

7. Position the posts of the magazine box bottom into the last coil of the magazine spring.
8. Push the magazine box bottom onto the magazine box until the bottom snaps into place.

WARNING: After each use, follow the lubrication and maintenance directions in this instruction book. If the firearm is immersed in water, it must be thoroughly cleaned and inspected as soon as possible. Immersion in salt water is especially harmful. Oil parts will flush water, then dry, clean and lubricate the firearm. The firearm does not include a safety. Have it provided by a competent gunsmith before the use. Failure to use the warning may lead to firearm malfunctions which could result in serious personal injury or death.

To Reassemble The Firearm

WARNING: Visually check the chamber and magazine box to make sure there are no rounds present before reassembling the firearm.

CAUTION: Do not reassemble the firearm with the magazine box in the rifle.

I. RECEIVER/BARREL ASSEMBLY:

1. Insert the breech bolt into the receiver with the bolt face toward the barrel.
2. Slide the bolt forward until it makes contact with the barrel.
3. Insert bolt guide rails into rear of receiver until they protrude approximately 1/2" from inside face of receiver. See Picture 17.
4. Insert one action spring (action spring set for Win. Mag.) into recess of bolt and over bolt guide rail. Work spring over guide rail while pushing guide rail towards barrel. See Picture 18.

PICTURE 17



NOTE: Rail should slide through slot on side of bolt.

5. Repeat for second action spring(s).
6. Insert operating handle through ejection port and into bolt.
7. Pull bolt rearward and ensure bolt guide rails are engaged in barrel extension.
8. Insert set screws and tighten with torque wrench (torque = 10-12 in-lb).
9. Lightly spray guide rails with Rem™ Oil.

NOTE: Breech bolt must slide freely in the receiver.

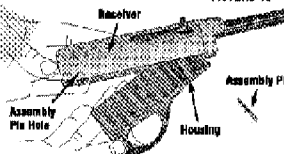
PICTURE 18



II. RECEIVER AND HOUSING:

1. Insert key on front of housing into mating slot in barrel extension. See Picture 19.
2. Rotate rear of housing into receiver, aligning assembly pin clearance holes.
3. Insert assembly pin.

PICTURE 19



III. ACTION TO STOCK ASSEMBLY:

1. Assemble the action into the stock.

WARNING: Put the safety mechanism in the "ON" or "SAFE" position.

2. Insert the front and rear take-down screws.
3. Tighten both screws, using a 3/16" Allen Wrench (torque = 45 in-lb).
4. The magazine may be placed back into the firearm. If the magazine is NOT in the firearm, the bolt will not engage the hold-open mechanism.
5. Pull the operating handle rearward until the bolt engages the hold-open mechanism.