



Earlier Remington centerfire bolt action, pump action and autoloading rifles use an extractor that is riveted into the bolt. When an extractor breaks or fails, it must be replaced. Models using the riveted extractor include 740, 742, 760, 600, 660, 788, 700, and XP-100. We recommend using Brownells Remington Extractor Rivet Anvil when fitting this extractor to your bolt.



### WARNING



Never attempt to disassemble or reassemble a firearm unless you are absolutely certain that it is empty and unloaded. Visually inspect the chamber, the magazine and firing mechanism to be absolutely certain that no ammunition remains in the firearm. Disassembly and reassembly should follow the manufacturer's instructions. If such instructions are not immediately available, contact the manufacturer to see if they are available. If they are not available at all, then you should consult other reference sources such as reference books or persons with sufficient knowledge. If such alternative sources are not available and you have a need to disassemble or reassemble the firearm, you should proceed basing your procedures on common sense and experience with similarly constructed firearms.

With regard to the use of these tools, the advice of Brownells Incorporated is general. If there is any question as to a specific application it would be best to seek out specific advice from other sources and not solely rely on the general advice and warnings given.

### HOW TO USE

The bolt should be stripped as far as possible. This includes removing the firing pin and ejector. After disassembling the bolt, the old rivet and extractor must be removed. It may be necessary to drill out the old rivet to remove it. Do Not enlarge the hole in the bolt! Make sure both the rivet hole and the extractor seating groove are clear, and do not contain any dirt, grease or material that will interfere with the installation of the new components. Clamp your Brownells Extractor Rivet Anvil (#080-740-000) in your bench vise so you have easy access to the rivet-supporting section of the tool.

Adjust the extractor for the approximate proper tension before installation by squeezing the ends together slightly. Using smooth jaw pliers, straighten the tail of the extractor (opposite the riveted end) for about  $\frac{1}{8}$ " to  $\frac{3}{16}$ ". Install the extractor by starting the riveted end into the bolt face and working it down around the bolt face into its slot. Align the rivet hole in the extractor with the hole in the bolt and push the rivet through both pieces, with the head on the inside.

Support the rivet head with the Extractor Rivet Anvil, or a similar tool, and peen over the end of the rivet. We recommend a 4 oz. ballpeen hammer for this task. Smooth up the peening to blend with the outside of the bolt. If the head of the rivet protrudes inside the bolt recess, carefully dress it down with a Dremel tool and a small diameter stone until it blends in with the extractor's interior surface.

Check the initial fit by slipping an empty cartridge case onto the bolt face. Turn the bolt so the case points down. The extractor must grip the case firmly, not allowing it to fall from the bolt.

### ADJUSTING THE EXTRACTOR

If the case is held so tightly that it snaps free from the bolt with difficulty, tap the extractor hook back into the recess slightly using a soft metal punch, such as brass or aluminum. Check the adjustment frequently until the tension is set properly.

If the fired/empty case is gripped so loosely that it falls free from the bolt, the tension must be increased by pulling the loose end of the extractor from under the bolt rim until the case holds securely. If necessary,

remove the rivet and extractor and re-bend the extractor for proper tension. Re-install the extractor, using a new rivet and repeat the tests.

After the tension has been adjusted to your satisfaction, the hook and any visible portion of the rim of the extractor must be matched to the bevel of the inside of the bolt rim. Use a Dremel tool, needle files and/or stones to blend the surfaces.

After the extractor has been installed, reassemble the firearm according to the manufacturer's instructions, and test for proper functioning as instructed below. The new extractor should hold the cartridge case securely, and the extraction and ejection should be positive. Check for looseness of both the extractor and the cartridge case after hand cycling a few DUMMY ROUNDS through the action.

If the rifle functions properly it should then be test-fired with live ammunition in a safe and appropriate manner. When test-firing semi-automatic firearms, first test by loading one DUMMY round into the magazine with a live round above it. If the rifle functions properly, repeat the test using two live rounds. Again, if everything works as it should, repeat using a full magazine. After test-firing, examine the cartridge cases closely for signs of binding or marring by the extractor.

Reassemble the firearm according to the manufacturer's instructions. Check for proper functioning using **ACTION PROVING DUMMIES**. Make sure **ALL SAFETY MECHANISMS** are fully functional as designed and approved by the manufacturer. If these tests prove satisfactory, test-fire the firearm with live ammunition in a **SAFE** and **APPROPRIATE** manner. **IMPORTANT!** Start the live ammunition tests by first loading an **ACTION PROVING DUMMY**, then a live round, into the magazine. Only after several tests have been conducted in this manner should additional rounds be placed in the magazine and fired.

# BROWNELLS<sup>®</sup>

## REMINGTON 700-TYPE

# RIVETED

# EXTRACTOR

READ & FOLLOW THESE  
**INSTRUCTIONS**

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