

7. Using a torque wrench, torque action bolts to 40 to 45 in-lbs.

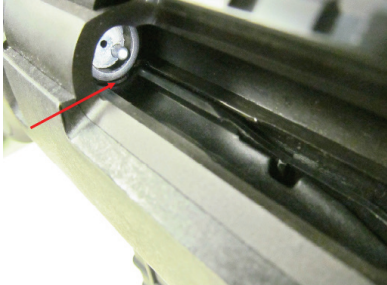
CAUTION
DO NOT EXCEED 45 IN-LBS. OR DAMAGE TO THE TRIGGER GUARD MAY RESULT.

DAMAGE DUE TO OVER TORQUING WILL VOID THE WARRANTY

8. Check the position of the magazine in the action as shown in *Figure 5* below.

- Magazine should be flush with the bolt slide area of the action to 1/32" (*see arrow, below*).
- Magazine should be level with the bolt.

Figure 5



Enjoy Your New Detachable Magazine!

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Remington Model 700 Long Action Magazine System Custom Installation Instructions

The system has been designed to function without modification on most injection molded polymer stocks.

Wood stocks are made to different specifications with trigger guard to action distance and angle varying greatly. In a standard internal magazine bolt action rifle this is of little concern. However, with a detachable, magazine fed, bolt action rifle the positioning of the trigger guard to the action is critical to function properly.

The following outlines how to adjust the Remington Model 700 (exc. ADL) Long Action Mag. System to your particular firearm.

Do not attempt to install this product on a loaded firearm! SERIOUS INJURY OR DEATH MAY OCCUR



A larger, printable version of these instructions are available at our website: www.legacysports.com



CAUTION

Failure to follow these instructions may result in unreliable operation and may damage the detachable magazine assembly.

Removing the Factory Trigger Guard and Internal Magazine

***** Before Proceeding*****

CHECK TO MAKE SURE YOUR FIREARM IS UNLOADED, NOW!

1. Unload the firearm and ensure the chamber is empty.

Do not attempt to install this product on a loaded firearm!

SERIOUS INJURY OR DEATH MAY RESULT
CHECK TO MAKE SURE YOUR FIREARM IS UNLOADED, NOW!

Installation Instructions

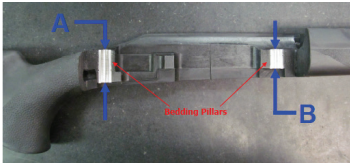
The Remington Model 700 Long Action Mag System is designed to perform reliably when the bedding pillars measure:

A: 1.230" to 1.265" (Figure 1)

B: .725" to .775" (Figure 1)

These are dimensions found in most injection molded polymer stocks

Figure 1



1. Measure the front and rear bedding pillars in the stock (see "A" and "B" in Figure 1).
2. If the measurements of your stock fall within the tolerances listed, proceed to step #5 for installation of the magazine system.

If either fall below the listed tolerances, continue to step #3

3. Use the following to calculate the thickness of shims or depth of machining in the stock. Use steel shim stock to obtain the correct thickness.

1.255" - (Distance measured at point "A") = Thickness of shims in Rear pillar.

.750" - (Distance measured at point "B") = Thickness of shims in Front pillar.

•Note: If the measurement in points "A" and "B" are larger than the recommended spec, the stock will have to be relieved to allow proper fit for reliable feeding.

4. Place the shims on the pillars as shown in Figure 2.
• Note: The shims should go around the mounting bolt holes as shown below, to ensure they do not move during use.

Figure 2



Do not attempt to install this product on a loaded firearm!
SERIOUS INJURY OR DEATH MAY RESULT

5. Install an **EMPTY** magazine in the conversion trigger guard and place in the stock (Figure 3).

Figure 3



6. Slide conversion trigger guard toward the rear of the stock to ensure the magazine is seated against the action to eliminate or reduce any "play" when installed (see arrows in Figure 4).

Figure 4

