

Model 700

The model 700 was conceived in the late 50's and was on the market on '62. It quickly became the standard for production firearms. We were the first to do production guns in an assembly line. Before this guns were done one at a time by hand.

Prior to the 700 we had several bolt action guns. The 600, 660, and 625 were the predecessors. These were very reliable, accurate, but 700 was designed to be better, faster, and easier to make.

The only difference between rimfire and centerfire is the primer. Rimfire has the paste around the outer edge centerfire has the primer in the center. This makes it reloadable. The self contained cartridge was a huge breakthrough in the late 1800's.

One of the key selling features is the locktime.

Locktime is the time it takes from the trigger pull to the bang.

The 700 has a 3 millisecond locktime.

This is due to the way that the bolt assembly marries in with the seer.

The bolt assembly consists of:

Bolt head (contains back side of firing pin-firing pin is connected to the bolt head. A lot of people call this the bolt plug.

Firing Pin

Firing Pin Spring (or main spring)

(the plug is held in by a little pin. The spring wraps around the pin.

When you cock the gun you are actually pulling the spring back. This is held back by trigger assembly. The seer makes contact w/ bolt at seer lines-when the seer drops down it (bolt goes forward and bang.

Trigger Assembly-is held on by couple of screws to bottom of receiver.

The safety assembly is on the trigger itself.

All that our safety does is to block the seer.

Trigger Adjustment Screws-2 in front and one in the back.

The bolt spring is available for consumers to buy but they should never be a reason for them to need to buy it. It can be dangerous to work with. Normally don't recommend that they work with it.

On Model 700 they can't get any part of bolt or firing pin assembly. They can get the spring only. This is factory restricted due to the Iss system.

The firing pin itself isn't restricted.

Trigger work should be done only at the factory. Sometimes we let RARC get permission from Dennis Sanita for them to do it but not often.

The bolt locks into the receiver.

The receiver is the meat & bones of this gun. Everybody wants ours you can't blow it up. Our 3 rings of steel is stronger than anyones. There are imitations but ours is best by far.

The 3 rings of steel consist of:

receiver
barrel
bolt head

For excessive head space every bolt has different specs on the locking lugs. The Barrel Lug (also called the recoil lug) is the bolt that hooks around the barrel. This stabilizes the barreled action in stock. It absorbs a large amount of energy. This is put on when the barrel is made.

We hammer forge our barrels. They are made out of steel.

On the end of the barrel is called the crown. Our guns have recessed crowns. This is so that when you bang the gun you don't knick the barrel. If you did knick the barrel you would destroy the accuracy.

Rifling is made at a specific rate of twist.

Faster rate of twist is for heavier bullets. Our rates of twist are made to stabilize any bullet in that caliber load-this is not necessarily true for reloads.

Free bore is there for safety reasons.

All 700 guns w/ standard barrels(not heavy) just blued we put front and rear sites on it. There are none on the stainless steel barrels.

Controlled feed is called Mouser. This feeds by a claw. One bad thing about it is that it scratches the back of the brass casing. This is bad for reloaders. In testing the housing broke ours didn't. Ours is the strongest bolt on the market.

The parts of the 700 are:

Stock
Trigger
Bolt assembly
Receiver
Barrel

The main differences in the BDL and the ADL are that the BDL has a detachable magazine or a hinged floor plate.

(The BDL also has the great finish walnut stock, white spacers black fore end tip.

There is a new type of fore end tip now. The part is available to buy. They can put them on (or back on if just came off) with any two part epoxy.

If a gun is magnum then it gets a recoil pad. Standard Long action or short action get butt plate. Pads have to be fitted. They can buy them but they do have to be fitted to the gun. Caution is advised because they can mess up their stocks doing this. Both butt plates and recoil pads need to be fitted to the individual gun.

Recoil pads are not fitted they are flat. Butt plate is fitted. Recoil pad has to be cut to fit stock. We don't recommend that they do this work themselves. (Also putting the recoil pad on voids the warranty but don't make a big deal out of this).

Trigger guard assembly in BDL can be hinged or detachable.

Inside Hinged Floor Spring is magazine spring (doesn't come with a hinged floorplate and trigger guard assembly when you order them).

On top of the magazine spring is the magazine spring follower. These are specific to caliber, long action, short action, and mag. Extracting and ejecting is done on the bolt face. The inside of the bolt on the opposite side of the lug is the extractor. This pulls the case out. The ejector is the shiny circular pin on the bolt face. When gun is fired this pin is pushed in and that ejects the shell. Consumers can buy and replace these.

The ejector parts are:

Ejector Spring
Ejector plunger

A possible problem that people may have is:

Gun is hard to cam bolt handle down. Usually will drill hole to fit ejector in place there is a tiny burr left and it catches. Can fix with a grinder.

Another cause may be that the extractor is not installed properly. We should let them know that if they try to fix this themselves that they are easy to break.

Ask if consumer has a scope on the gun. Sometimes if the screw on the scope base is too far in that catches.

(Never forget that there is the possibility that it is the manufacturers fault. Always kindly serve the customer).

The Magazine follower spacer is only for 222 rem and 47rem calibers only. These two particular caliber bullets are really short and the spacer goes into the back of the follower to take up space and make it feed correctly.

Bolt face parts, ejector and spring are for sale.

We use rivetless extractors for long action and short action calibers. Magnum caliber extractors use riveted extractors. This is an extractor that has a rivet that goes down through the bolt face. This helps with the extra force of the magnum loads.

Normally we suggest that they get a gunsmith to put extractors on or they will break for them (unless its something that they are familiar with doing). The magnum needs to be done by a gunsmith because of the tooling that has to be done to rivet it.

Guns with riveted extractors in small non magnum calibers are old. Consumers can get parts from Jack First (he not only sells and makes obsolete parts, he is a great gunsmith). They could just change from riveted to non riveted by buying a total bolt assembly. This would modernize the firearm.

The same receiver plug screws are in all guns but we call them 597 plug screws. The exception is the 7400 and the 7600 (theirs are bigger).

We don't recommend see thru mounts.

Our safety is called a positive click safety. We will never make it quieter.

We just started making the detachable magazine models in 1993.

We do not make detachable magazine ultra mags because our current magazines won't fit.

Except

The new custom shop African Game Rifle. It is detachable but it is completely different system. It is a single stack magazine.

The BDL Custom Deluxe always has a shiny walnut stock, white line spacers, black fore end tips and either a hinged floor plate or a detachable magazine.

The magnum has a recoil pad and 2 (as opposed to 1) black screw holes filled on the stock.

ADL is satin finish, lower grade wood, no black fore end tip. Blind box magazine.

Both come with swivel studs. These are both standard contour hunting barrels.

Contour barrel is a heavy barrel (sometimes called a bull barrel). It has a bigger outside diameter.

We have bull barrels are on the 700 varmint or Sendaro.

All of our varmint guns are short action caliber.

Long action receivers are physically longer to accommodate longer cartridges.

There are two different kinds of varmint stocks:

Synthetic-aramid fiber

Laminate wood –satin finish.

Laminate wood is the strongest stock that we make and it is impervious to weather.

We used to make a walnut varmint stock but it was discontinued.

The pressure point (located inside the fore end of the stock) is a design feature. People shouldn't sand them down. They can ruin the accuracy of the firearm.

There is no pressure point on a laminated stock-it's just not necessary.

A huge selling feature is the aluminum bedding block which can be found on the synthetic varmint and Sendaro.

(You can't put aluminum bedding block in wood it just won't work).

The synthetic stock has an aluminum bedding block. This stabilizes the barrel.

People can bed their own guns with fiberglass or some other material. They do it a lot. (Voids the warranty on the stock).

Synthetic stocks are BDL style (hinged floor plate).

Wooden stocks should be tightened hand tight. If consumer is adamant about using torque pounds then they should never use more than 35 **inch** (not foot) pounds but try to push hand tight.

The synthetic varmint and Sendaro can go to 50 **inch** lbs. Hand tight is fine also.

Recoil pads on varmint and Sendaros are glued on. Consumers must take to a gunsmith to remove and replace. We won't do it.

Even older stocks, 30 to 40 years old even, you may notice that the recoil pad may look slightly smaller than the stock. This is where the wood has swollen, this is perfectly normal.

Sendaro's are mostly just long action versions of a heavy barrel.

A heavy barrel disperses heat much better, (heat is the enemy of accuracy), and helps with rigidity.

To site a firearm in we suggest that you shoot 3 shot groups, let cool for 15 to 20 minutes and shot another group.

Sendaro has fluting. This gives more surface area. It cools better and makes it more rigid.

A classic gun is a variation of a mountain rifle.

A mountain rifle is a light weight, shorter BBL that is smaller contour. The stock is always the same, no monte carlo stock, no cheekpiece, no black fore end.

The mountain rifle is offered in detachable magazine. The custom shop has other versions.

All custom shop wooden stocks are glass bedded by hand. They are truly free floated. Synthetic guns are glass (fiberglass) bedded too.

Synthetic 40x's are aluminum bedded.

A big thick fore end is referred to as a beaver tail fore end.

The recoil lug is listed as the barrel bracket on the parts list.

The bolt handle is not restricted on the parts list. Mark it as restricted on the parts list. People don't need to buy it.

The bolt plug listed on the parts list (blue and SS) are probably before ISS. The bolt plug manufactured after this time is restricted.