

7. Using a torque wrench, torque action bolts to 40 to 45 in-lbs.
Caution
DO NOT EXCEED 45IN-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" below (see arrow).
 - Magazine should be level with the bolt.

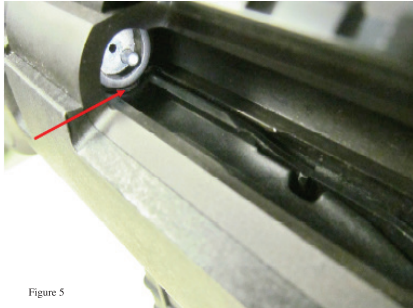


Figure 5

5

Enjoy Your New Detachable Magazine!



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Remington Model 700
Short Action Mag System

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 wood stocks. 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 Short
Action Mag System to your particular firearm.

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

Custom Installation Instructions



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 mag 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 Short Action Mag System is designed to perform

reliably when the bedding pillars measure:

A: 1.240" to 1.265" (Figure 1)

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

These are the dimensions found in most injection molded polymer stocks.

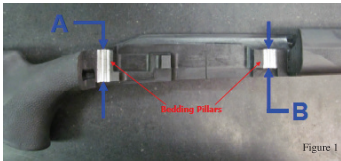


Figure 1

2



Figure 2

3

1. Measure the front and rear bedding pillars in the stock (see "A" and "B" in Figure 1 above).

2. If the measurements of your stock fall within the tolerances listed, proceed to step #5 for installation of the Remington Model 700 Short Action Mag System

If either fall below the listed tolerance, 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 and reliable feeding.

4. Place the shims on the pillars as shown in Figure 2.

• Note: The shims should go around the mounting bolts as shown below to ensure they do not move during use.

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 Floorplate and place in stock (See Figure 3).



Figure 3

6. Slide Conversion Floorplate toward the rear to ensure the mag is seated against the action to eliminate or reduce any "play" when installed (See arrows in Figure 4).



Figure 4

4

