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PROCEDURE FOR REPLACEMENT OF TRIGGER HOUSING ASSEMBLIES

MODEL 600, 560 AND MOHAWK 600 ONLY

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IMPORTANT NOTICE: ABSOLUTELY NO ALTERATIONS OR ADJUSTMENT ARE TO BE MADE TO THE REPLACEMENT TRIGGER ASSEMBLY. IF ANY UNUSUAL PROBLEMS ARE ENCOUNTERED DURING REPLACEMENT OF TRIGGER ASSEMBLY, RETURN FIREARM TO FACTORY.

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PENCO-Beypore, N. I.
**PLAINTIFF'S
EXHIBIT**
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AL 0030106

PROCEDURE FOR REPLACEMENT OF TRIGGER HOUSING ASSEMBLIES

Remove Trigger Guard and Stock Assembly

- A. Unscrew front and rear guard screws.
- B. Remove trigger guard.
- C. Lift away and remove stock assembly from action.
- D. Remove magazine assembly from receiver.

Remove Trigger Assembly From Action

- A. Pull safety lever rearward beyond the safe detent position to clear the rear sear pin.
- B. Tap out both sear pins.
- C. Pull trigger assembly from receiver.

Assemble Replacement Trigger Assembly

- A. Insert trigger assembly, identified with "V" stamped on left side of trigger, with slave pins intact, into receiver and align sear pin holes to receiver.
- B. Lightly tap slave pins to engage sear pin holes in receiver. Put safety to "On" safe position.
- C. Insert tapered end of sear pins in left side of receiver. Seat pins flush to slightly below bolt stop with slot. Make sure pins do not protrude into bolt stop slot in receiver.
- D. Prick punch receiver at sear pin holes on left side. Bolt stop must not bind in slot.
- E. Push safety lever to "off-safe" position, pull trigger and hold. Depress top rear of sear safety cam to insure that it moves freely in trigger housing. The sear safety cam must not bind and must retract without hesitation.
 1. If binding occurs, insert wide blade screwdriver and carefully spread walls of housing against side of receiver, and recheck element "E", above.
 2. Visually check alignment of inner walls of trigger housing with firing pin head guide slot in receiver.

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Assemble Replacement Trigger Assembly (continued)

- F. Push safety lever from "On-Safe" position to "Off-Safe" position, to insure free movement with no binding and positive engagement of detents. Check bolt lock area of the safety lever to make sure it works freely in receiver slot. If slight binding occurs on receiver, file receiver slot. If excessive binding occurs, then use another trigger assembly.
- G. Insert bolt assembly in action.
- H. Put removed trigger assembly in an individual envelope for return to Remington (one assembly per envelope), to the attention of D. Sanita, Arms Service Division, Ilion, New York 13357.

Trigger Assembly Clearance

- A. Assemble barrel action to stock to check trigger assembly clearance. The brass reinforcing screw located forward of the trigger assembly clearance cut may possibly interfere with the new design trigger assembly. If this occurs, bend center reinforcing screw toward muzzle for proper clearance. (Note illustration)

Safety Lever Clearance in Stock

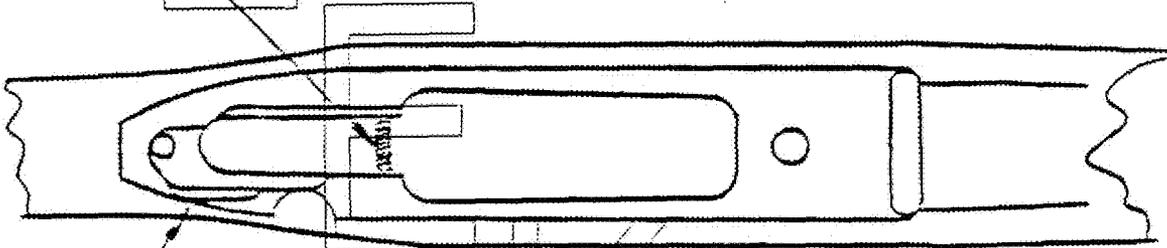
- A. For safety lever clearance, wood is to be removed from the rear of the safety clearance cut.
1. With the barrel action removed from the stock, measure 6.530" from the rear edge of the recoil lug shoulder to rear of safety lever clearance cut and remove wood for safety lever clearance, leaving a 1/8" to 3/16" radius in the rear corner. This wood removal can be performed with proper chisels and/or a rotary type high speed grinder. (Note illustration)

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Reinforcing screw should not interfere with trigger housing assembly.

- A. Bend screw forward .050" max.
- B. If interference remains or the screw breaks, remove exposed stock reinforcing screw section and file flush with interior walls of stock.

Possible interference point with trigger housing assembly



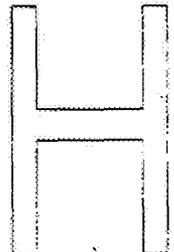
Model 600 & 660 Stock
Safety arm operation must be free & clear of stock.

Interference point of safety lever

Bend screw forward
.050 max.

1/8" to 3/16" Rad.

6.530



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PROCEDURE FOR REPLACEMENT OF TRIGGER HOUSING ASSEMBLIES

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- B. After completing this operation, insert barrel action into stock holding recoil lug tightly against recoil shoulder and with the bolt in the closed position, pull the safety rearward. Check bolt lift to insure safety arm has secured the bolt in the locked position. Inspect the safety lever for binding or contact with the safety lever clearance cut in the stock. Should the safety lever, in the "On-Safe" position, contact the stock, remove wood until clearance is obtained.
- C. After proper wood clearance has been obtained, complete the assembly of rifle. Check for clearance between trigger and trigger guard. Close the bolt, put the safety lever in the "On-Safe" position, pull the trigger rearward freely with no binding. If any contact is found, the trigger guard is to be filed.
- D. Check freeness of safety. Safety must not bind. The safety must snap in detent in both the "On-Safe" and "Off-Safe" positions.
- E. Check function of safety. Cock rifle and move safety to "On-Safe" position. No click or catch permitted when trigger is pulled and the trigger must readily retract when released. The firing pin must not fall. Move safe to "Off-Safe" position. The firing pin must not fall. Pull trigger. The firing pin must fall. Cock rifle and close bolt firmly. The firing pin must not fall. (Repeat several times) Open bolt, pull safety to "On-Safe" position and close bolt. The bolt must lock down. The safety must remain in "On-Safe" position and the bolt must not open until safety is pushed to the "Off-Safe" position.
- STOCK
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