

David Tubb's SpeedLock Cocking Piece

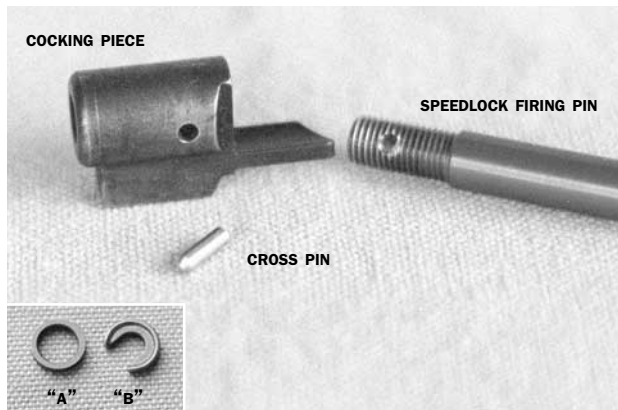
Engineered
by 9-time
National
High-Power
Champion
David Tubb

for Winchester Model 70™

[fits all versions of Model 70™ rifles]

FIRING PIN INSTALLATION

[SAFETY NOTE: You will be working with spring-loaded parts held under considerable pressure. A firing pin spring can eject with great force, possibly causing a great deal of injury. Please wear safety glasses!]



1.) Disassemble the firing pin from the bolt. Next remove the spring from the factory firing pin (wear safety glasses).

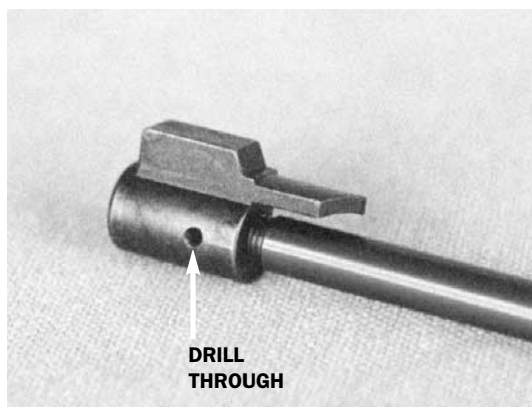
2.) With the spring removed, next remove the cross pin in the bolt shroud to allow the pin to be removed from the shroud (some models don't require this).

3.) Screw the bolt shroud back in the rear of the bolt into its closed (fired) position. Screw the SpeedLock™ cocking piece all the way onto the new SpeedLock™ firing pin. Drop this assembly into the back of the bolt shroud. Check the bolt face to see the amount of firing pin tip protrusion.

[Note: To avoid inaccuracy in taking this measurement, start with the pin threaded all the way into the cocking piece.]

4.) If the pin tip isn't protruding from the bolt face, remove the firing pin assembly and loosen the cocking piece one turn at a time, checking as you go.

Repeat as necessary until the correct protrusion is attained. Be sure the bolt shroud is in the fired position when checking pin protrusion! Recommended protrusion is .060 inches, but that amount is not critical. A safe, workable range is anything from .025-.085 inches.



5.) When protrusion is correctly set, remove the firing pin assembly from the back of the bolt, being careful not to let the cocking piece move on the threaded portion of pin. Put the cocking piece with the firing pin set to a correct protrusion in a non-marring vise and drill one 3/32-inch diameter hole through the pre-drilled hole in the cocking piece and drill completely through the firing pin. This hole is already pre-drilled through the cocking piece.

6.) Insert the cross pin (included) to secure the pin and cocking piece.

7.) Fit the safety cam to the bolt shroud safety lever (so that the safety works). This

may require removal of small amount of the SpeedLock™ firing pin directly in front of the safety cam notch on the cocking piece, as well as metal removal from the cam cut on the cocking piece.

8.) Cut the cross pin notches in the firing pin (if needed).

9.) If you don't have the "A" spring retaining washer and "B" half moon notch which retains the spring on the pin (pre-64 models don't have it) then call and order the parts from us or a Winchester™ parts dealer.

10.) Reassemble with the included new SpeedLock™ CS Spring. Wear safety glasses. Lubricate the bolt shroud and bolt threads, safety cam notch, and cam finger cut with a good quality grease.

