SPECIFICATION

Remington 700 and Clone Short Action DBM

This user guide is suitable for the following Remington 700 and Clone DBM variants. Please refer to the parts diagram on the following page for specifics:

7075-T6-REM700-SA
316-REM700-SA
4140-QPQ-REM700-SA

This guide provides step-by-step installation instructions as well as addresses any likely installation problems. Please contact us if you have any questions which aren't covered in this specification or from our FAQ section online at www.lumleyarms.com.

Overview

The Remington 700 and Clone action DBM from Lumley Arms accepts all Accuracy International and compatible short action AICS magazines. We have engineered these DBMs to withstand a lifetime of hard use. Specifically:

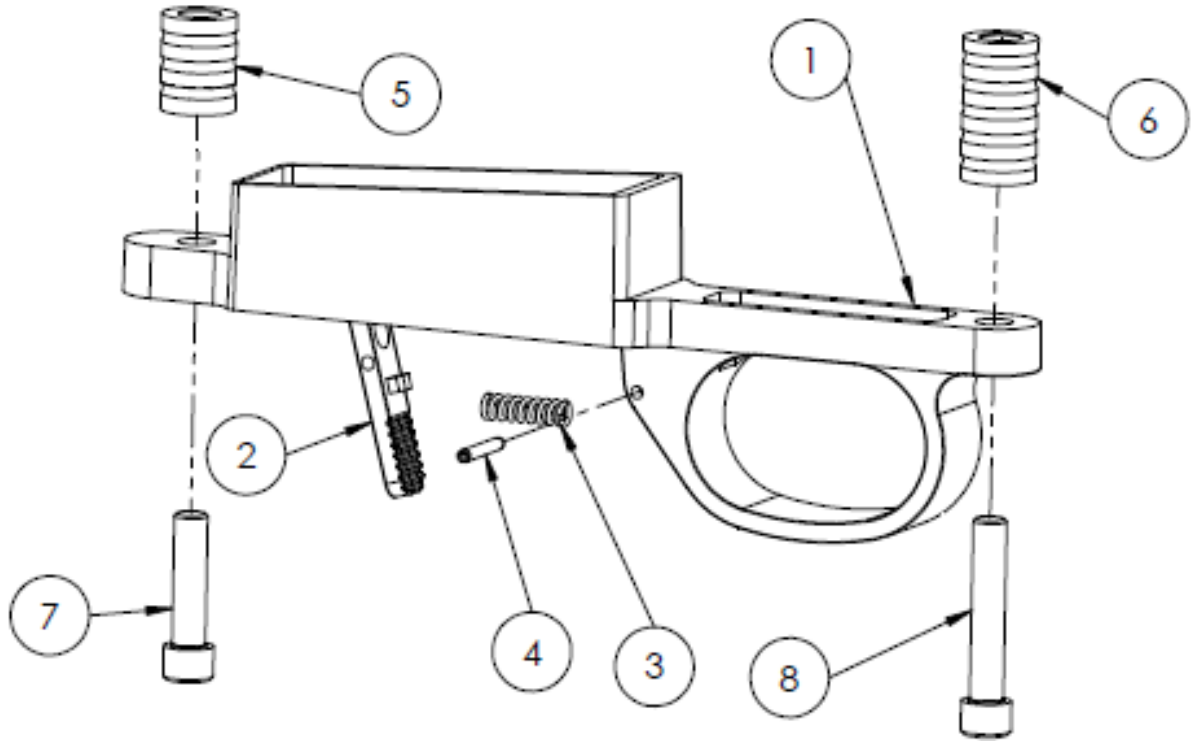
I. This DBM is precision CNC machined to tight tolerances from one piece of the finest ordnance, marine and/or aerospace grade steels and alloys presently available.
II. This DBM is finished with the best available hardening and coating treatments for the ultimate in wear resistance, dry lubricity and corrosion resistance.
III. All minor components (springs, rolls pins, action screws, action pillars, mag release lever) are manufactured to the same high standards as the main body. All components are made to precise tolerances and specifications.

Warranty

All our products have a lifetime back-to-base (Sydney, Australia) warranty against mechanical defects and manufacturing flaws. Whether you are the original owner or not, please contact the dealer from whom you purchased the unit or email us directly at info@lumleyarms.com if you have any concerns about the function or finish of your DBM. If you require spare or replacement parts, we will be happy to supply and/or fit these as required for a small fee to cover return postage costs.

Parts Diagram

The DBM consists of the following components listed in the table below. Each DBM is accompanied by a 4mm allan key for the installing the hex-socket action screws (interchangeable with 5/32”). Also included are extra roll pins and lever springs of varying pull weights. Should you need further spare parts or assistance with repair / replacement of faulty or missing parts – please contact us.



Part	7075-T6-REM700-SA WEIGHT 110g (0.24 lb)	316-REM700-SA WEIGHT 250g (0.55 lb)	4140-QPQ-REM700-SA WEIGHT 250g (0.55 lb)
1	**Main body of DBM** 7075-T6 alloy, Hard Coat Type 3 anodised.	**Main body of DBM** 316 stainless steel, glass bead blasted and passivated	**Main body of DBM** 4140 high tensile steel then QPQ nitrided to 65 Rc hardness
2	**Lever** 4140 high tensile steel then QPQ nitrided to 65 Rc hardness	**Lever** 316 Stainless, passivated.	**Lever** 4140 high tensile steel then QPQ nitrided to 65 Rc hardness
3	**Spring** 316 stainless steel wire	**Spring** 316 stainless steel wire	**Spring** 316 stainless steel wire
4	**Roll Pin** 316 stainless, Zinc plated – black	**Roll Pin** 316 stainless, Zinc plated – silver	**Roll Pin** 316 stainless, Zinc plated – black
5	**Front Pillar** 6061-T6 alloy, anodised gold	**Front Pillar** 6061-T6 alloy, anodised gold	**Front Pillar** 6061-T6 alloy, anodised gold
6	**Rear Pillar** 6061-T6 alloy, anodised gold	**Rear Pillar** 6061-T6 alloy, anodised gold	**Rear Pillar** 6061-T6 alloy, anodised gold
7	**Front Action Screw** 316 Stainless Steel, blackened 0.25 x 28 TPI UNF x 1 LONG	**Front Action Screw** 316 Stainless Steel, natural 0.25 x 28 TPI UNF x 1 LONG	**Front Action Screw** 316 Stainless Steel, blackened 0.25 x 28 TPI UNF x 1 LONG
8	**Rear Action Screw** 316 Stainless Steel, blackened 0.25 x 28 TPI UNF x 1.375 LONG	**Rear Action Screw** 316 Stainless Steel, natural 0.25 x 28 TPI UNF x 1.375 LONG	**Rear Action Screw** 316 Stainless Steel, blackened 0.25 x 28 TPI UNF x 1.375 LONG

Stock Compatibility and DBM Inlet Profile
Our DBM for short action Remington 700 and Clones is 100% compatible with the Badger Ordnance M5 inlet profile. We chose this profile because of the ever increasing number of stock manufacturers inletting for it as a factory option. The inlet profile is available on the website in PDF format, and the DXF file is available upon request.

Installation Instructions
If you are not using a pre-inletted stock to suit this DBM profile, we recommend a competent gunsmith to inlet your stock prior to Step 1. Most gunsmiths will charge $100 (or less) to inlet the stock for the DBM. If you choose to inlet yourself, a reasonably sized vertical milling machine and a firm, padded vice or clamp fixture is required to avoid marring the stock finish. We recommend practicing on an old or unused rifle stock until you are confident in the inletting operation. Inletting with a dremel or similar rotary tool is not recommended; it will likely provide a functional inlet for the DBM system but will also yield a messy or uneven inlet profile. Best results are achieved when the action pillars (included) are epoxy bedded into the stock. Failing to use the pillars or not ensuring the DBM and action are spaced correctly apart may result in the magazine either not locking into the DBM or the magazine locking in but the bolt nose not picking up the cartridge, or the being magazine loose and noisy. Check our FAQ page for more details on possible fitting issues.

STEP 1:
Ensure the rifle is unloaded, remove the bolt from the action. If still attached, unscrew and remove current trigger guard from the stock. Make sure not to use factory action screws when installing our DBM later.

STEP 2:
We recommend the use of our pillars provided. To install the pillars, enlarge the current action screw holes in the stock if required. As the pillars have an OD of 14.27mm, We recommend using a 14mm HSS drill bit chucked into the vertical milling machine with the stock firmly secured in a padded vice to get started. With care this can also be done using a handheld drill with the stock held by a vice with rubber jaws. Drill each hole carefully using the 14mm drill bit ensuring it remains perpendicular to each hole. Enlarge as necessary. Starting off with a smaller diameter drill bit will minimise the likelihood of damage to the stock if the action screw holes are not already drilled or are undersized.

STEP 3:
Best results are achieved by ensuring the pillars are epoxied into the stock. Any good bedding compound can be used. If not already done so, this is the best time to also bed the barreled action to ensure a perfect fit. Ensure that the receiver and DBM sit firmly against the pillars prior to bedding into the stock. If not, further inletting may be required for the DBM. Make sure to apply release compound before bedding.

STEP 4:
Apply bedding compound liberally and assemble the barreled action and attached pillars into the stock. The pillars can be attached to the receiver for this bedding step with 1/2x28 screws and a washer. For detailed steps on pillar bedding, we have found following the tutorial on the link here achieves the best results: http://www.6mmbr.com/pillarbedding.html

STEP 5:
After 24 hours, check the assembled rifle for fit and finish. Ensure the barreled action and DBM sit flush in the provided inlet and are wedged firmly between the pillars. Test function of DBM by cycling the bolt multiple times. Insert snap caps into magazine and cycle bolt action testing function of loading and unloading. We don't recommend doing this with live ammunition. Your DBM should function as designed. If not, please see our FAQ page at **www.lumleyarms.com**