



Gentry Custom LLC
314 N Hoffman St
Belgrade, Mt 59714
(406)388-4867

Remington Model 700, 7, 600, 660, 721 & 722

3-Position Safety with Bolt Lock Instructions

Always make sure that the gun is not loaded before you start work.

1. Disassemble the new Gentry safety by removing the safety lever screw, lever, plunger, and spring.
2. Remove original shroud and striker assembly from the bolt. Reassemble with the Gentry safety and striker assembly.
3. Check the sear engagement.
4. We recommend that you replace the factory trigger with an aftermarket trigger. We use the Rifle Basix L-1 trigger. Whether you plan on using the old trigger or a new trigger you will need to fabricate a spacer to replace the safety parts, .125 thick with a .125 hole in the center for the bolt stop pin & safety pivot pin. Reassemble the pin, spacer and e-clip so that the bolt stop release will work.
5. With the bolt closed into the action. Check for binding. If the safety drags, polish it just enough so that it is clear and moves freely.
6. With the striker assembly and safety in the bolt, close the bolt so that it is fully closed. With a center punch (Fig. A) make a mark in the back of the bolt body where the lever plunger goes.
7. Disassemble the bolt and place it in a mill. Indicate the bolt lugs to set the bolt rotation and indicate the center of the bolt then offset to .345 to drill with a 3/16x90° spot drill (Fig. B) plunge hole .060 deep.
8. Locate the punch hole that you made in step 6 as in (Fig. C) with a 1/8" carbide ball mill, plunge the hole .100 deep, check for burrs. Your bolt should now have 2 hole in it as in (Fig. D)
9. Reassemble the safety. With the safety lever in the forward (fire) position screw the unit onto the bolt. If the safety will not screw on check to see if the plunger is too long. If it is too long shorten the plunger and lightly chamfer the outer edge. Make sure you take just enough off the plunger to maximize its locking capabilities when the safety is in its rearmost (bolt lock safety) position
10. **We strongly recommend that you purchase our new and improved cocking piece.**
11. Remove safety from bolt and disassemble it. Reattach the firing pin, cocking piece, and safety, without the firing pin spring, to the bolt. Close the bolt on the action Use your thumb and push to cocking piece forward to engage the sear. While in you are holding the cocking piece in scribe the cocking piece through the safety lever hole (Fig F).
12. Modify the cocking piece to a 40° angle in (Fig. E). When machining or grinding the cocking piece make sure that you only remove a small amount of material at a time.
13. When the final fitting is done the safety lever would retract the firing pin approximately .020-.025 to the rear when the safety is moved to the middle and rear positions. Check the trigger and sear notches to see if they move apart when the lever is moves into the rear position.



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14. Check the firing pin protrusion. It should be .055-.065. If too long polish the tip to correct the length. If too short, clean bolt recess and firing pin shoulder.

"J" lock Models must have a new firing ping, spring and cocking piece.

Please contact us if you are having any problems or if you have questions.

NO LIABILITY EXPRESSED OR IMPLIED FOR IMPROPER FIT BY NON QUALIFIED GUNSMITHS.

Safety Parts List

Safety Shroud

Lever

Spring

Lever Plunger

Lever Screw

Bolt Lock Plunger

Plunger Spring

Plunger Screw

Extra Parts List

3/16X90* Spot Drill Garr # 91010

Gentry Cocking Piece

Lever Plunger Hole Drill



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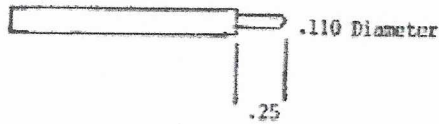


Fig. A

Lever Plunger Drill

Approx. 2" long #19 drill rod with the tip turned down to a #32 drill

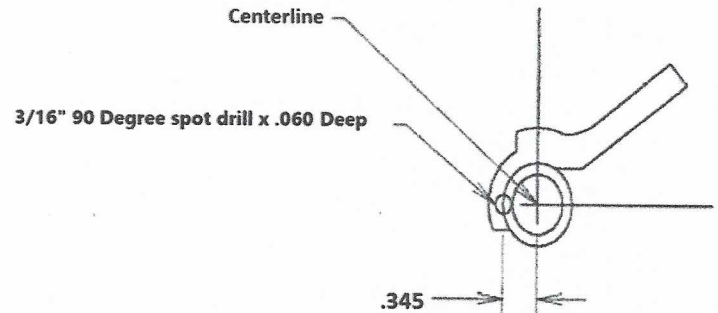


Fig. B

Bolt Lock indication

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

Offset .345 to spot drill with 90 Degree.

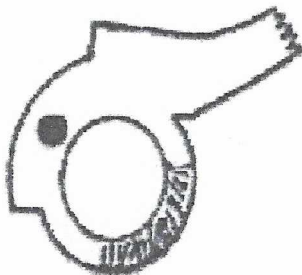


Fig. C

Use a 1/8" Carbide Mill

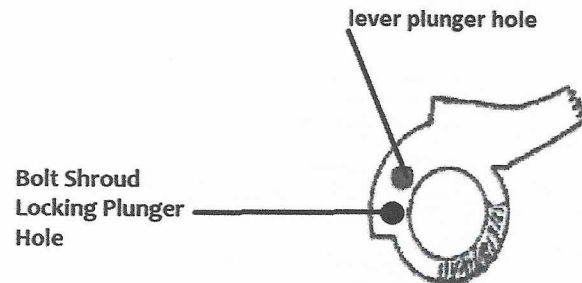


Fig. D

Your bolt should look like this with the 2 holes in it.

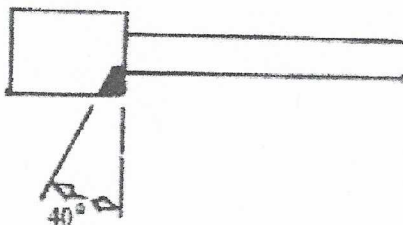


Fig. E

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

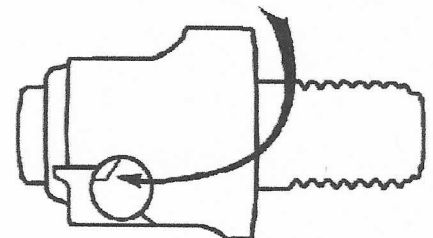


Fig. F