

Procedure for changing Bolt Lock Safety Arm to Non-Bolt Lock Safety Arm

A. Check chamber and magazine for live ammo.

B. Remove stock. **NOTE: Care to be taken to ensure stock / action / scope are not damaged.**

1. ADL Stock removal.

- Remove 3 screws that hold stock to action.
- Carefully remove stock.
- Remove magazine spring and follower. **Note: Magazine box held into receiver with a screw.**
- Examine Trigger Assembly to the checklist – See attachment A.

2. BDL Stock removal.

- Open hinged floor plate.
- Remove takedown screws. **Note: Care to be taken to ensure stock / action / scope are not damaged.**
- Remove floor plate with magazine spring and follower.
- Remove magazine box.
- Examine Trigger Assembly to the checklist – See attachment A.

3. After removing the stock assembly, if any of the following conditions exist the entire trigger assembly should be replaced:

- Adjustment screws altered out of adjustment.
- Components rusted, or coated with heavy sticky residue.
- Contains non-Remington components.
- Contains broken or damaged components.

Else:

C. To remove safety to remove bolt lock arm.

- Lay action on bench with safety arm facing up.
- Remove safety switch snap washer.
- Remove safety detent spring.
- Remove safety pivot pin. **NOTE: bolt release will also come off.**
- Slide safety out the back of trigger housing. **NOTE: do not lose safety detent ball.**
- Place template on side of safety arm - align holes and mark. * See illustration.
- Cut or grind excess material away from bolt lock safety. **NOTE: make sure not to leave any burrs or sharp edges and recolor surface. * See illustration of Bolt Lock Safety and Non-Bolt Lock Safety.**