten at this time. Reassemble front sight (see Front Sight Assembly). See that rib is fitted to contour of barrel properly and tighten all screws.

SAFETY ASSEMBLY:

To Disassemble - Push safety snap washer out of slot in safety pivot pin. A screw driver or the edge of a coin is suitable for this purpose. Remove safety pivot pin, safety detent spring, safety assembly and safety detent ball.

To Replace - All parts interchangeable -- no factory adjustment required.

To Reassemble - Place safety assembly into sear housing so that short tab fits into opening between walls of housing and long tab fits into slot in bottom of receiver. Align hole in rear of safety assembly with hole in sear housing and push in safety pivot pin from left side. Place safety detent ball into hole in safety assembly and rotate safety assembly to rear position. Place safety detent spring over safety assembly so that bent tabs fit inward over safety assembly. Making sure that safety pivot pin is in as far as it will go, snap safety snap washer into slot in pin. Safety should snap freely forward and rearward.

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SEAR HOUSING and COMPONENTS

To Disassemble (with safety removed) - Drive out two sear pins from bottom rear of receiver and remove sear housing, sear and safety cam assembly and sear block spring. Remove sear block stop screw only if replacement is required. Drive trigger pin out of trigger housing and remove trigger link assembly. Drive sear block pin out of sear housing and disassemble housing from trigger link assembly.

To Replace - All parts interchangeable -- no factory adjustment required. See instructions for trigger adjustment, should adjustment of sear block stop screw be necessary.

To Reassemble - Align hole in sear block assembly with bottom forward hole in sear housing (tabs face forward on sear housing). Drive in sear block pin until end is flush with or under right side of housing. Insert housing up into slot in bottom of receiver. Align forward sear pin holes in receiver and housing. Drive forward sear pin into receiver hole and part way into hole in housing to retain housing in receiver. Insert sear and safety cam assembly into housing (see Sectional View on last page). Align holes with punch from right side of receiver and drive sear pin in completely until end of sear pin is flush on under inside wall of bolt stop slot in receiver. Place sear block spring into housing and over sear block stud. Push down on sear and safety cam assembly (top of spring should fit into slot on bottom of sear) until step on top rear of sear and safety cam assembly is below rear sear pin hole. Drive in rear sear pin completely. Sear and safety cam assembly should now be spring loaded and retained by the rear sear pin. Screw in sear block stop screw. Fit trigger up into trigger housing, align holes and tap in trigger pin. Trigger should work freely.

TRIGGER LINK ASSEMBLY:

Note: The trigger link assembly is assembled at the factory as a unit and it is not intended nor recommended that it be disassembled. Should disassembly be attempted, instructions are given below.

To Disassemble - Using small punch, carefully drive out front and rear trigger link pins from right to left. Disassemble trigger, trigger link, trigger link pin (front and rear), trigger link roller (front and rear), and sear block assembly. If original trigger link is to be replaced, it is important that it is not damaged during disassembly, especially that the two holes do not become enlarged when driving out pins.

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To Replace - Replacement as an assembled unit recommended. Plant assembling processes are used that require special tooling. However, parts are interchangeable providing sufficient care is taken when removing the staked trigger link pins.

To Reassemble - Insert trigger link roller into top hole in trigger and place between tabs in front of trigger link. Flat surface on trigger link should face down and two openings in bottom (flat) surface will face forward. (See Sectional View on last page) Align holes and insert trigger link pin from left to right. Support under head of pin with pin all the way into hole, and carefully stake opposite end of pin so that pin will be retained. Trigger should pivot freely in trigger link with little or no end play or lateral movement of trigger in trigger link. Such play may be caused by enlargement of holes in trigger link when driving out trigger link pins. Should this occur, replacement of the trigger link will be required.

TRIGGER HOUSING (with trigger link assembly removed)

To Disassemble - Unscrew trigger housing screws from back of barrel bracket and remove trigger housing. Trigger adjustment is made and sealed during factory assembly. The trigger adjusting screw, therefore, should not be disassembled unless required for readjustment of trigger. See instructions for trigger adjustment.

To Replace - Parts interchangeable -- no factory adjustment required. Should replacement of trigger adjusting screw be required see instructions for trigger adjustment.

To Reassemble - Follow reverse order.

BOLT STOP (with sear housing removed)

To Disassemble - Drive out bolt stop pin and disassemble bolt stop and bolt stop spring.

To Replace - Interchangeable --- no factory adjustment required.

To Reassemble - Place end of bolt stop spring into recess provided in bottom of bolt stop slot. Place bolt stop up into slot, fitting bolt stop spring into slot at rear of bolt stop. Align holes and drive bolt stop pin through bolt stop and part way into receiver. End of pin should not protrude into sear housing slot. After sear housing has been reassembled into receiver, drive bolt stop pin in as far as it will go.

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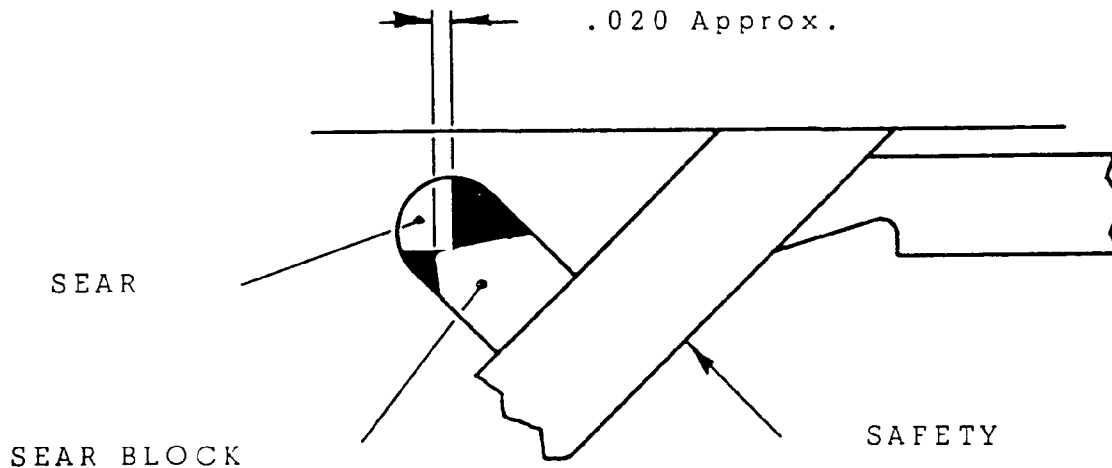
TRIGGER ADJUSTMENT (with bolt final assembly in receiver and stock removed)

Note: Trigger adjustment is made and sealed during factory assembly and it is not recommended that it be disturbed unless replacement of parts requires it.

1. Pull trigger to extreme rearward position and close bolt. Release trigger. Screw in sear block stop screw until it touches sear block and stake screw in this position.

To check this adjustment, open and close bolt. Pulling trigger should move sear block out from under sear, leaving a minimum of overtravel after sear has been released.

Sear and sear block engagement can be seen through the elongated slot in upper-central part of sear housing. This engagement should be approximately .020 of an inch. See sketch below.



By screwing the trigger adjusting screw into trigger housing further, this engagement is decreased.

2. To eliminate trigger creep (excessive trigger motion prior to release of sear) remove bolt and pull trigger to its rearmost position. Screw in trigger adjusting screw until approximately one quarter of an inch remains protruding from forward end of trigger housing.

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3. With bolt removed, release trigger and push down on top-rear end of sear. Check engagement as described above. To check final sear engagement, insert and close bolt. Pulling trigger should allow firing with minimum of trigger motion prior to release of sear. If excessive creep is evident on making this check, readjust as required.
4. Check final trigger adjustment by pushing on rear end of firing pin head when action is cocked. The firing pin should not move. If motion is seen, trigger adjusting screw should be readjusted to allow more engagement of sear and sear block.
5. When proper adjustment has been made, stake trigger adjusting screw.
6. Should pistol fire when bolt is rammed forward and closed roughly, adjustment has been made too fine and there should be more engagement of sear and sear block.

If desired, a final check can be made by using a trigger pull scale. The factory adjusted pull is from 1 1/2 to 2 3/4 pounds. Adjustment of the trigger should be within this range.

FGH:T

REMINGTON
FIELD SERVICE MANUAL1. FAIL TO EXTRACT

- a. Cause - Broken or worn extractor.
Remedy - Fit new extractor.
- b. Cause - Fouled or rusted barrel chamber.
Remedy - Clean, lightly polish or replace barrel.

2. FAIL TO EJECT

- a. Cause - Ejector stuck in bolt.
Remedy - Free or replace ejector.
- b. Cause - Fouling.
Remedy - Clean bolt face and ejector.
- c. Cause - Broken or worn extractor.
Remedy - See fail to extract.

3. FAIL TO COCK

- a. Cause - Broken, worn or improperly adjusted sear or sear block,
or both.
Remedy - Replace or readjust parts.
- b. Cause - Firing pin follows down.
Remedy - Fit new firing pin or seat assembly.

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Servicing

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STOCK

Listed below is the recommended method of restoring the finish on the Nylon stock.

Scratches: Use finely powdered pumice stone and oil. Rub with felt pad. Wipe clean and dry.

Abrasion: Use Du Pont auto rubbing compound. Rub with cloth pad. Wipe clean and dry.

For Polishing: Use Du Pont autowaxes.

To Clean Checkering: Use stiff tooth brush.
(and Striations)

CAUTION: Phenol is used in the weld assembly of nylon components.
Use all necessary acid handling precautions.

Follow numbered sequence:

1. Swab both joining surfaces with phenol. Take care that acid is applied to contact surfaces only.
2. Two (2) applications should be sufficient.
3. Allow swabbed surfaces to saturate thoroughly for at least five (5) minutes before joining.
4. Join saturated surfaces and hold in place. Use tape or clamps.

Note: Care should be taken that acid in excess is not applied to joining surfaces. Excess acid, squeezed or extruded from joined surfaces, must be removed immediately. Blemished areas will appear on unjoined areas if acid saturation is allowed to develop.

5. Allow at least one (1) hour for joined surfaces to weld together. Then remove tape or clamps.

To remove slight abrasions or blemishes in weld areas, use a good grade of auto rubbing compound.

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