



REMINGTON M 700, 7, 600, 660, 721 & 722

3-POSITION SAFETY WITH BOLT LOCK INSTRUCTIONS

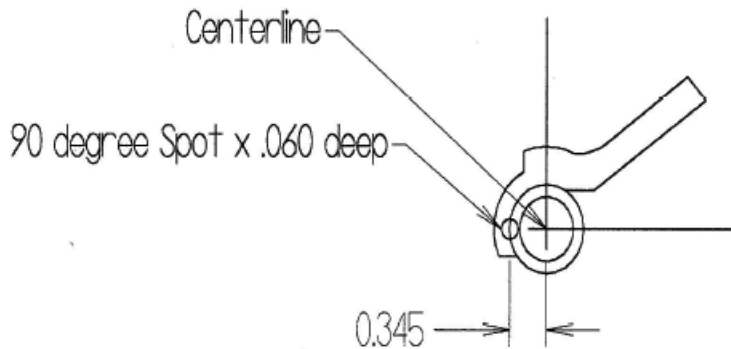
1. Remove old bolt sleeve, striker assembly, & safety parts from the trigger.
2. If using the old trigger unit, make up a spacer .125 thick with a .125 hole in the center for the bolt stop pin & safety pivot pin. Reassemble the pin, the spacer, & the e clip so that the bolt stop release will work.
3. Remove the safety lever cross screw, lever, plunger, & spring from the new safety.
4. Assemble the new bolt sleeve & safety onto the bolt & close the bolt in the action. Check for binding. If the sleeve drags, polish or file enough to clear and reduce the drag.
5. With the sleeve on the bolt: close the bolt so it is in the down position. With a center punch (Fig. A) punch a mark in the back of the bolt body.
6. Disassemble the bolt & clamp in a mill. Locate hole as in (Fig. B) with a 1/8" carbide ball mill plunge the hole .100 deep: check for burrs.
7. Reassemble the safety lever, plunger, & spring into the sleeve. With the safety lever in the forward position; screw the unit onto the bolt. The plunger is already prefitted to the bolt sleeve. \*If the plunger will not lock the bolt while in the reward position **NOTIFY US**. We will make up a longer plunger. There is a large fluxion in the Remington 700 bolts.
8. **We strongly recommend you purchase our new and improved striker or cocking piece.**
9. Modify the striker to the angle in (Fig. C) the cam surface should be polished smooth. You can assemble the firing pin & striker without the mainspring. Using thumb pressure on the striker to depress the sear, you can see how much to remove & to rough the cam surface in. Reassemble the safety lever, & spring, also the striker, firing pin & mainspring. When the final fitting is done, the safety lever would retract the firing pin approx. .020 - .025 to the rear when the safety is moved to the middle & rear positions. Check the trigger & sear notches to see if they move apart when the lever is move into the rear positions.
10. Check the firing pin protrusion. It should be .055 - .065. If too long polish the tip to correct length. If too short, clean bolt recess & firing pin shoulder.

"J" Lock Models must have a new firing pin, spring, & cocking pc.

If you have any problems or question please contact me.

**NO LIABILITY EXPRESSED OR IMPLIED FOR IMPROPER FIT BY NON QUALIFIED PERSONS**

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Indicate bolt lugs to set bolt rotation.  
 Indicate center of bolt.

Offset .345 to spot drill with 90 Degree.

Y  
 X

view:TOP WCS:TOP T/Cplane:TOP

0.09432  
 Inch

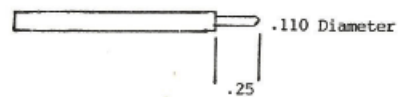


Fig. A

Approx. .2" long, made from 5/32 drill rod.  
 Turn tip to .110 with a 90° nose & heat treat.



Fig. B

Use 1/8" carbide ball mill.

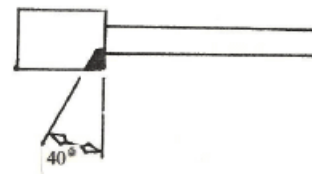


Fig. C

This must be as close to 40° as possible,  
 +/-2°, to line up with matching flats on safety lever.