

## TAC21 Installation for Remington 700

### Short & Long Action

Before starting make sure that your rifle is unloaded and safe. Always point rifle in a safe direction.  
Read all instructions before starting installation.

#### Tools required (Not included):

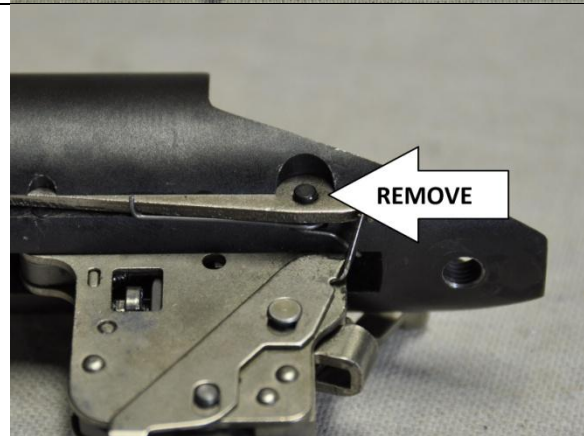
1/8" Allen wrench, 5/32" and 3/16" torque Allen wrench, small hammer, tweezers.

1. Remove bolt from action.
2. Remove barreled action from original stock.

3. Place trigger on safe.

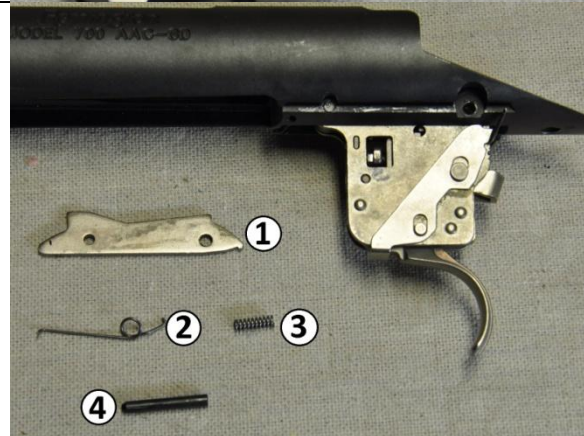


4. With a 1/8" drift punch and a small hammer, drift out the rear sear pin. Take care not to lose the bolt stop spring and the sear spring which is concealed within the trigger assembly. Remove the bolt stop lever.



5. Please note, your trigger will still be attached via the front trigger pin. The sear spring is concealed within the trigger assembly and should be kept track of.

- (1) Bolt stop lever
- (2) Bolt stop spring
- (3) Sear Spring
- (4) Rear sear pin

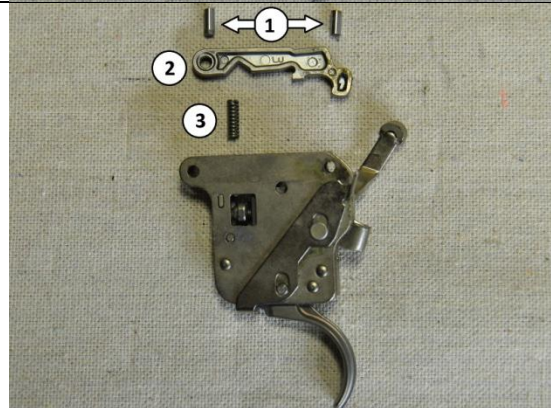


6. With a 1/8" drift punch and a small hammer, drift out the front sear pin. You can now remove the trigger assembly from the action.

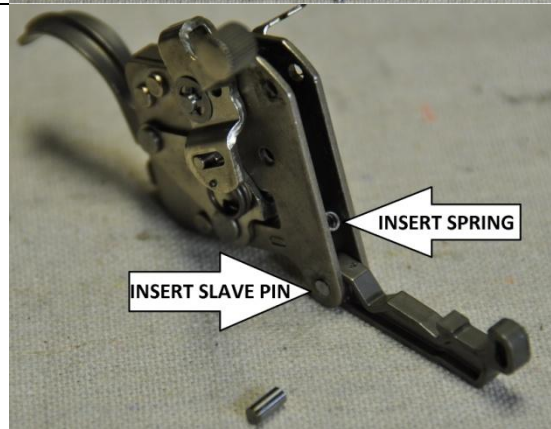


7. Trigger assembly expanded.

- (1) 2x Slave Pins
- (2) Sear
- (3) Sear Spring



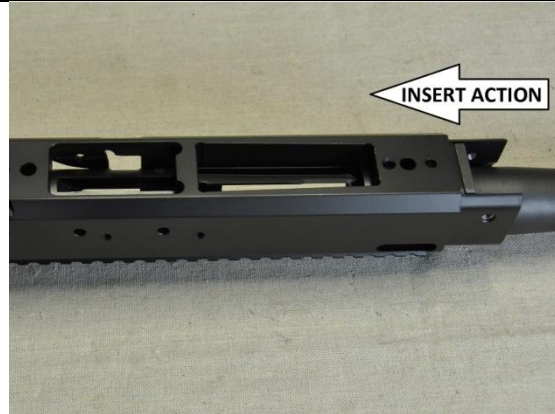
8. Reinstall the sear spring (5.3) and sear into the trigger. Secure the sear using one of the slave pins (7.1) included in the TAC21 hardware kit.



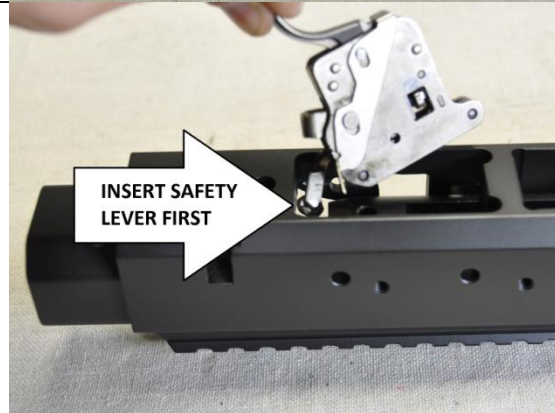
9. Fold the sear into place and secure it with the remaining slave pin (7.1).



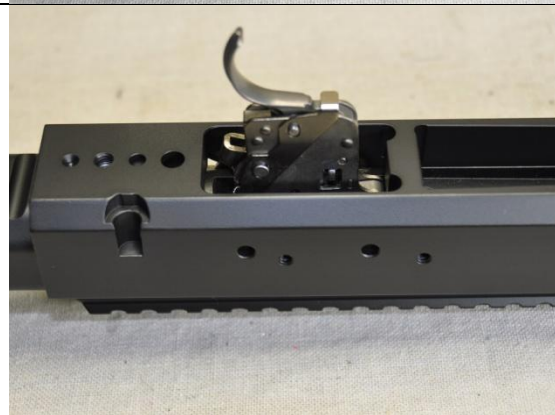
**10.** Insert the barreled action into the TAC21 action housing. Do not insert the action all the way, leave approximately 1 inch to make room for trigger assembly insertion in the following steps.



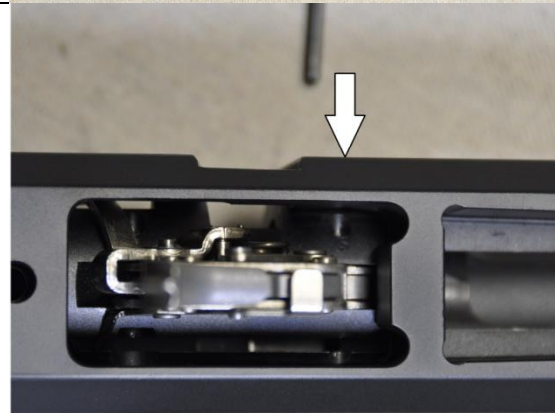
**11.** Set trigger assembly on 'SAFE'. Guide the trigger assembly into action housing by the tip of the safety selection lever.



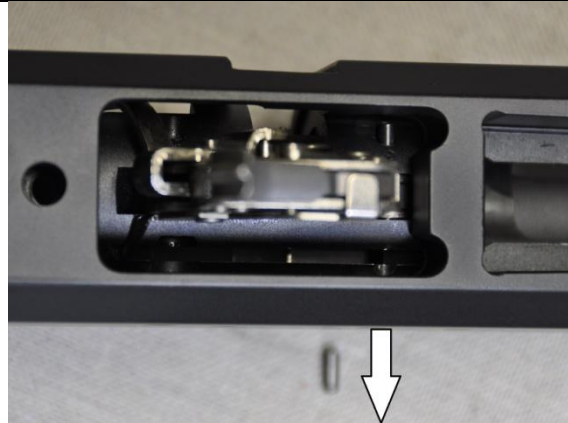
**12.** Once the trigger assembly is in place, the action can be inserted all the way.



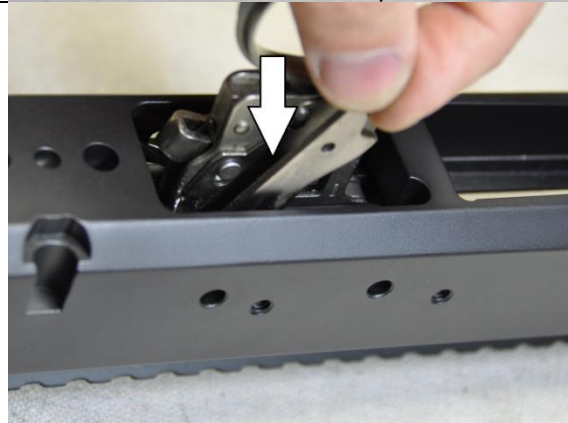
**13.** Insert the front sear pin through the action housing and into the action. Please note, the front sear pin is shorter than the rear sear pin. With a 1/8" drift punch and a small hammer, tap the front pin through the action and trigger assembly.



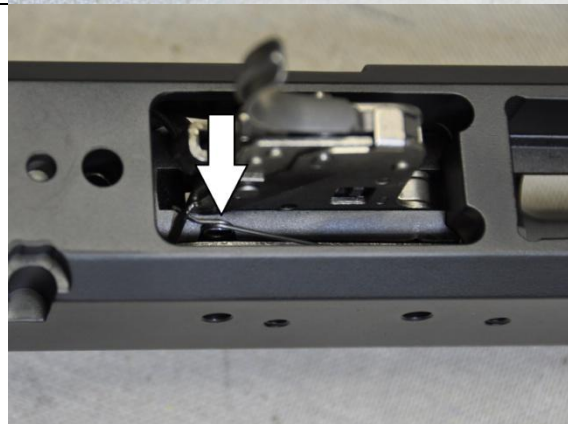
**14.** When inserted, the front sear pin will replace the slave pin. Be sure to retrieve the slave pin and set it aside.



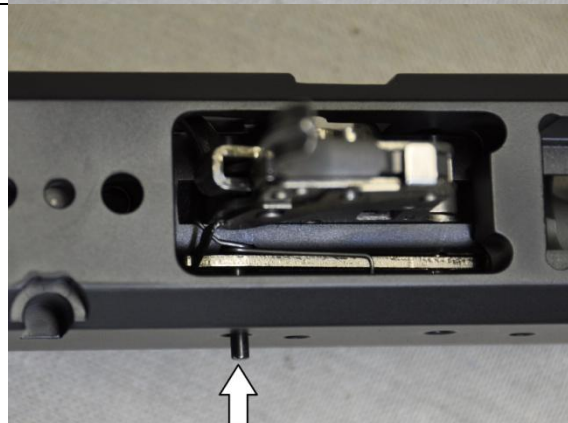
**15.** Drop the bolt stop lever (5.1) in place. The hooked end faces toward the rear.



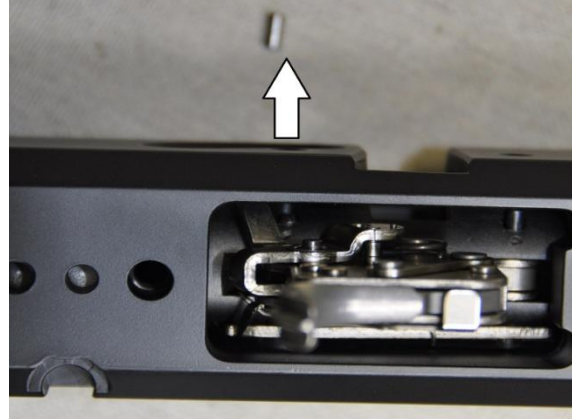
**16.** Insert the bolt stop spring (5.2) using tweezers.



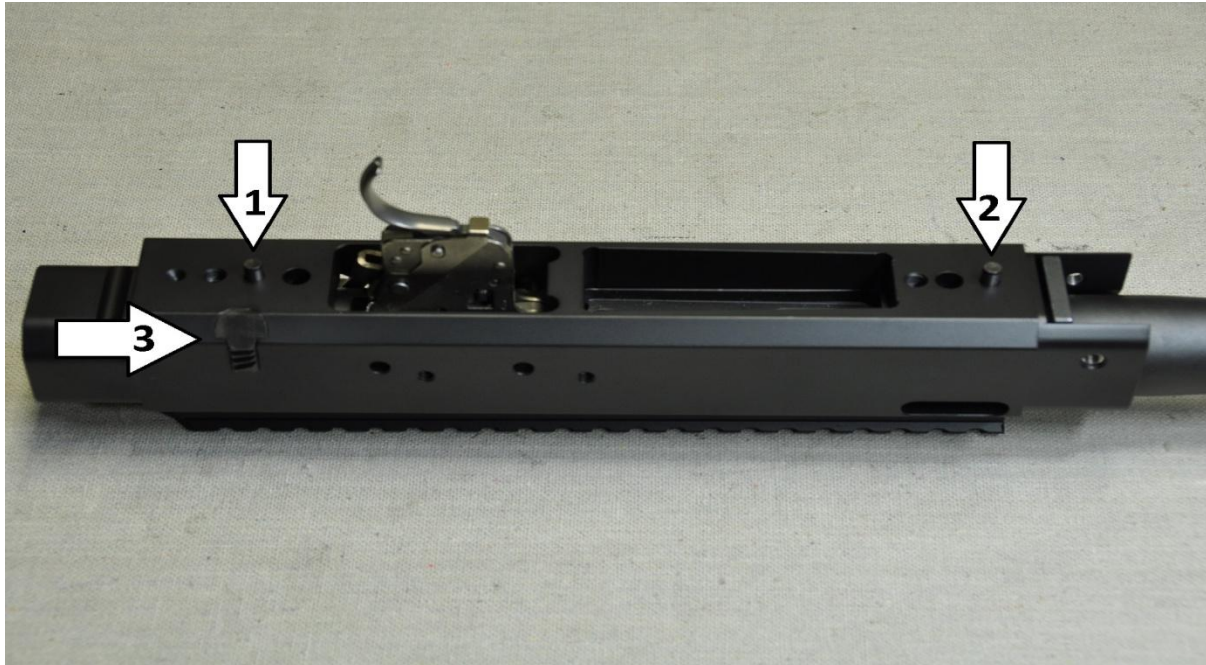
**17.** Press down on the bolt stop spring (5.2), and insert the rear sear pin (5.4) through the action housing, bolt stop lever, bolt stop spring, action, and trigger assembly.



**18.** When inserted, the rear sear pin will replace the slave pin. Be sure to retrieve the slave pin and set it aside.



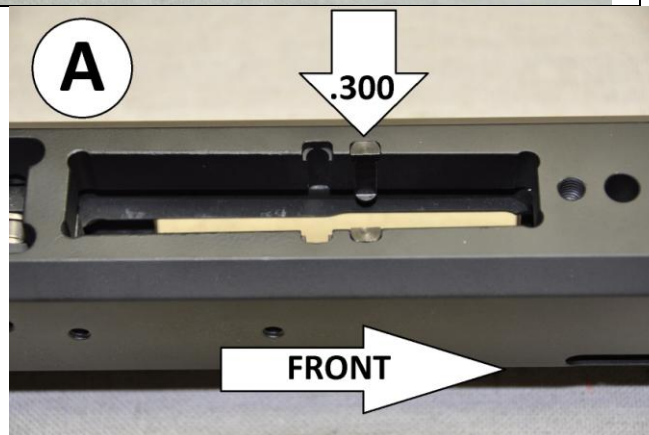
- 19.** (1) Install 3/16 x 1/2 dowel pins into main housing as shown.  
(2) Install 3/16 x 1/2 dowel pins into main housing as shown.  
(3) Install lever lock insert on the side of the main housing.

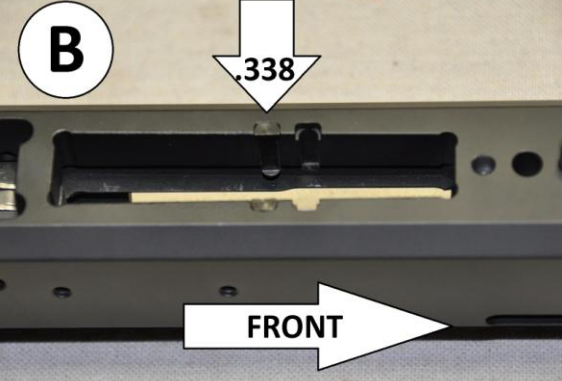
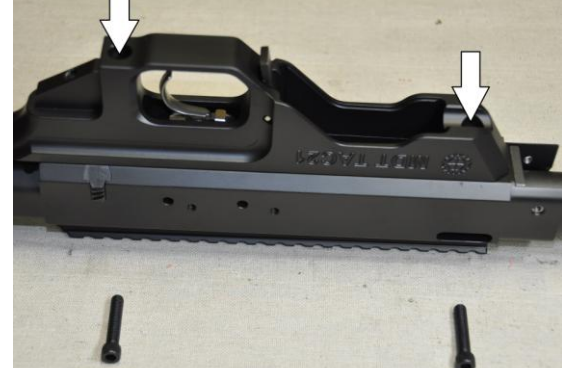



**20-A. LONG ACTION ONLY**

Install the magazine limiter pins. Choose the appropriate configuration for your rifle's chamber.

Config A: .300 Winchester Magnum



<p><b>20-B. LONG ACTION ONLY.</b></p> <p>Config B: .338 Lapua Magnum</p>	
<p><b>21.</b> Fit the trigger housing onto the action housing by way of the dowel pins. Install M6 bolts as shown. Torque to 65 inch/lbs.</p>	
<p><b>22.</b> Fit fore-end to main housing. Install the 3 10-32 countersunk screws to secure fore-end to main housing. Torque to 15 inch/lbs.</p> <p>Note: The screw holes are slightly off-set on purpose, this results in a tighter fit between the components.</p>	

**23.** Install pistol grip using provided 1/4-28 bolt.

**24.** Reinsert bolt. Ensure the firearm is not loaded.

**25.** Attach buffer tube to end cap and install desired butt-stock.



**26.** Attach end-cap to main housing and lock in place using end-cap lever.



**27.** Conduct function test. Check that bolt moves freely and safety is functioning properly.



**28.** Congratulations, you have successfully assembled the TAC21 Chassis for the Remington 700!

Enjoy!