

reassembly, the residual glue must be thoroughly removed from the pocket and recoil bracket to ensure proper seating of the recoil bracket. Prior to assembly, Loc-tight #422 should be applied to the recoil bracket.

To remove the stock assembly – Remove the three take down screws using the proper Allen wrench size. Lift the barrel assembly out of the stock assembly, the bolt stop is held in place by the stock and will slide out of the receiver when the stock is removed. To reassemble, insert the bolt stop into the mating hole in the receiver, place the barrel assembly into the stock aligning the recoil bracket with the cross slot in the bottom side of the barrel. Install and tighten the front and middle take down screws to a torque of 50-60 in-lbs. Install and tighten the rear take down screw to a torque of 10-15 in-lbs.

To remove the recoil pad from the stock assembly – Remove the two recoil pad screws using a large “Phillips” style screw driver, pull the recoil pad from the stock. To reassemble, align the recoil pad with the recess in the rear of the stock and install the two recoil pad screws.

To remove the sling swivel studs from the stock assembly – Insert a small punch through the cross hole in the stud and turn counterclockwise. To reassemble, turn clockwise until the stud mates flush with the counter bore in the stock, align the cross hole perpendicular to the barrel.

To remove the latch assembly from the stock assembly – Slide a thin flat piece of steel between the stock and leg of the latch spring from the bottom side of the stock through to the top side. Without the use of a piece of steel, the latch spring leg will catch on the stock. Use a large diameter punch to push the latch, pivot pin, and spring upward and out of the stock. To reassemble, position the latch spring in the pocket in the latch and slide the pivot pin through the latch and spring. Slide the latch assembly into the stock, aligning the pivot pin with slots in the stock. Use a large diameter punch to snap the pivot pin downward into the pockets molded into the stock. Activate the latch to ensure free movement and proper spring return.

CYCLE OF OPERATION

The cycle of operation for the M/710 follows the basic pattern of bolt action rifles. To fire the firearm, the Integrated Safety System (ISS) must be in the fire position (red dot showing), slide the bolt assembly forward feeding a round from the magazine, fully close the bolt and rotate handle downward until contact is made with the receiver, align the sights or scope with the intended target, slide the safety to fire (F) position and squeeze the trigger. To unload the rifle, rotate the bolt handle upward and pull the bolt assembly rearward, the fired cartridge will automatically eject from the receiver when the bolt reaches the bolt stop. When not in use, the firearm should be stored with the bolt assembly open, the ISS in the locked position (white dot showing), and the safety in the safe position (S).

MALEFUNCTIONS

Cause and Correction

Bolt fails to feed a round when closed (Bolt Over-Ride):

- Cause:
1. Magazine not properly latched into stock
 2. Magazine follower binds
 3. Magazine feed lips deformed