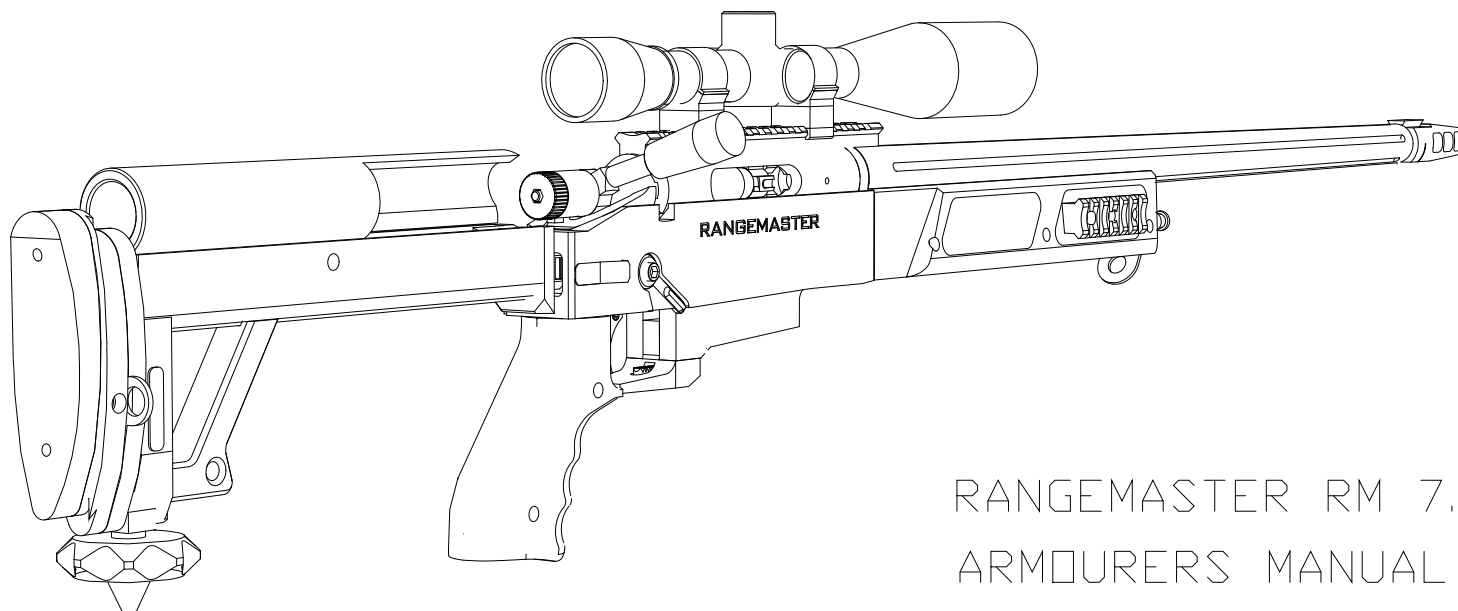
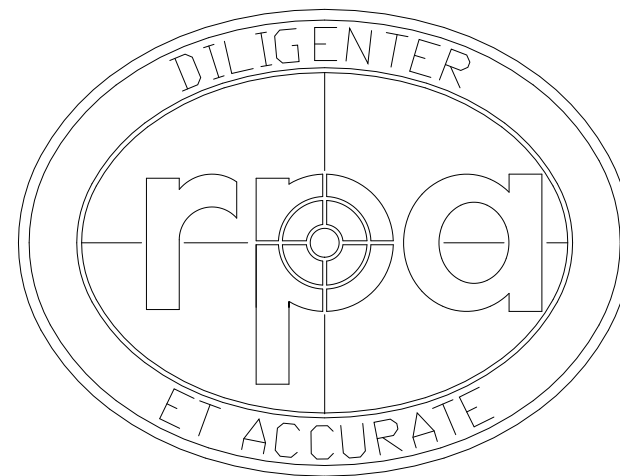
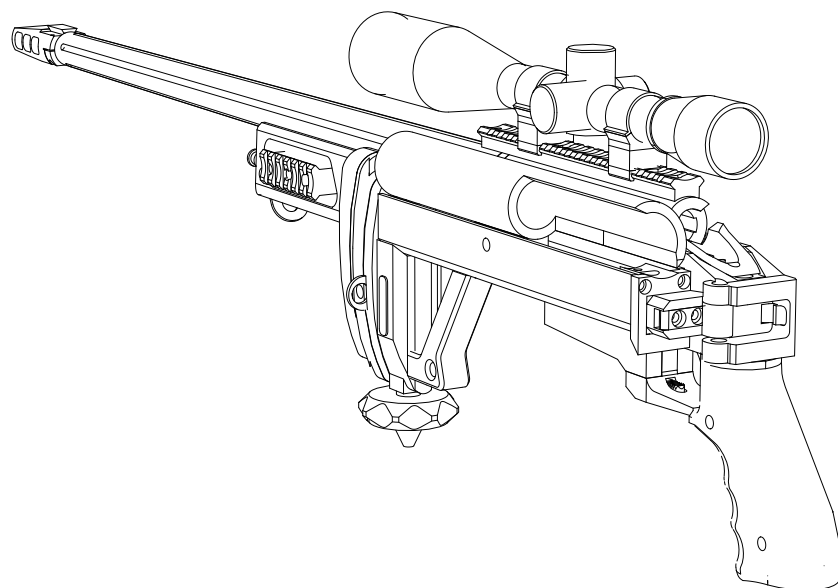


TITLE



RANGEMASTER RM 7.62 RIFLES
ARMOURERS MANUAL

SPARE PARTS



ORDERING PARTS

PLEASE CONTACT YOUR LOCAL RPA DEALER OR CALL RPA INTERNATIONAL
QUOTING THE SERIAL NUMBER OF YOUR FIREARM TO RECIEVE A PARTS
LIST AND IDENTIFY PARTS TO ORDER

SEND OR FAX INFORMATION TO YOUR LCAL RPA DEALER OR;

RPA INTERNATIONAL LTD
PO BOX 441
TONBRIDGE
KENT
ENGLAND
TN9 9DZ

TEL +44 845 880 3222
FAX +44 845 880 3232
EMAIL INFO@RPAINTERNATIONAL.CO.UK
WWW.RPAINTERNATIONAL.CO.UK



BOLT BODY
22-1002

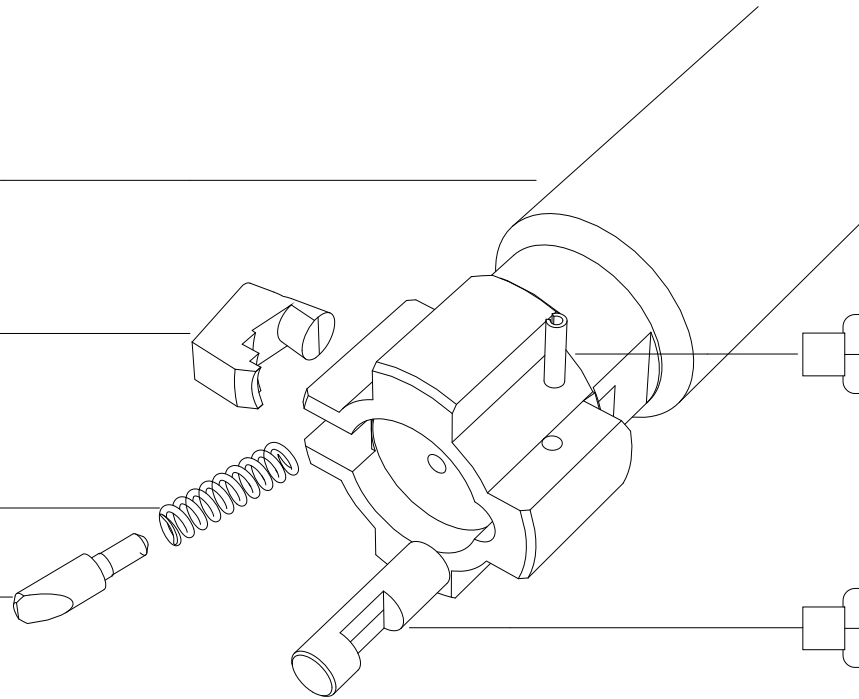
EXTRACTOR
20-1017-no2

EXTRACTOR SPRING
20-1027

EXTRACTOR PLUNGER
20-1016

ROLL PIN
20-1026

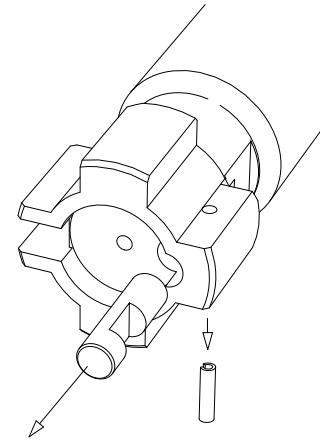
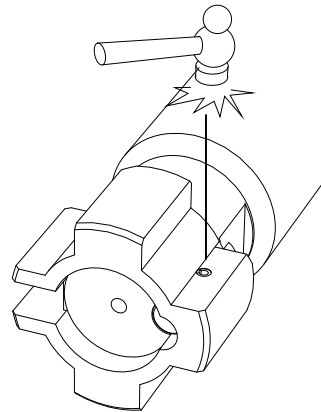
EJECTOR PIN
20-1009





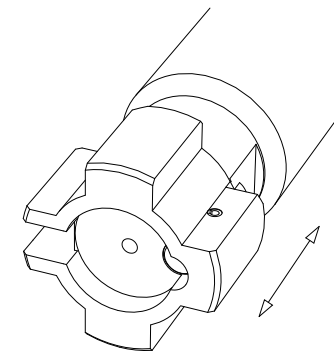
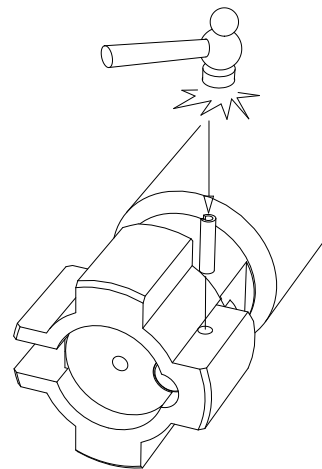
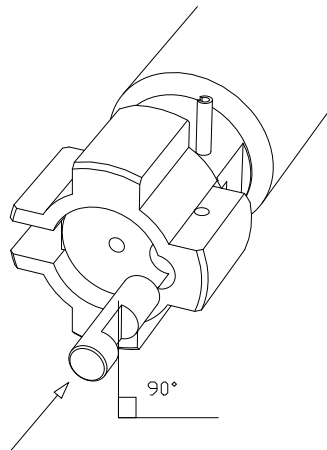
EJECTOR PIN REMOVAL

DRIVE OUT 1.5MM ROLL PIN
USING A PIN PUNCH. RETRACT
EJECTOR FROM FRONT FACE



EJECTOR PIN REPLACEMENT

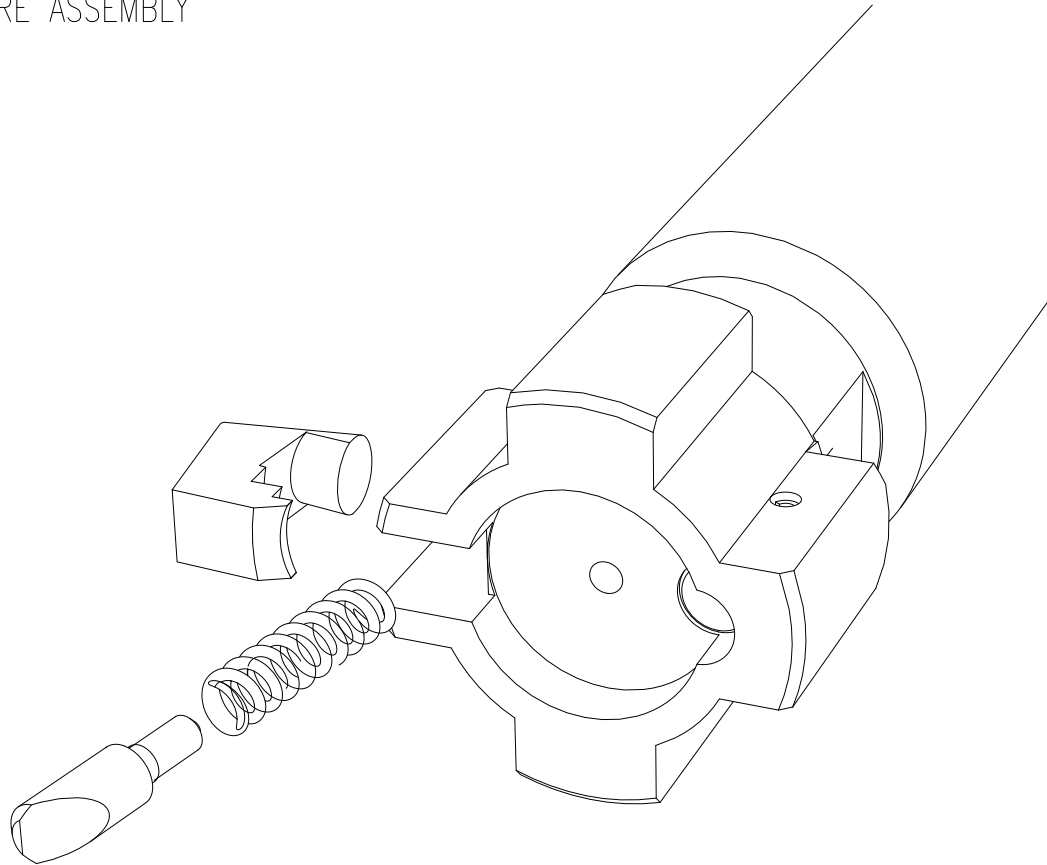
ALIGN EJECTOR SLOT TO PIN HOLE
AND SLIDE INTO BOLT FACE
USE PIN PUNCH TO TAP IN CROSS PIN

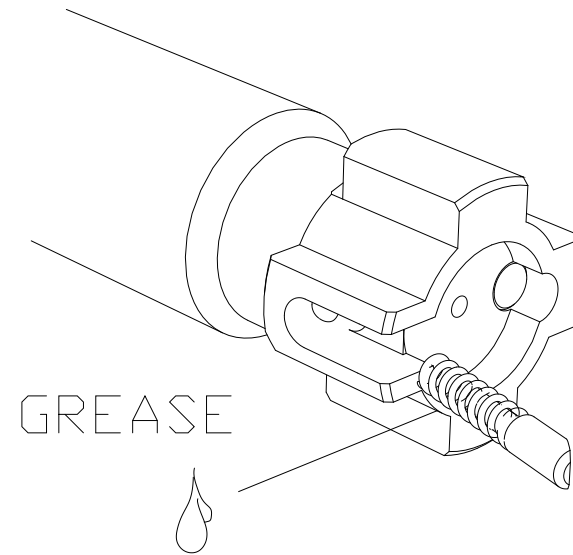
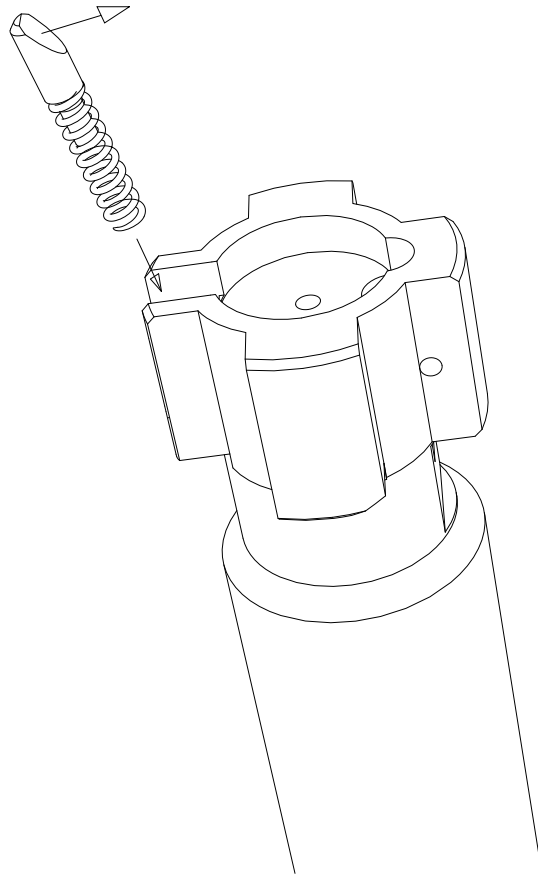


CHECK FOR FREE MOVEMENT



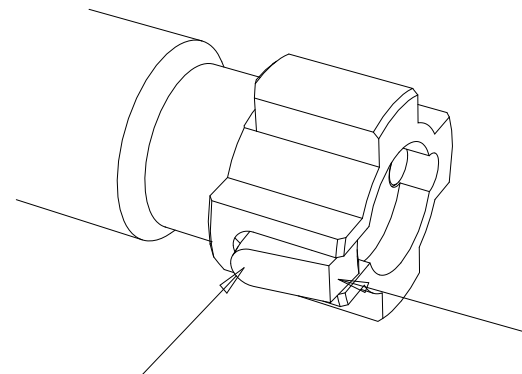
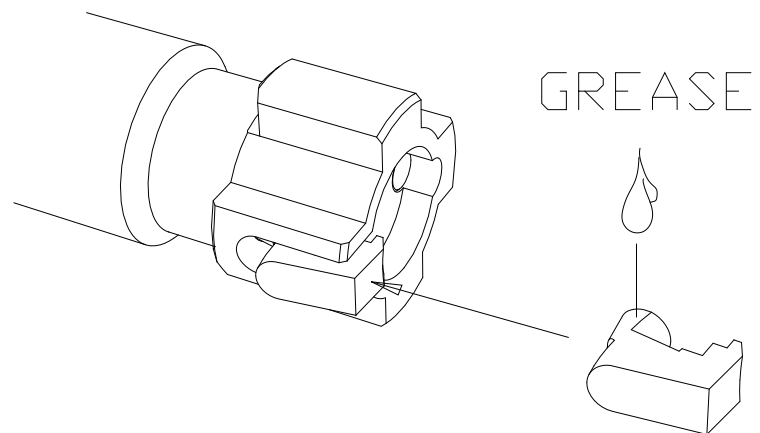
CHECK EXTRACTOR, EXTRACTOR PLUNGER AND
AND SPRING FOR FIT BEFORE ASSEMBLY





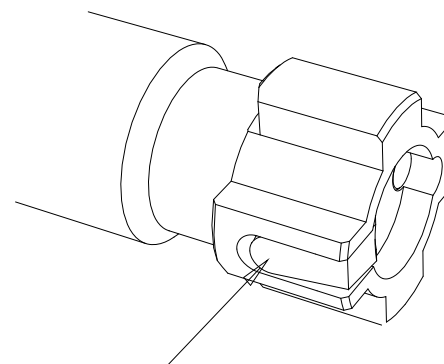
AFFIX SPRING TO PLUNGER AND DROP INTO PLACE.

ENSURE FLAT FACE ON PLUNGER IS INNERMOST



FITTING THE EXTRACTOR

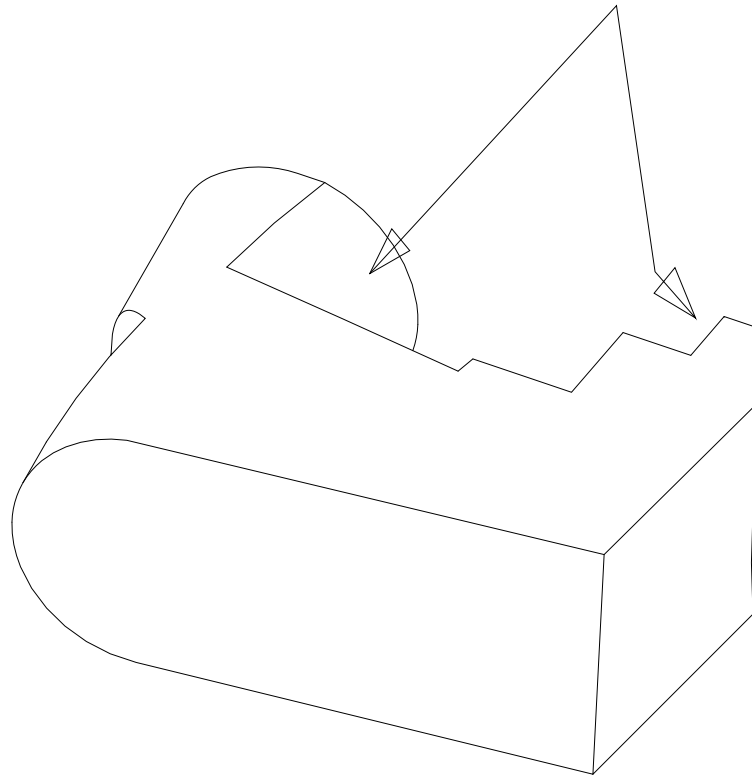
SLIDE THE EXTRACTOR ALONG THE SLOT IN THE BOLT HEAD TO DEPRESS THE PLUNGER. AT THE END OF ITS TRAVEL PUSH THE EXTRACTOR IN UNTIL IT CLICKS INTO PLACE.

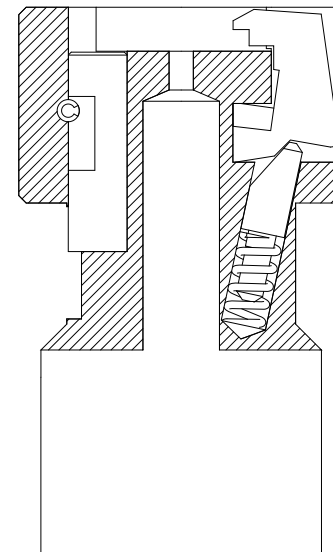
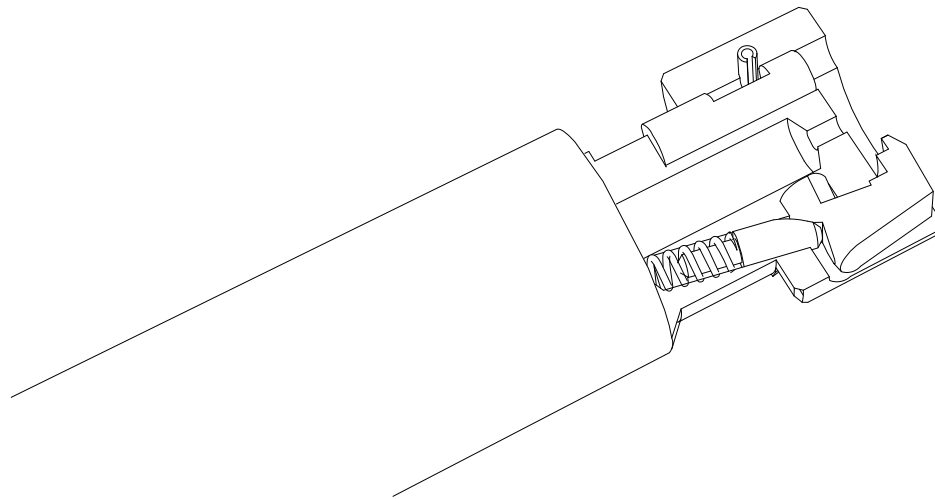


"CLICK"



IT MAY BE NECESSARY TO REMOVE MATERIAL FROM THE AREA MARKED TO ENSURE A FREE FIT OVER THE CASE.



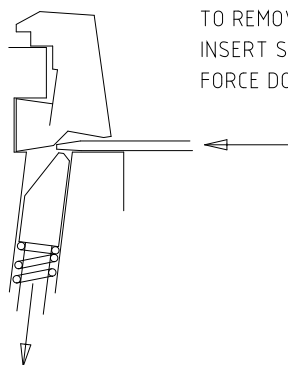


CUTOUT VIEW

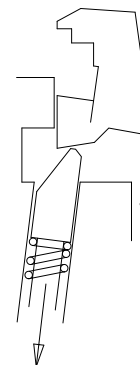
CUTOUT SHOWING POSITION OF EXTRACTOR,PLUNGER,SPRING,EJECTOR AND CROSS PIN WHEN FITTED CORRECTLY



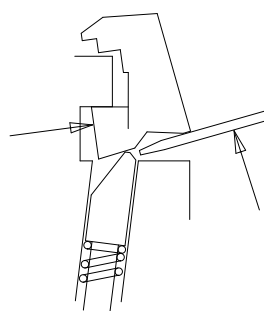
OVERVIEW



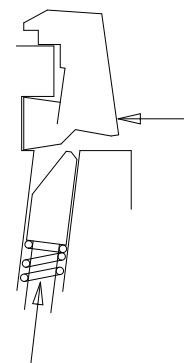
TO REMOVE:-
INSERT SMALL SCREWDRIVER TO
FORCE DOWN EXTRACTOR PLUNGER



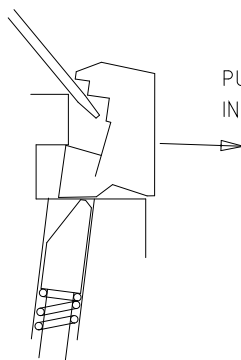
TO REFIT:-
PUSH EXTRACTOR DOWN TO DEPRESS
THE PLUNGER
N.B. LONG ANGLE OF THE PLUNGER
IS TO THE INSIDE



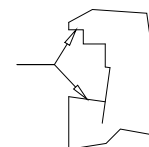
LEVER EXTRACTOR UPWARDS
SO THAT THE HEEL KEEPS THE
PLUNGER DEPRESSED



PUSH EXTRACTOR INWARDS UNTIL
PLUNGER CLICKS INTO PLACE



PUSH EXTRACTOR FROM THE
INSIDE UNTIL IT IS FREE

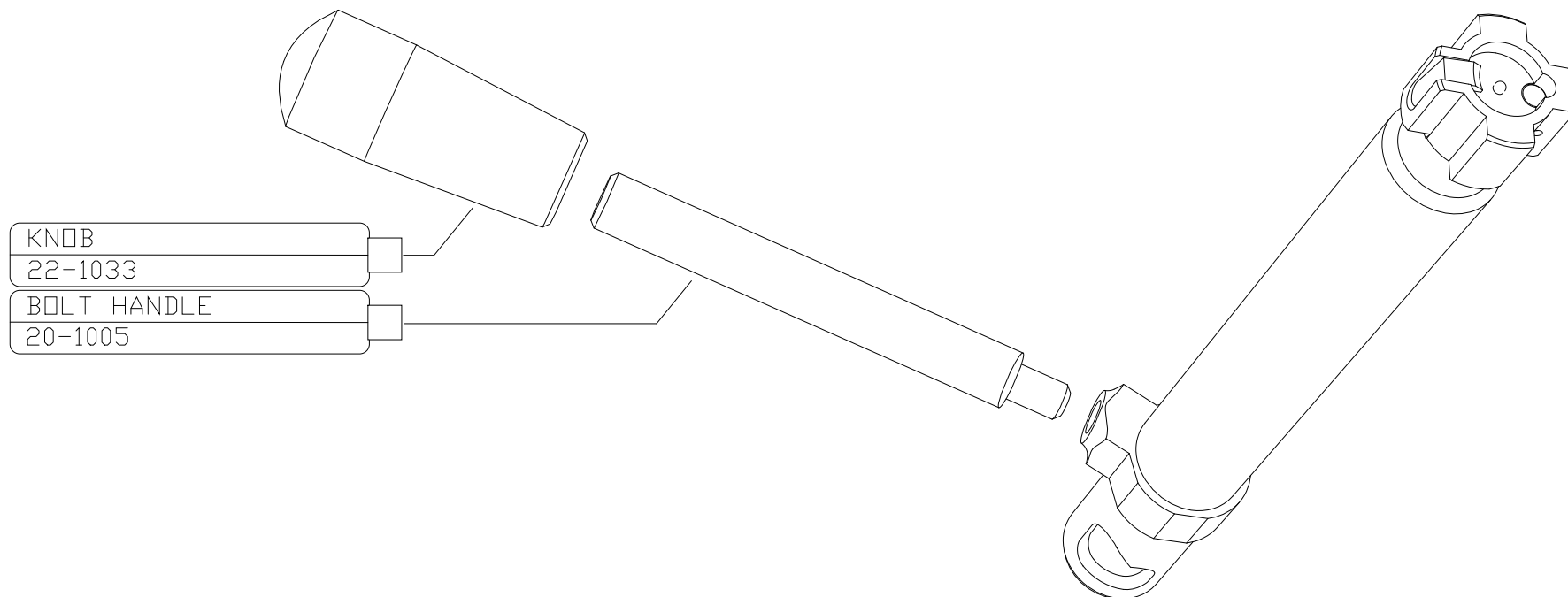


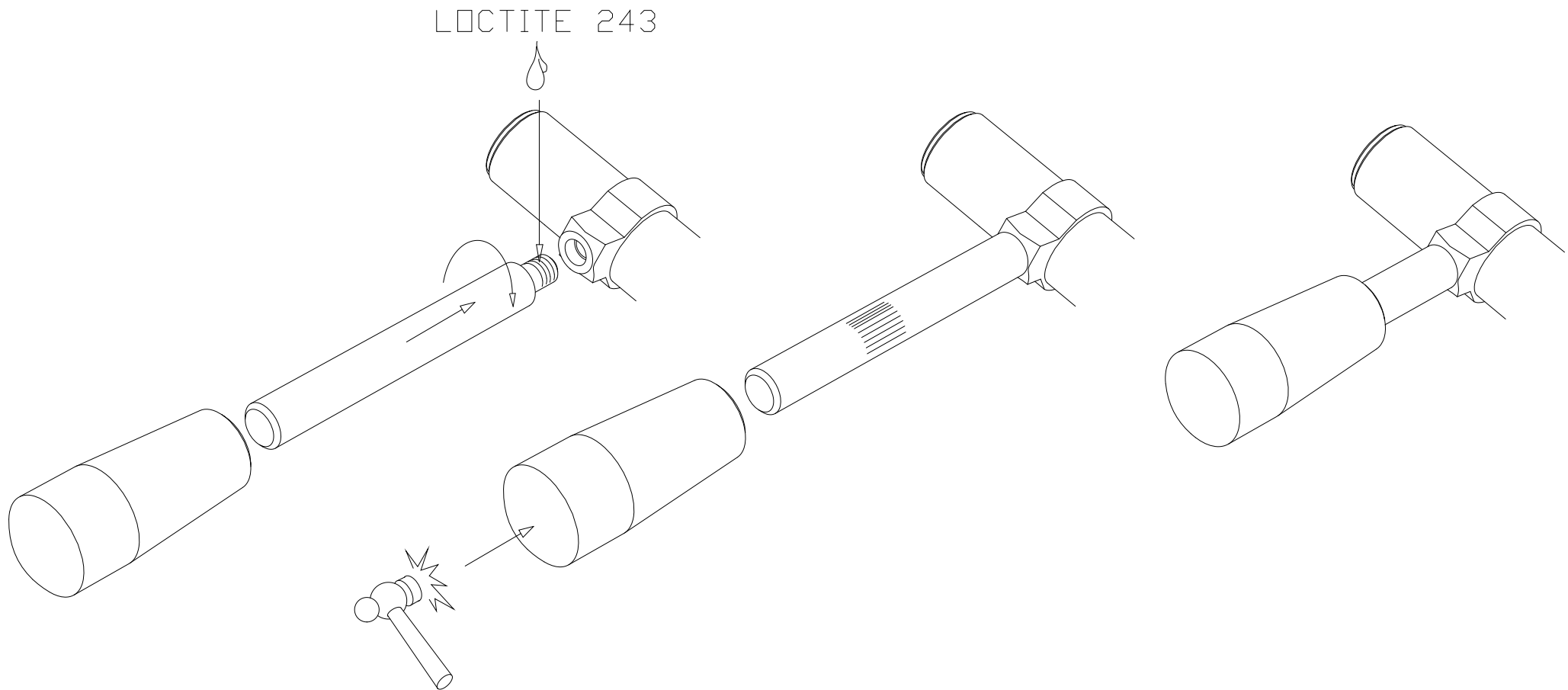
OWING TO THE VARIATIONS BETWEEN
SOME "WILD CAT" AMMUNITION YOU
MAY NEED TO REMOVE SOME MATERIAL
FROM AREAS SHOWN TO ENSURE
THAT THE CLAW RETURNS OVER THE
RIM OF THE CASE

ONLY A MINIMAL AMOUNT OF MATERIAL SHOULD BE REMOVED
TO MAINTAIN THE INTEGRITY OF THE EXTRACTOR, THIS CAN
EASILY BE REMOVED WITH A FINE NEEDLE FILE



CAUTION: IT IS ADVISED THAT THIS
WORK IS CARRIED OUT WITHIN
THE CONFINES OF A CLEAR PLASTIC
BAG TO AVOID LOOSING EITHER
THE EXTRACTOR, SPRING OR
PLUNGER

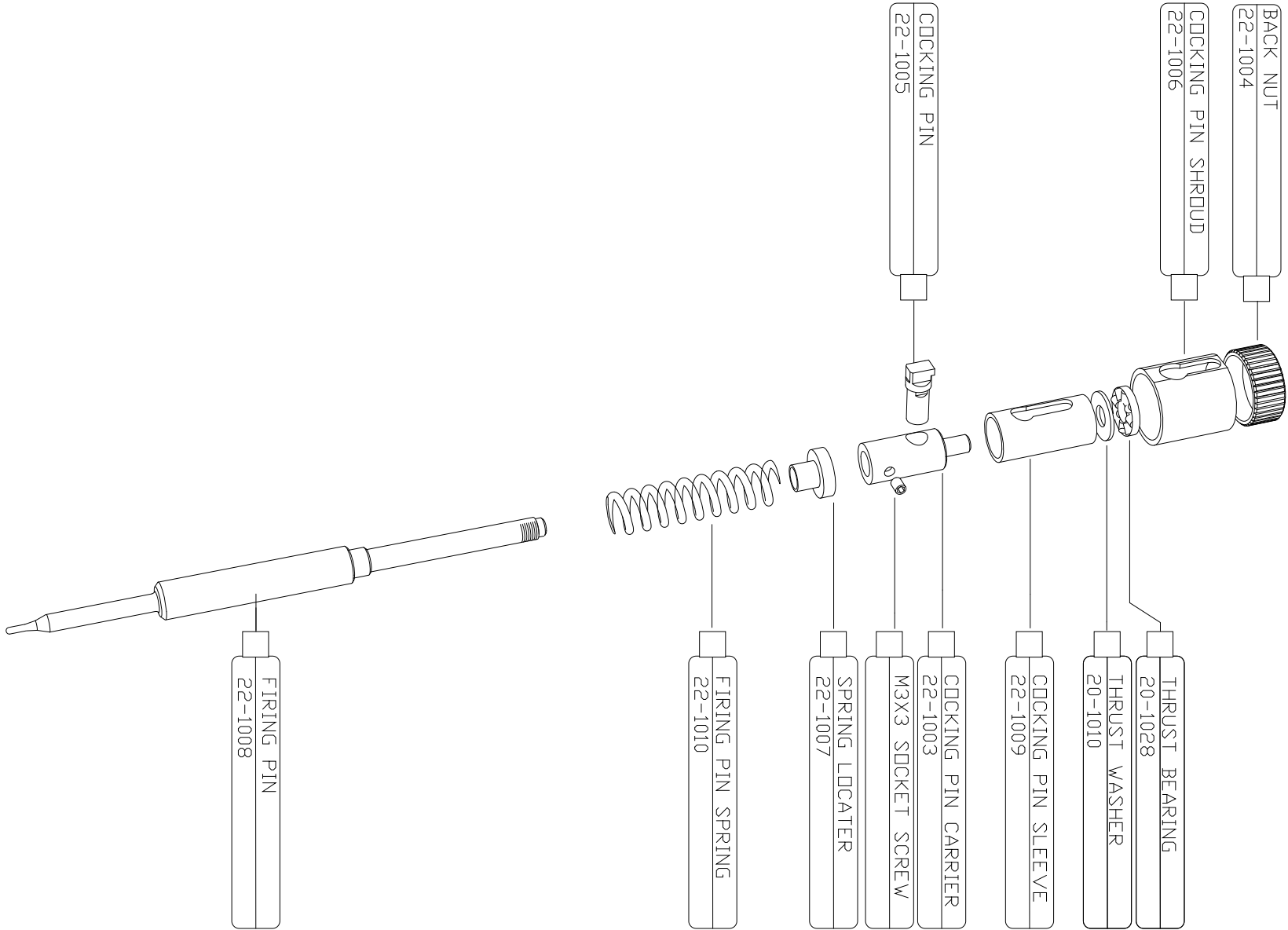


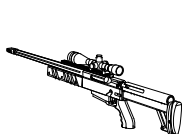


AFFIXING THE BOLT HANDLE

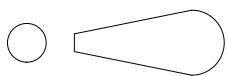
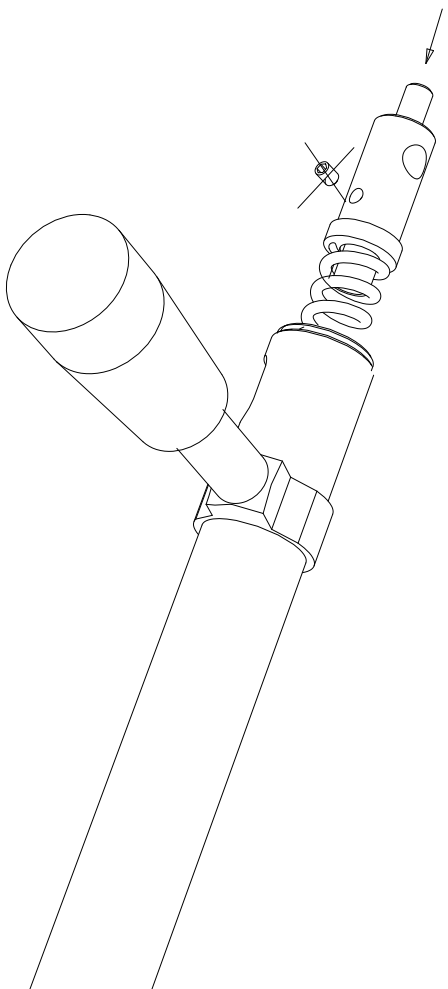
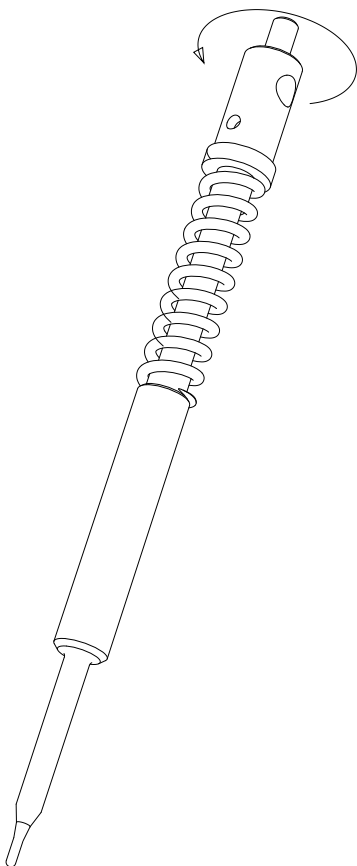
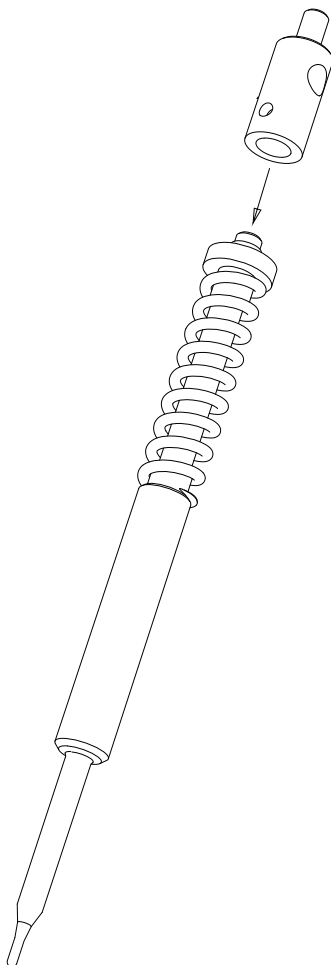
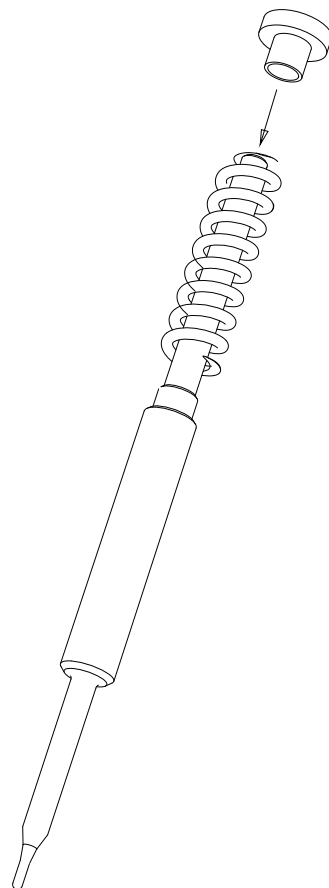
CLEAN THE BOLT HANDLE, APPLY STUDLOCK (LOCTITE 243) TO THE THREAD AND FASTEN SECURELY. TAP ON THE KNOB.

TO REMOVE THE BOLT HANDLE YOU WILL NEED TO HEAT THE GLUED PART UNTIL THE STUDLOCK BREAKS





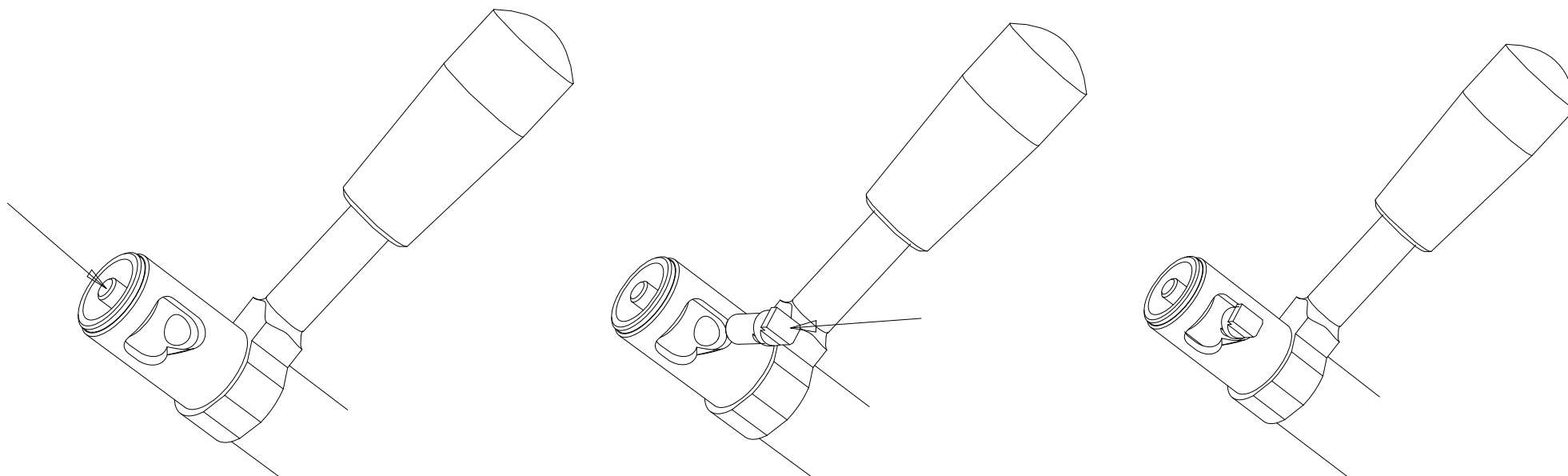
ASSEMBLE THE FIRING PIN



ASSEMBLE THE PARTS TOGETHER
DO NOT FIX COCKING PIN CARRIER INTO PLACE WITH SET SCREW UNTIL
IT HAS BEEN ADJUSTED CORRECTLY



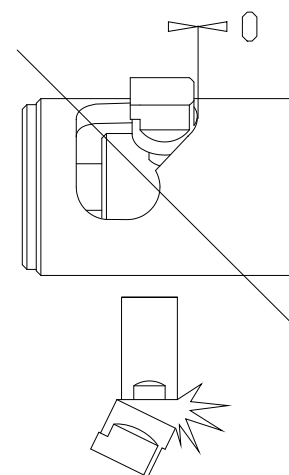
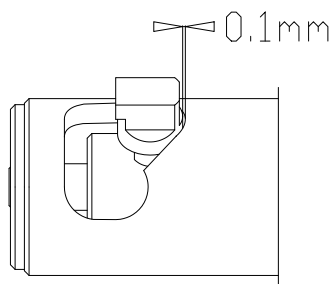
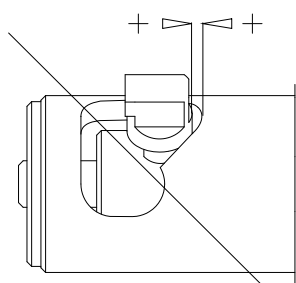
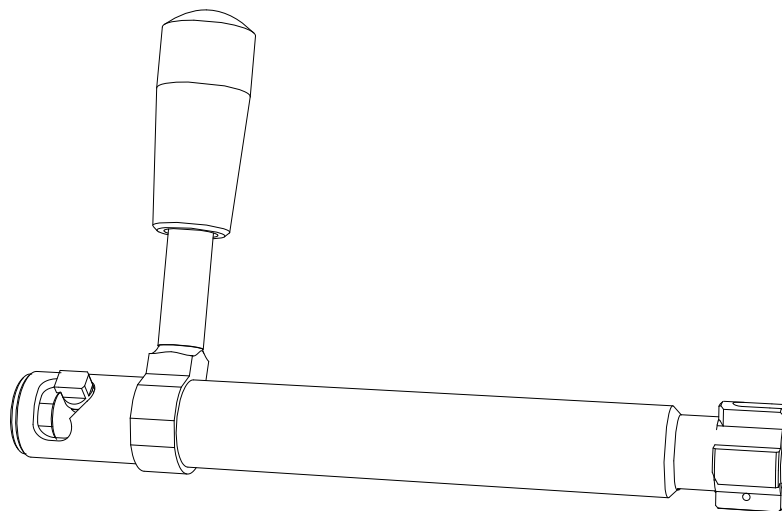
SETTING THE FIRING PIN



PLACE THE FIRING PIN ASSEMBLY INTO THE BOLT AND ALIGN THE COCKING PIN HOLE TO THE CAM.
INSERT THE COCKING PIN TO CHECK FOR CLEARANCE.



SETTING THE FIRING PIN

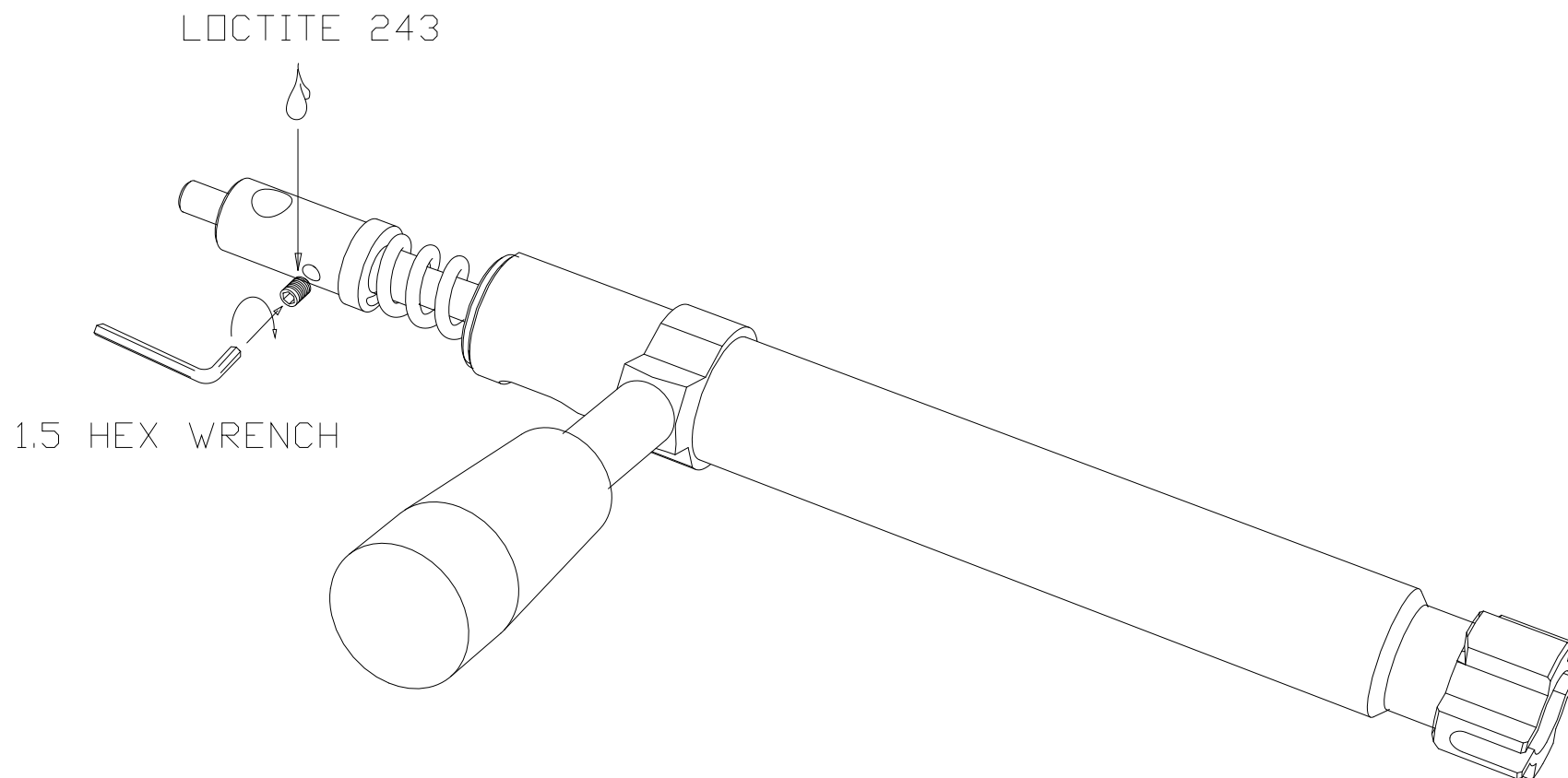


ADJUST THE COCKING PIN CARRIER UNTIL ONLY A VERY SMALL AMMOUNT OF CLEARANCE IS ATTAINED BETWEEN THE COCKING PIN AND THE CAM ON THE BOLT.

IF THIS IS SET WITH TOO MUCH CLEARANCE THERE IS A POSSABILITY THAT YOU WILL GET LIGHT STIKES WHEN THE WEAPON IS FIRED.
IF THIS IS SET WITH NO CLEARANCE (THE COCKING PIN HITS THE CAM WHEN FIRED) YOU MAY DAMAGE THE COCKING PIN.



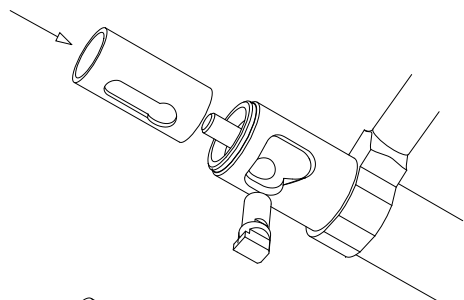
SETTING THE FIRING PIN



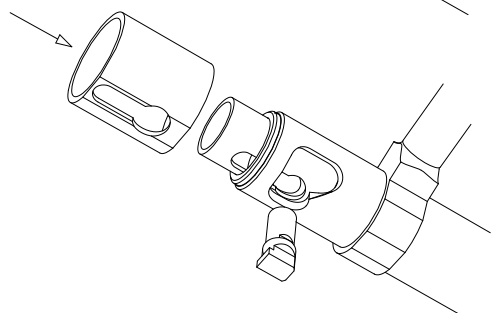
WHEN THE FIRING PIN HAS BEEN SET CORRECTLY, APPLY STUDLOCK TO THE SET SCREW AND SECURE THE COCKING PIN CARRIER INTO PLACE.



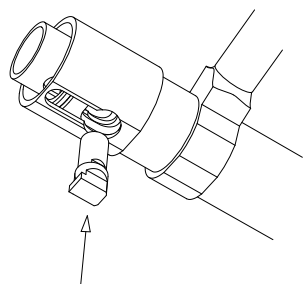
SETTING THE FIRING PIN



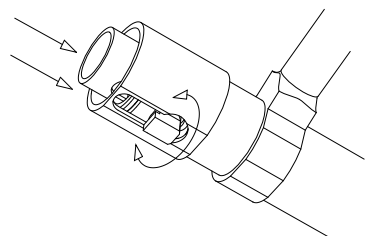
INSERT THE COCKING PIN SLEEVE AND
ALIGN THE KEY WAY



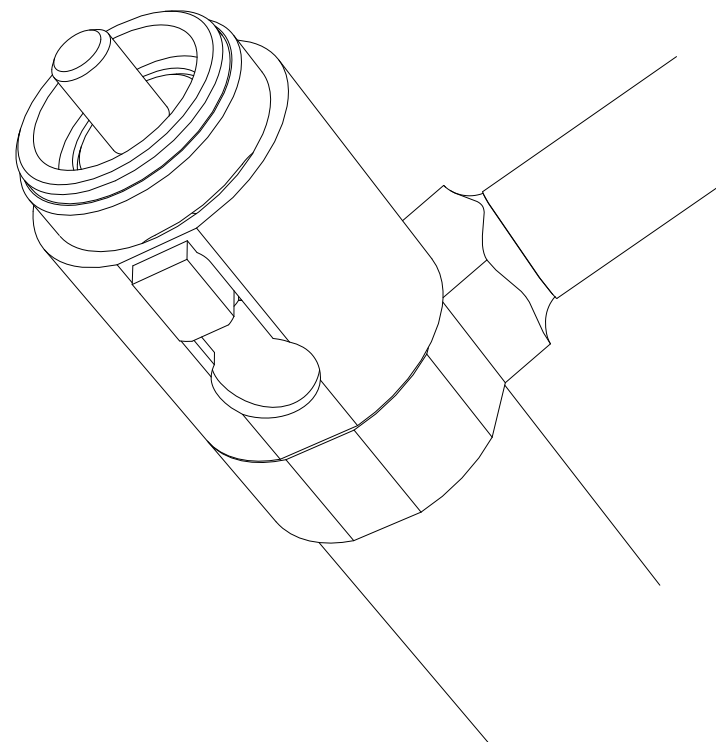
SLIDE OVER THE COCKING PIN SHROUD
AND ALIGN THE KEY WAY

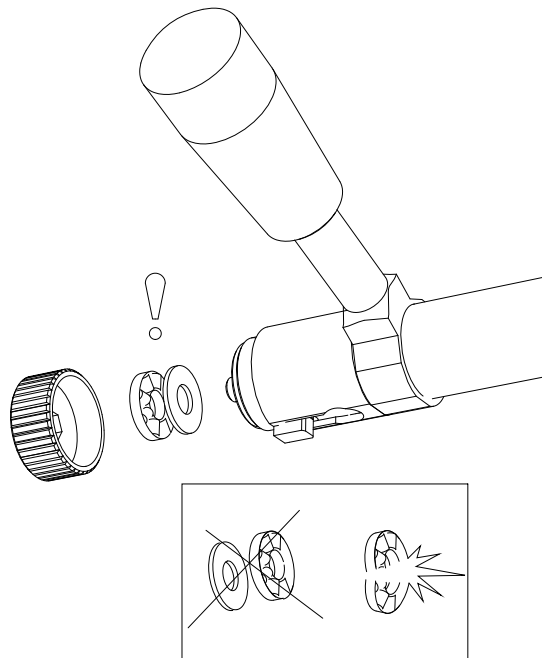


INSERT THE COCKING PIN WITH THE TAIL
TO THE REAR

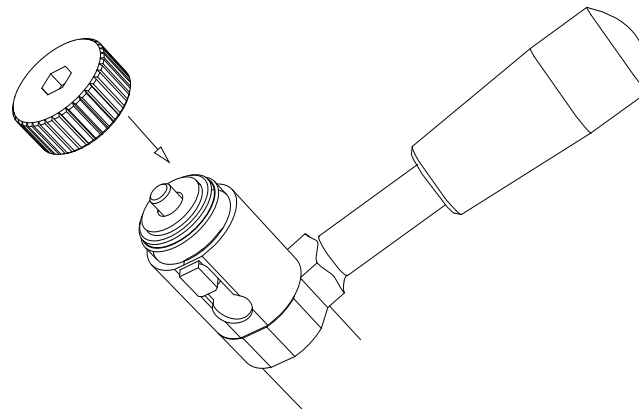


SLIDE IN THE COCKING PIN SLEEVE AND
SHROUD TO ARREST THE COCKING PIN

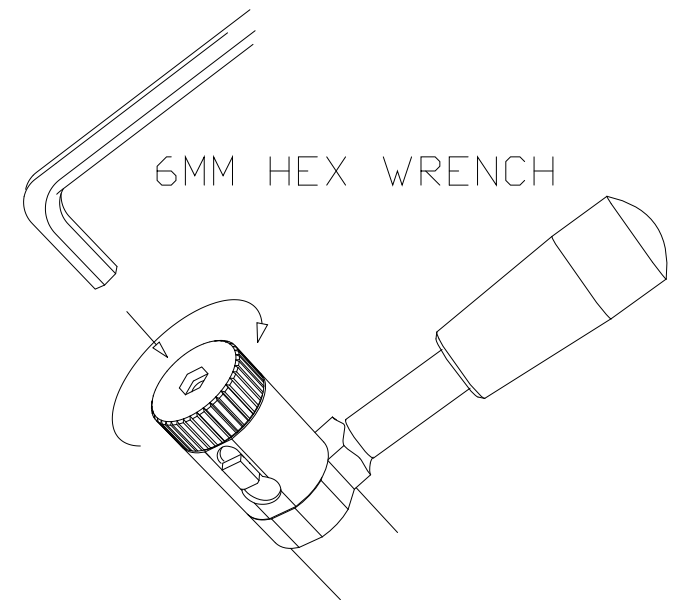




ENSURE THE THRUST BEARINGS ARE
INSERTED AS SHOWN OR DAMAGE
MAY OCCUR



ROTATE FIRING PIN ASSEMBLY TO
THE FIRE POSITION (DE-COCKED)
THEN AFFIX THE END CAP



SECURE TIGHTLY WITH 6MM WRENCH
RE-COCK THE BOLT BEFORE INSERTING
INTO THE RECEIVER

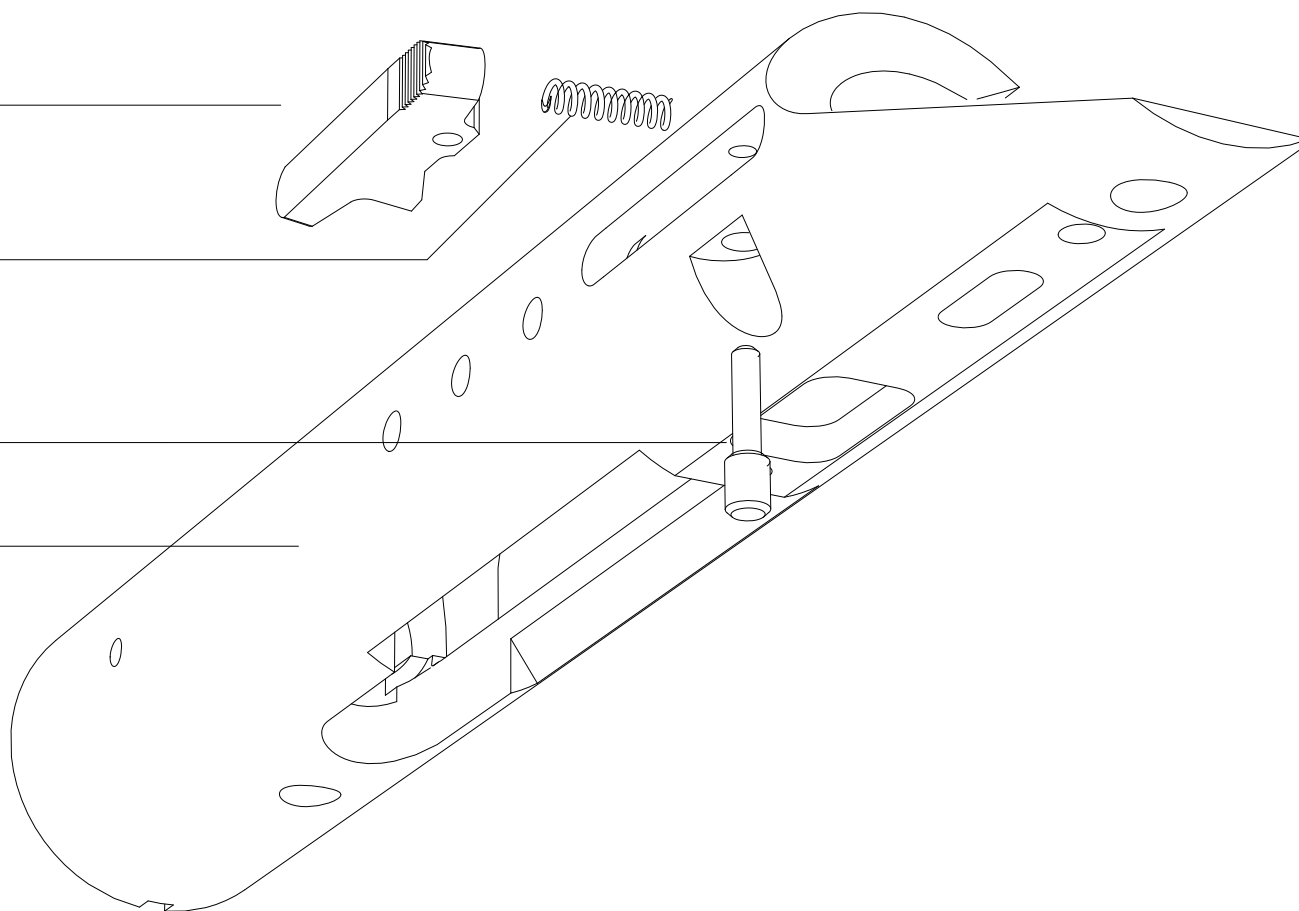


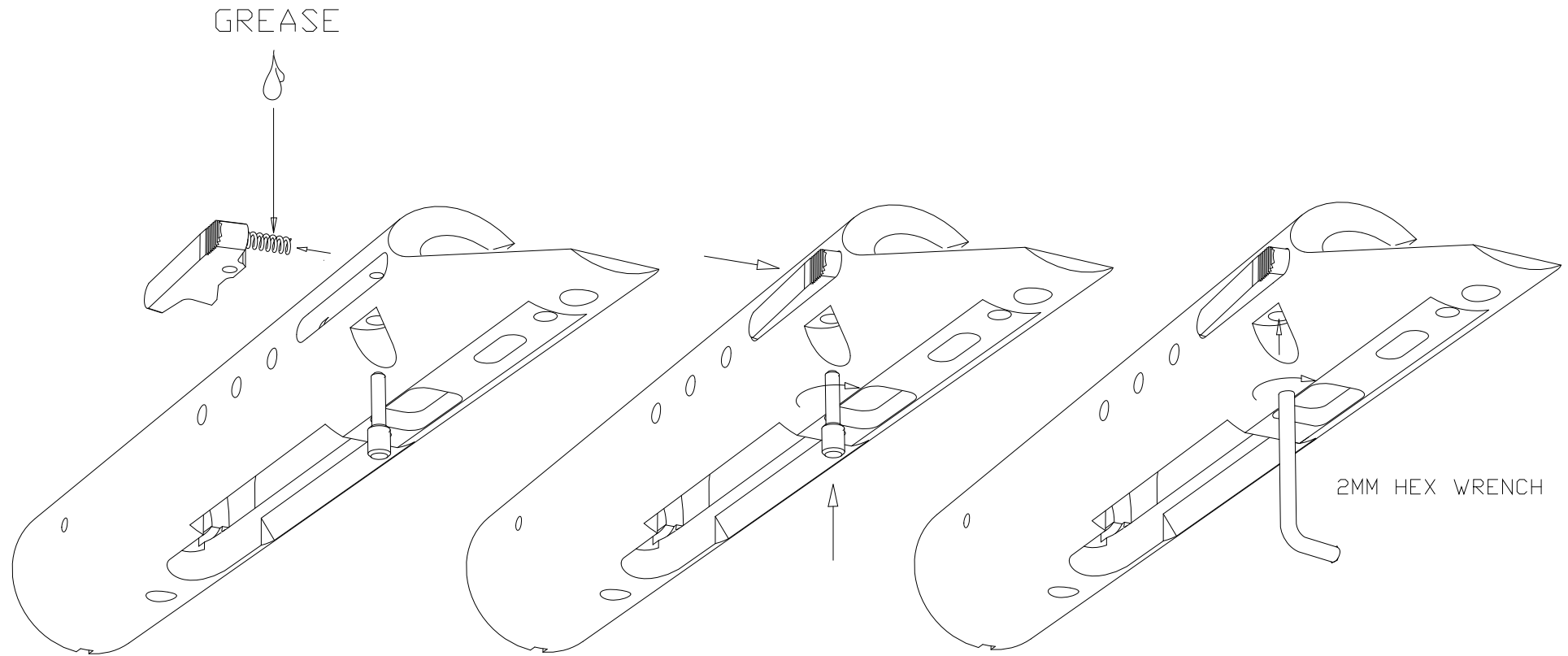
BOLT STOP
31-1010

BOLT STOP SPRING
20-1027

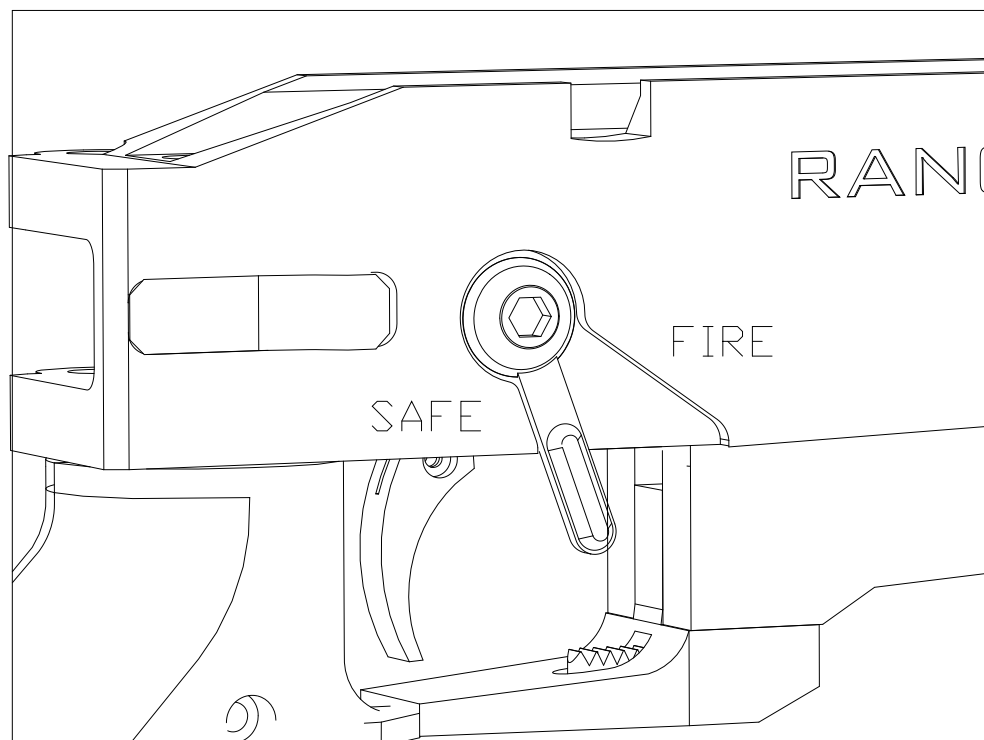
BOLT STOP SCREW
30-1010

ACTION BODY
31-1002

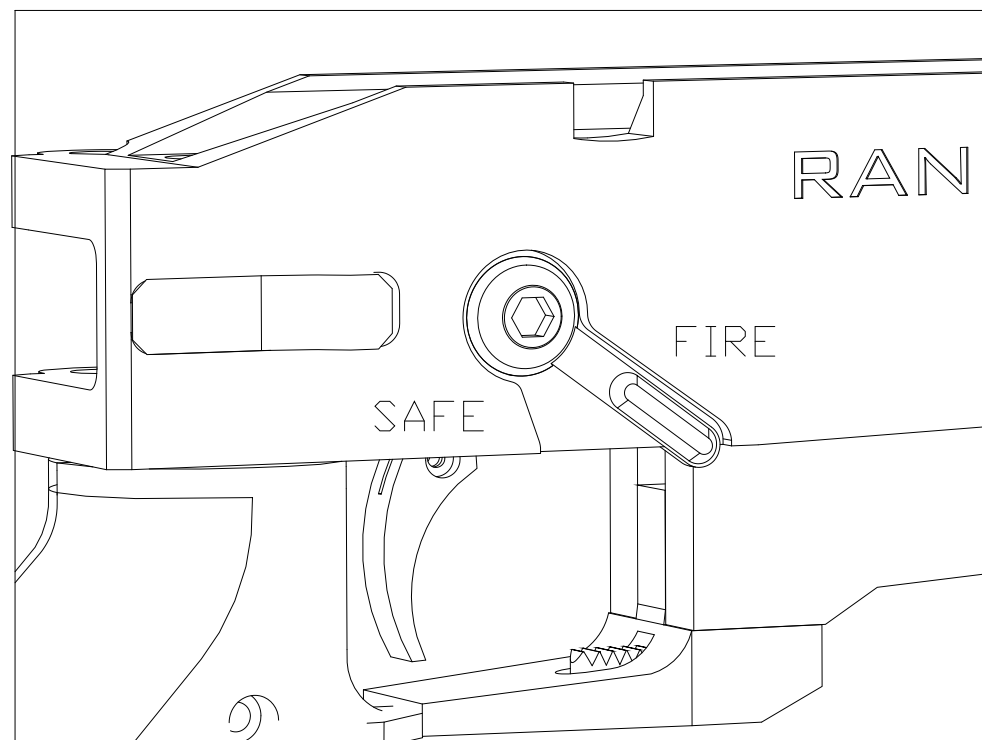




ASSEMBLE SPRING TO BOLT STOP. PLACE INTO BOLT STOP SLOT AND SECURE INTO PLACE



SAFETY ON



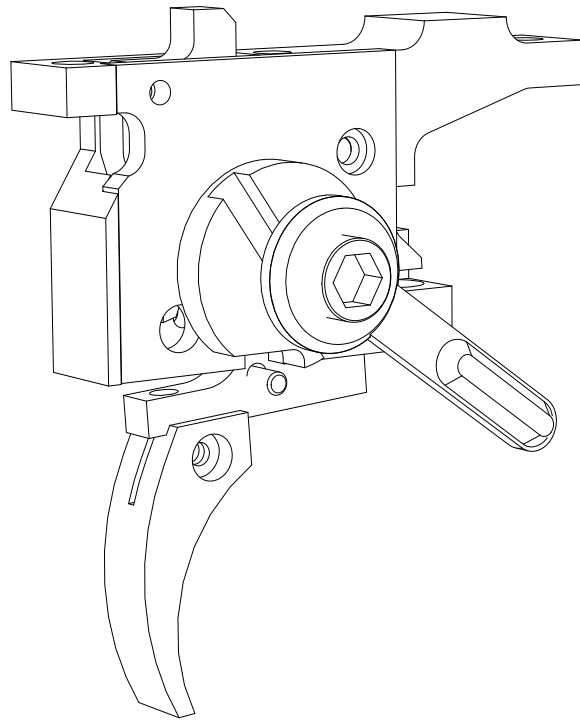
SAFETY OFF



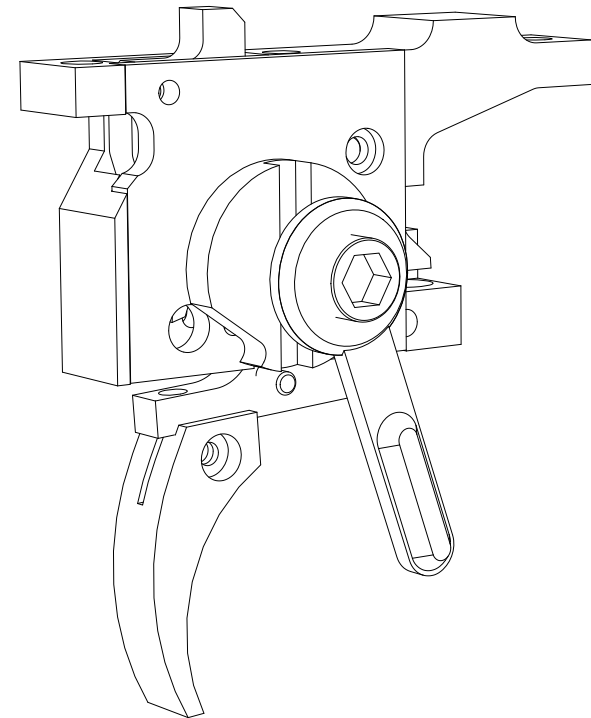
THE SAFETY ALSO ACTS AS A TRIGGER LOCK; THEREFORE, THE BOLT MUST BE IN A COCKED POSITION BEFORE APPLYING THE SAFETY.

APPLYING THE SAFETY AFTER THE WEAPON HAS BEEN FIRED AND BEFORE THE BOLT IS RE-COCKED MAY LOCK THE TRIGGER IN ITS FIRED STATE AND YOU WILL NOT BE ABLE TO LOAD THE FIRING PIN ON NEXT USE.

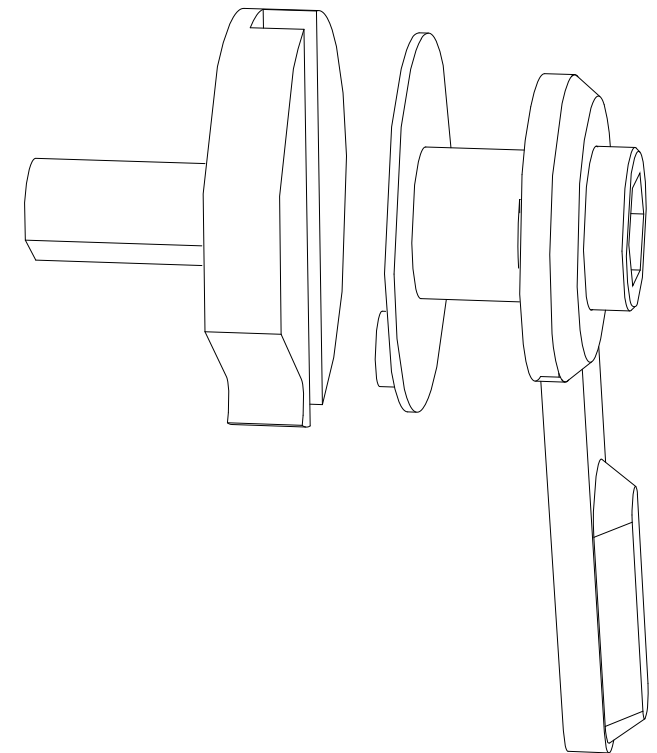
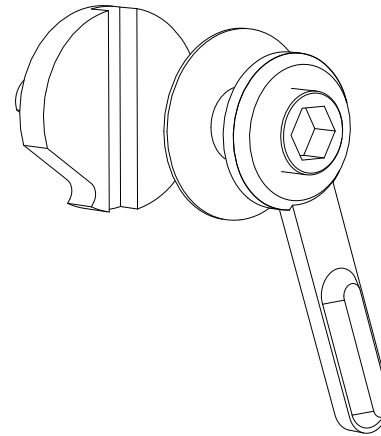
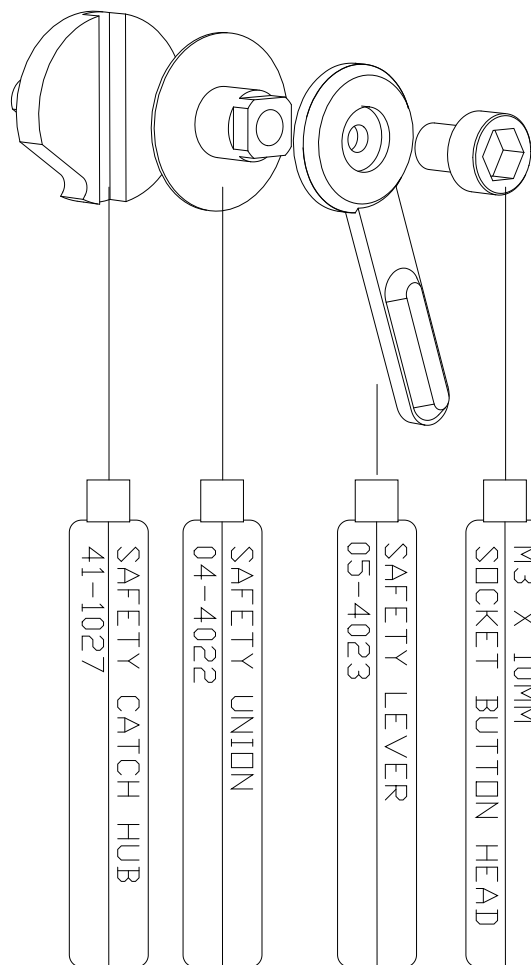
THIS MAY ALSO CAUSE DAMAGE TO THE TRIGGER!!



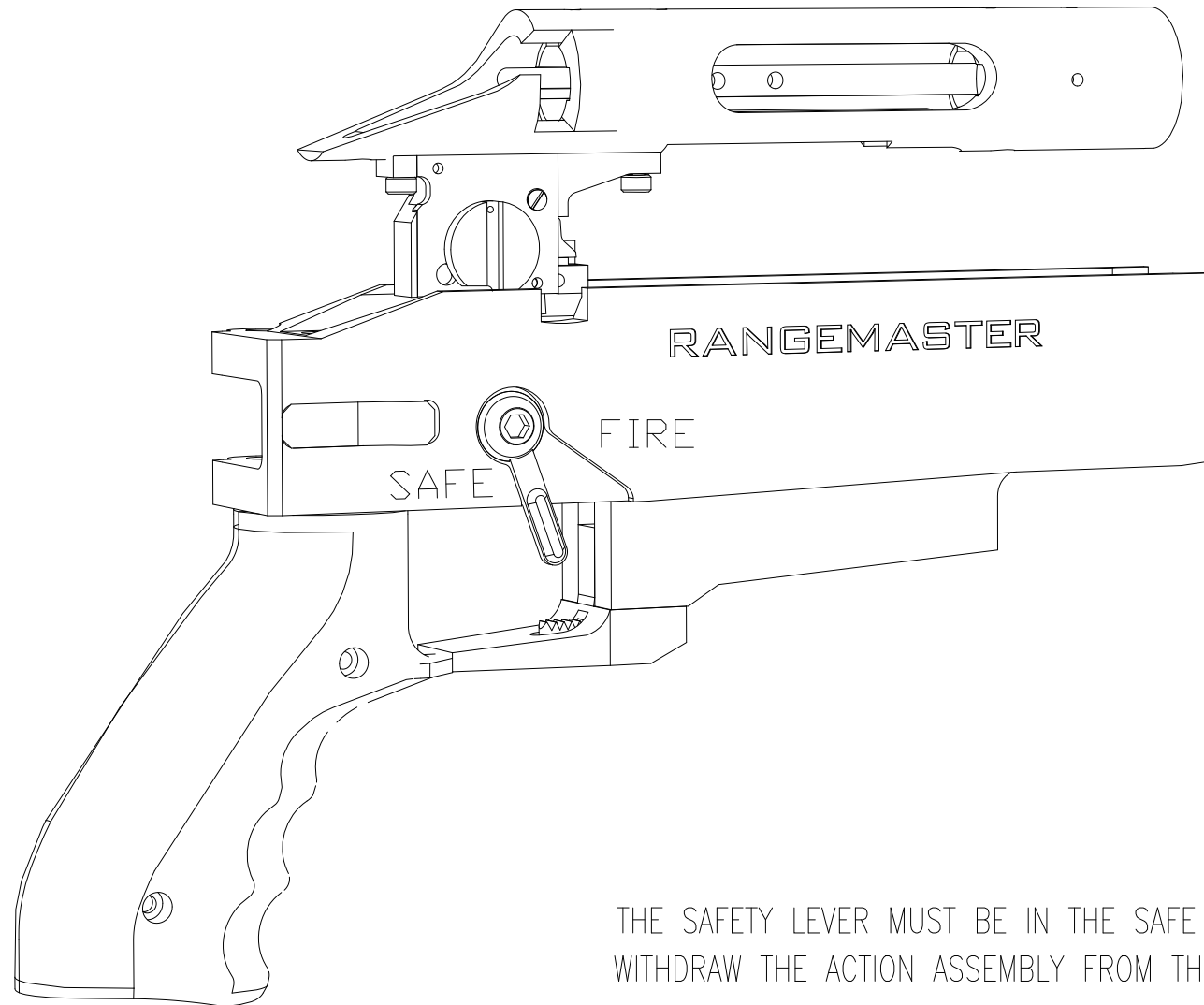
SAFETY OFF



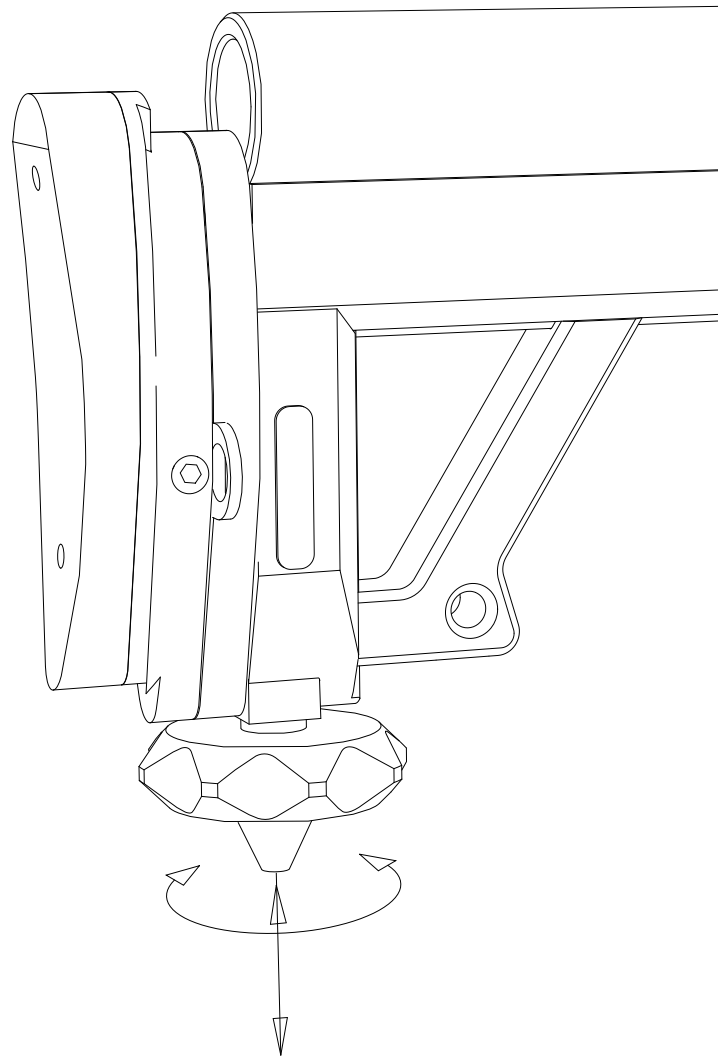
SAFETY ON



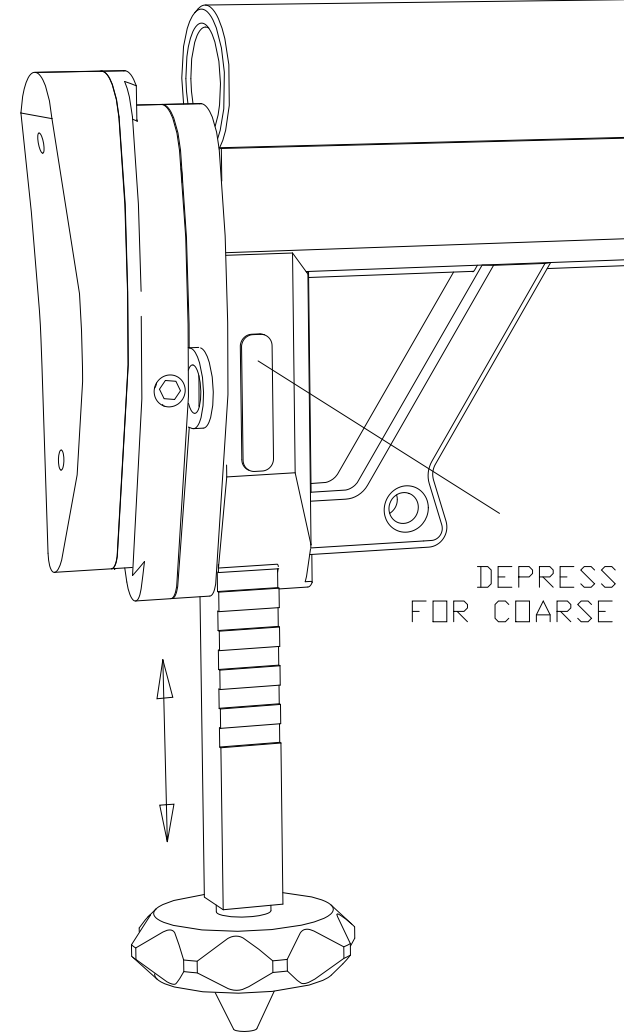
RELATIONSHIP BETWEEN SAFETY LEVER
AND UNION TO TRIGGER SAFETY HUB



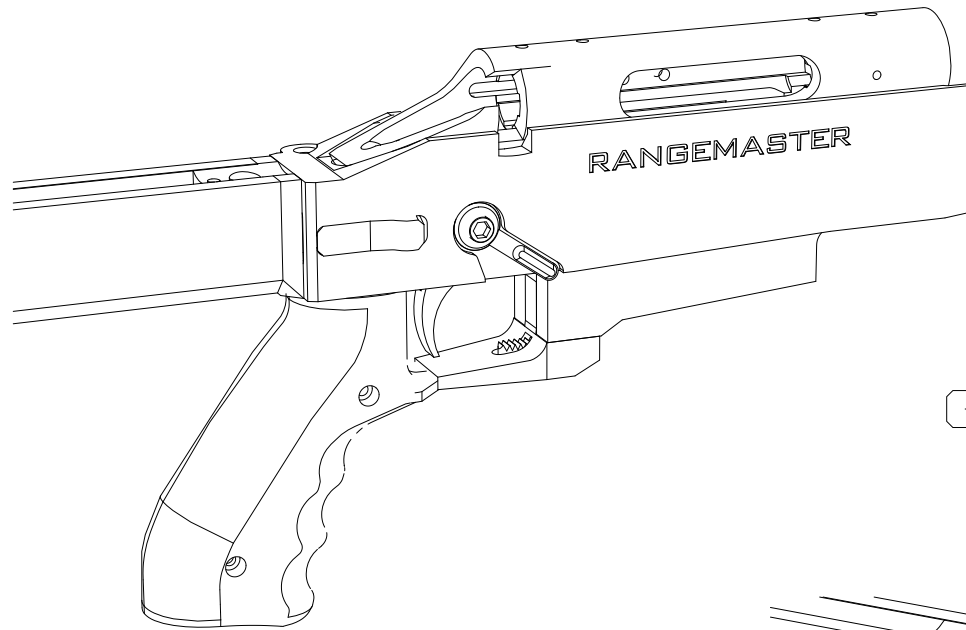
THE SAFETY LEVER MUST BE IN THE SAFE POSITION BEFORE YOU CAN
WITHDRAW THE ACTION ASSEMBLY FROM THE CHASSIS



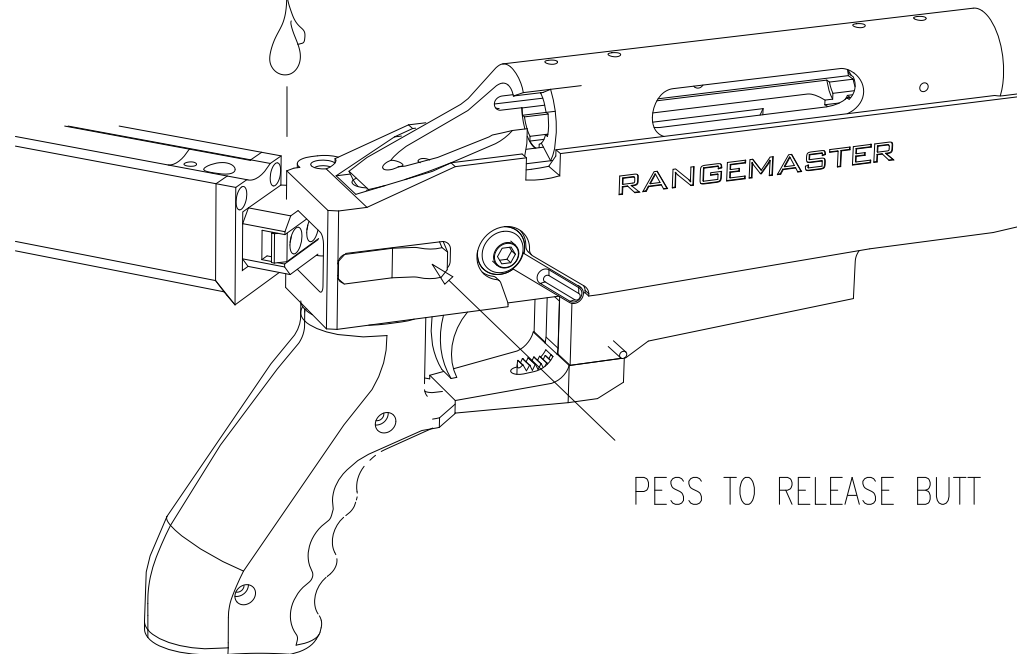
ROTATE KNOB
FOR FINE ADJUSTMENT



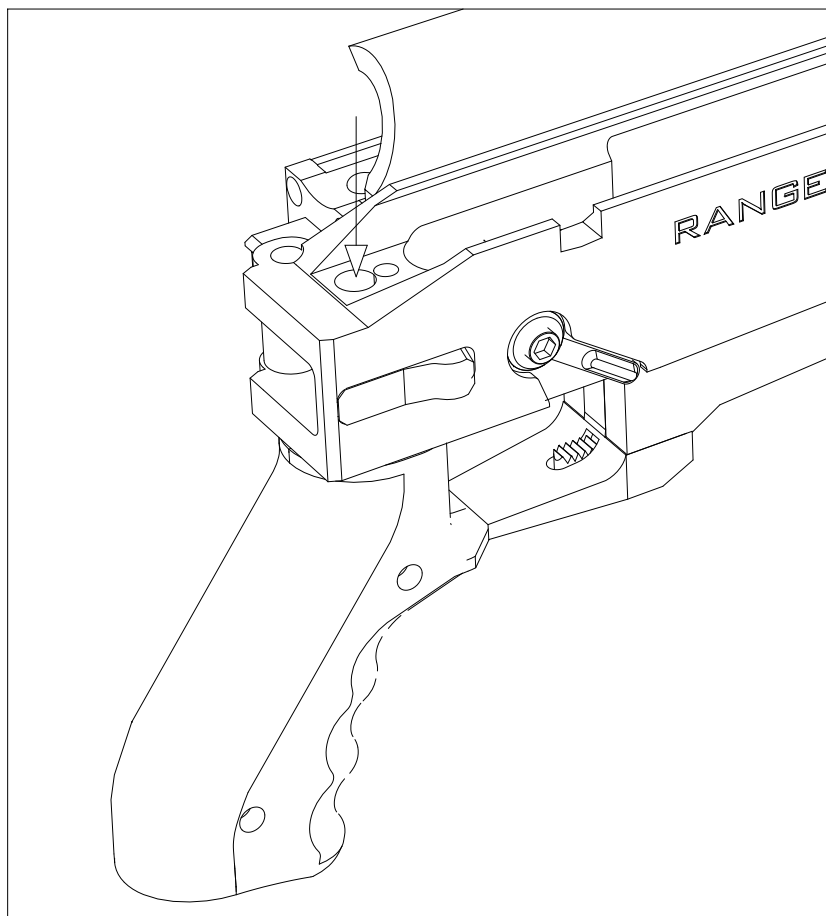
DEPRESS LEVER
FOR COARSE ADJUSTMENT



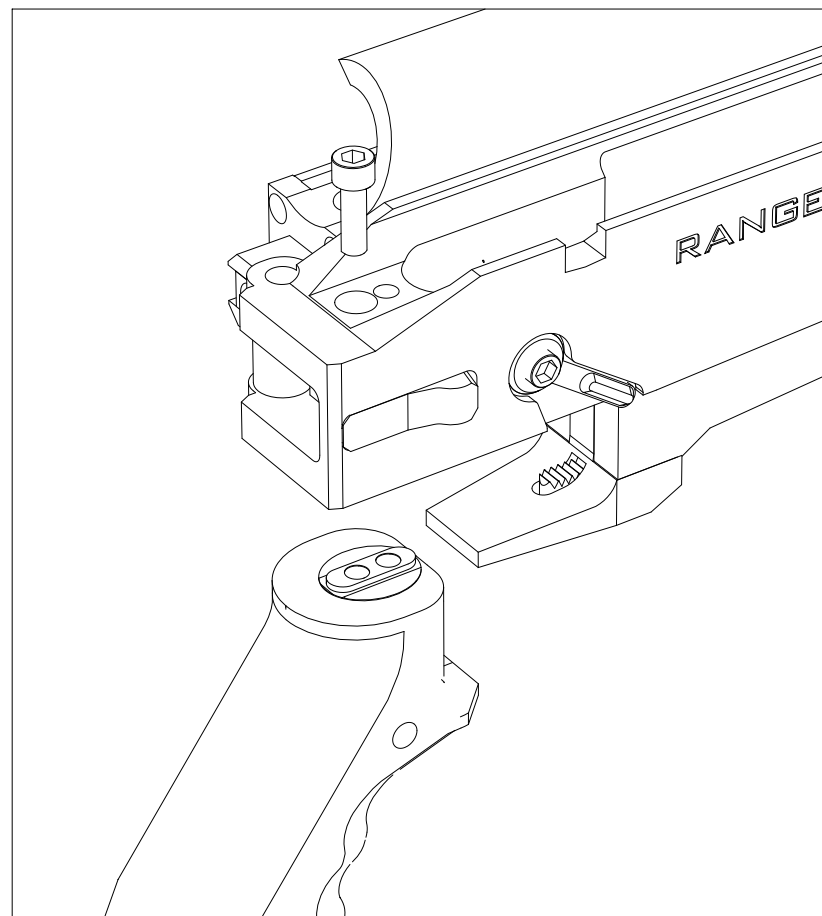
GREASE



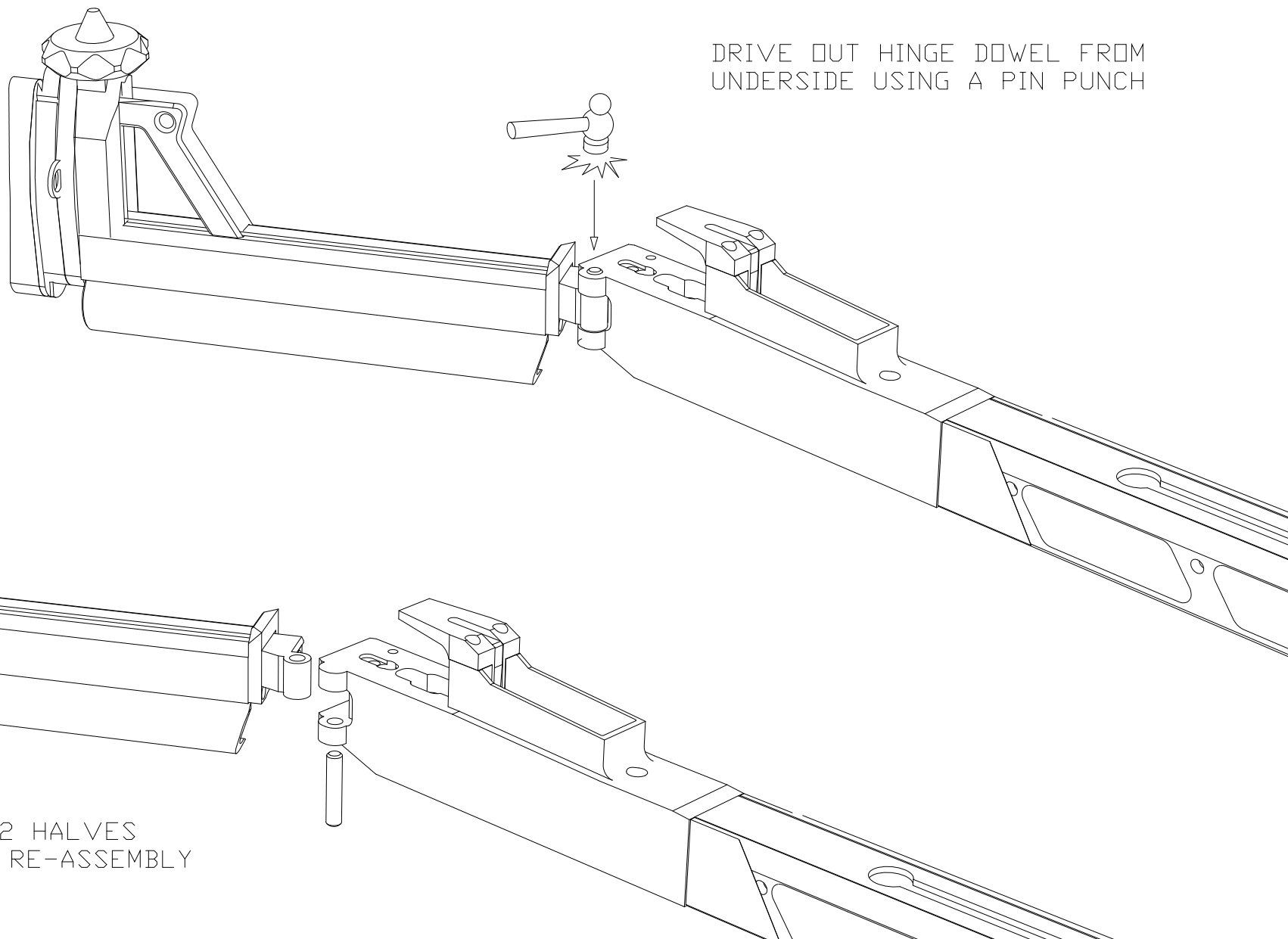
PRESS TO RELEASE BUTT



REMOVE BARRELED ACTION TO
ACCESS GRIP RETAINING SCREW

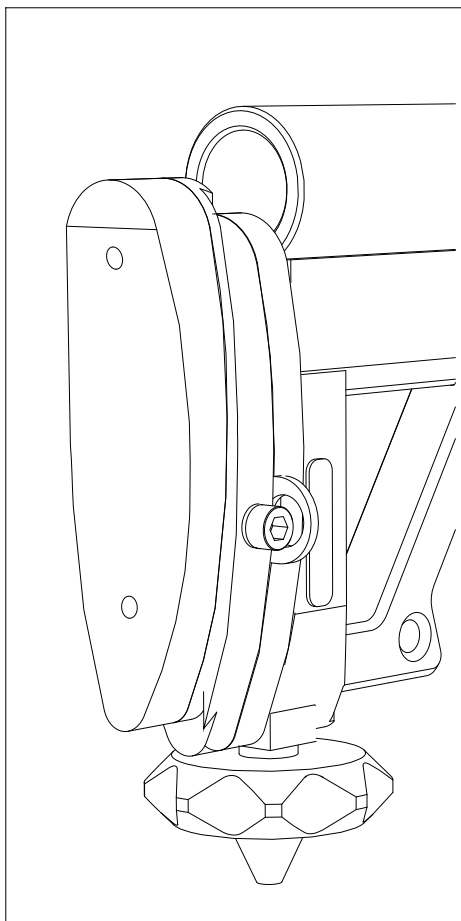


UNDO SCREW TO RELEASE
GRIP ASSEMBLY

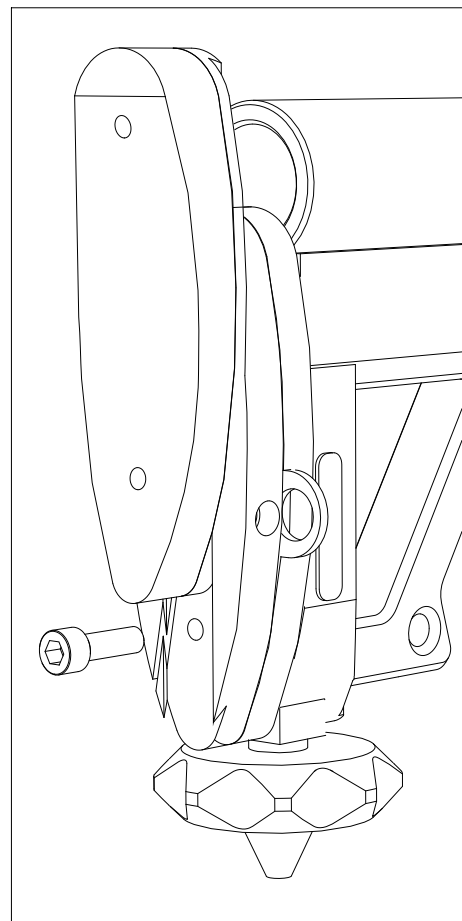


DRIVE OUT HINGE DOWEL FROM
UNDERSIDE USING A PIN PUNCH

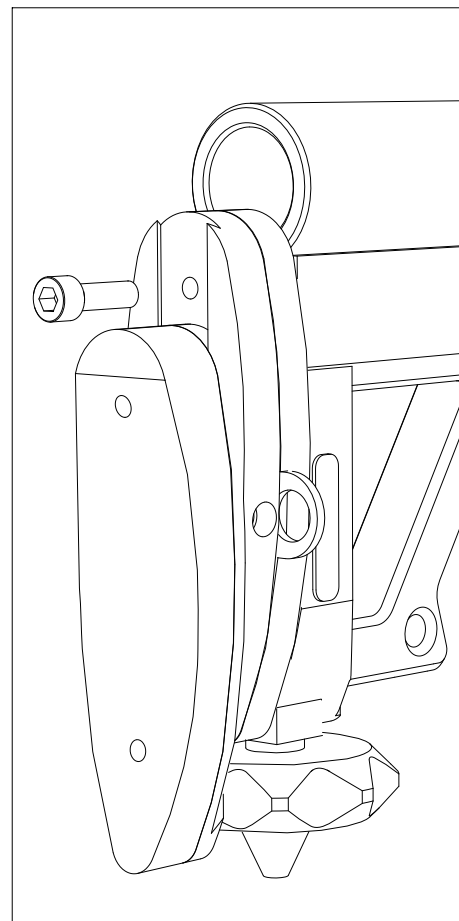
PULL STOCK INTO 2 HALVES
GREASE DOWEL ON RE-ASSEMBLY



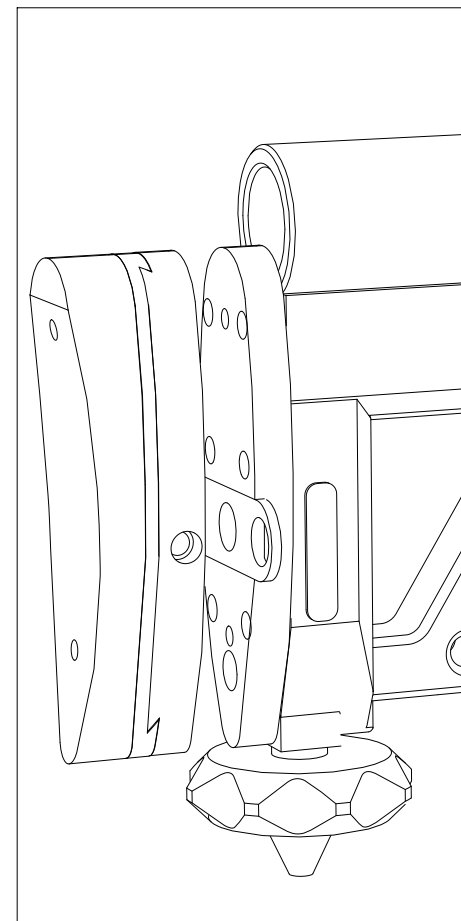
REMOVE CLAMP
SCREW



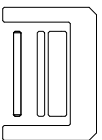
LIFT UP PLATE
TO REMOVE LOWER
SCREW



LOWER PLATE
TO REMOVE UPPER
SCREW



REMOVE ASSY
FROM BUTT



③

ANOTHER THRUST WASHER MAY BE ADDED HERE IF THIS IS SUCCESSFUL. YOU CAN INSERT THIS EXTRA WASHER INTO THE FIRING PIN ASSEMBLY WHERE MARKED. IT IS ESSENTIAL THAT THE ROLLER BEARING SITS AGAINST CAP FACE

②

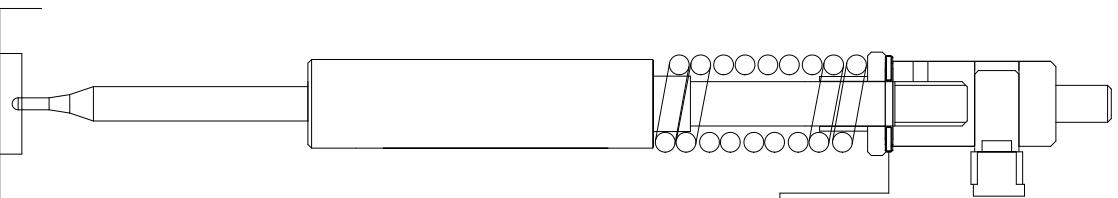
THE COCKING PIN CAN BE ROTATED 180° TO MAKE LONG EDGE FACE FORWARD. THIS WILL INCREASE SPRING PRESSURE AND GIVE A LONGER DROP. THIS MAY MAKE THE BOLT FEEL “CLUNKY” TO CLOSE. IF THIS IS NOT ACCEPTABLE, ADDING AN EXTRA WASHER SHOULD CURE THE PROBLEM (SEE ABOVE)

THRUST WASHERS MAY BE USED HERE TO INCREASE SPRING PRESSURE (SEE 3)

PLEASE REFER TO ASSEMBLY DRAWINGS WHEN DISSASSEMBLING FIRING PIN MECHANISM

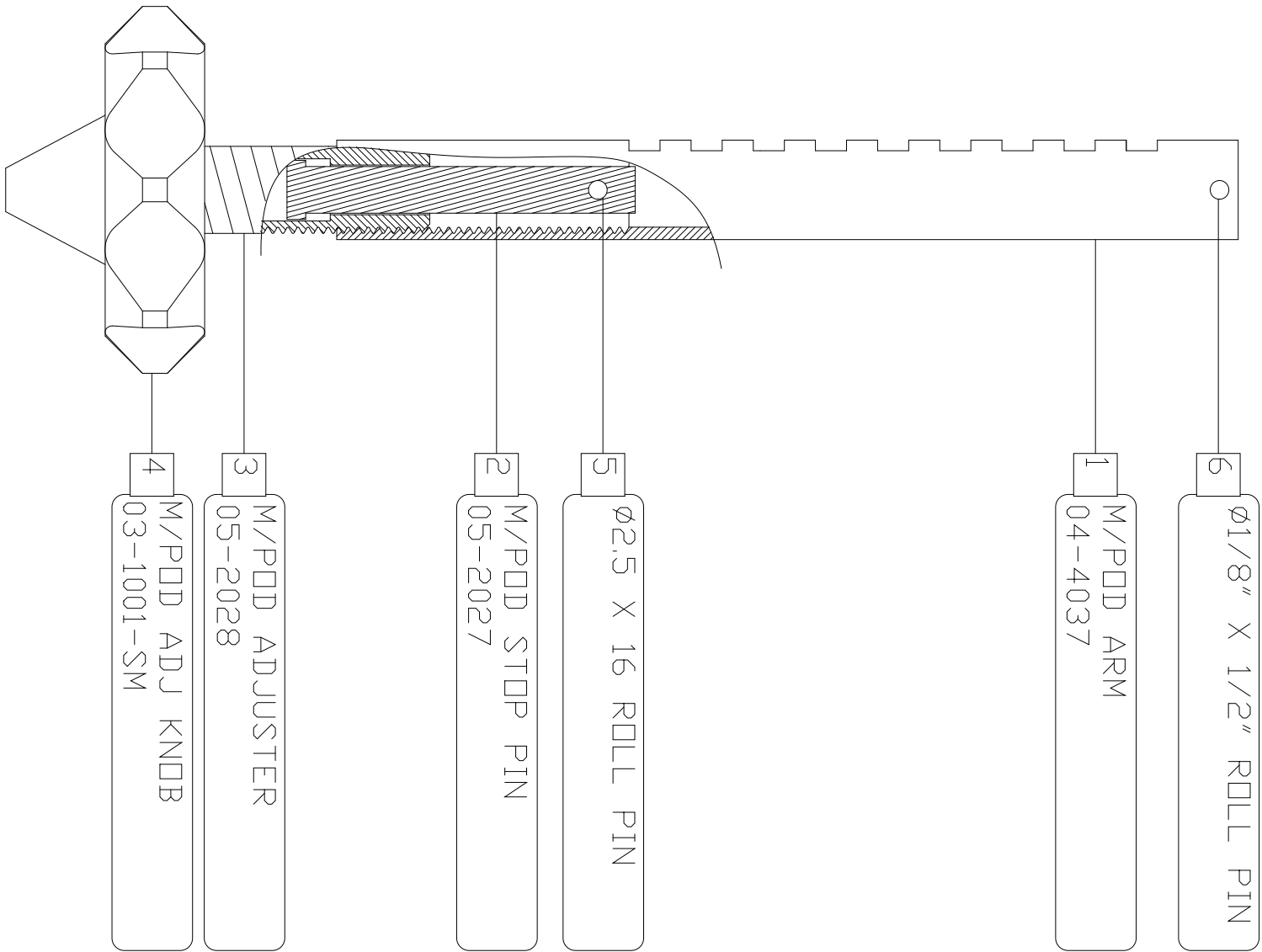
①

EXCESSIVE GREASE OR OIL IN THIS AREA CAN CAUSE “PISTONING”, THUS SLOWING THE LOCK TIME AND COULD CAUSE LIGHT STRIKES. CLEAN AND REPLACE. ENSURE FREE RUNNING OF FIRING PIN ASSEMBLY WITHIN BOLT TUBE WHEN RE ASSEMBLING. APPLY LUBRICATION ACCORDING TO LUBRICATION DRAWING



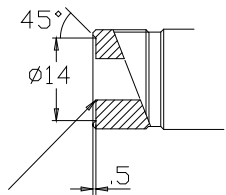
N.B. THE REAR COLLAR IS HELD IN PLACE USING M3 SOCKET SET SCREWS AND LOCTITE STUDLOCK, THEREFORE YOU MAY HAVE TO BOIL TO RELEASE.

MONOPOD ARM ASSEMBLY

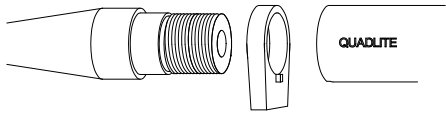
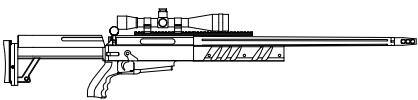


ALL DIMENSIONS IN mm

SCRAP VIEW OF CROWN



45° BREAK TO .1mm ABOVE MAJOR DIA
MUST BE CLEAN, CONCENTRIC AND BURR FREE

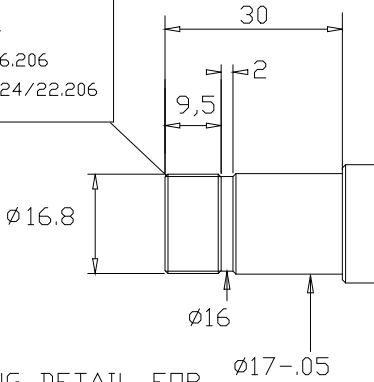


DO NOT SCALE

| Rev | Date | Description | Dr'n | Ch'kd | App'd |
|-----|----------|-------------------------|------|-------|-------|
| 1 | 11.02.05 | RE DRAWN | EL | | |
| 2 | 11.07.05 | DRAWING ERROR RECTIFIED | EL | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

NOTES:
HEADSPACE PROTRUSION
12mm CASES @ 3.175mm±.025
11mm CASES @ 3.175mm±.025
9.5mm CASES @ 2.745mm±.025

M17 X 1mm PITCH
MAJOR 16.974/16.794
EFFECTIVE 16.324/16.206
EFF OVER PAR 22.324/22.206

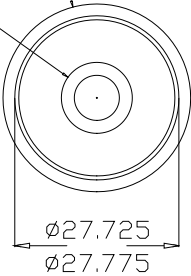


THREADING DETAIL FOR
RPA MUZZLE BRAKE OR SUPPRESSOR

U/CUT 2.5 WIDE
TO CORE DIA
GO GAUGE
HEADSPACE PROTRUSION
SEE NOTE

1 1/16" X 16 TPI UN - 2A
MAJOR 26.949/26.710
EFFECTIVE 25.918/25.791
EFF OVER PAR 32.268/32.141
BARREL THREAD SHOULD
NOT BE A TIGHT FIT.
LOCATION IS ACHIEVED
BY SPIGOT ON BARREL TO
C/BORE IN RECIEVER

1.5 RAD ABOUT
CHAMBER
Ø32 STOCK



SPIGOT DIAMETER

THIS DIMENSION INCLUDES A MACHINING ALLOWANCE:

DO NOT BE TEMPTED TO MAKE YOUR HEADSPACE TOO TIGHT..REMEMBER YOUR
SHOOTING ENVIROMENT,DIRT,DUST,TEMPERATURE,VARNISHED CASES AND
VARIATIONS IN AMMUNITION DIMENSIONAL ACCURACY

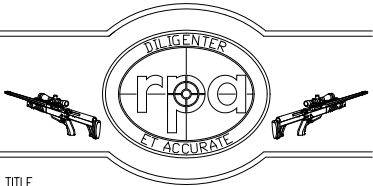
ALL DIAMETERS TO BE CONCENTRIC ABOUT BORE..MAX .025 TIR

THIS IS AN AUTOCAD R GENERATED DRAWING.
DO NOT MODIFY BY HAND.

GENERAL TOLERANCE:
±0.1mm - ±0.5"
ALL M/C DIMENSIONS - UNLESS STATED

MATERIAL:

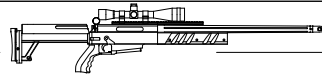
FINISH:



TITLE
QUADLITE BARREL
THREADING DETAIL
1 1/16" X 16 TPI UN-2A

SCALE -
DRG./STK.No. 31-LITE

ALL DIMS IN mm



DO NOT SCALE

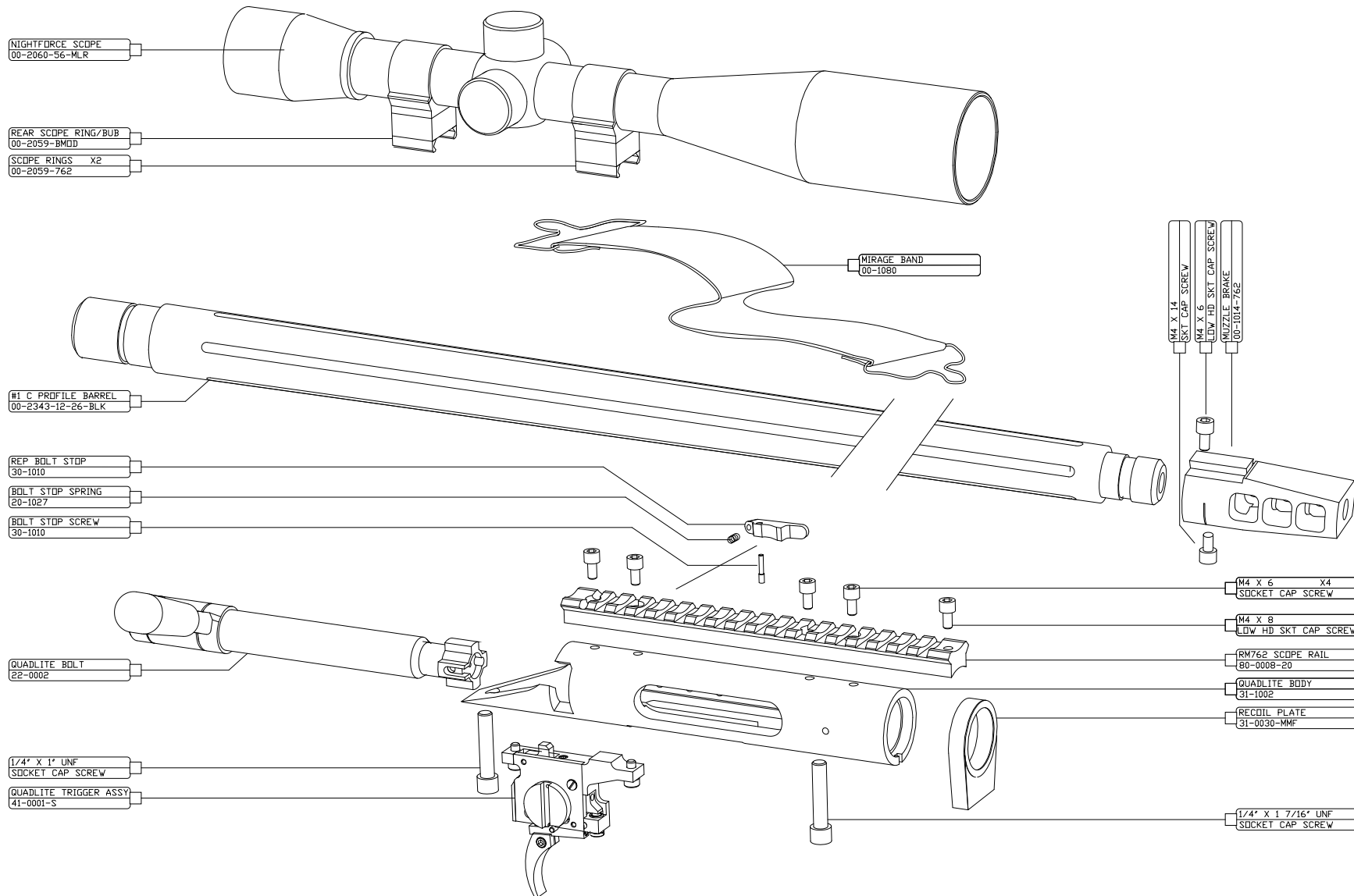
| Rev | Date | Description | Dr'n | Ch'kd | App'd |
|-----|----------|-------------|------|-------|-------|
| 0 | 24.01.07 | 1ST ISSUE | HE | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

GENERAL TOLERANCE:
 $\pm 0.1\text{mm}$ $\pm 0.25^\circ$ $\sqrt{32-16}$
ALL M/C DIMENSIONS - UNLESS STATED

MATERIAL:

FINISH:

ASSOCIATED ASSY No. -

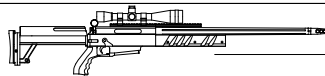




TITLE
BARRELED ACTION ASSY

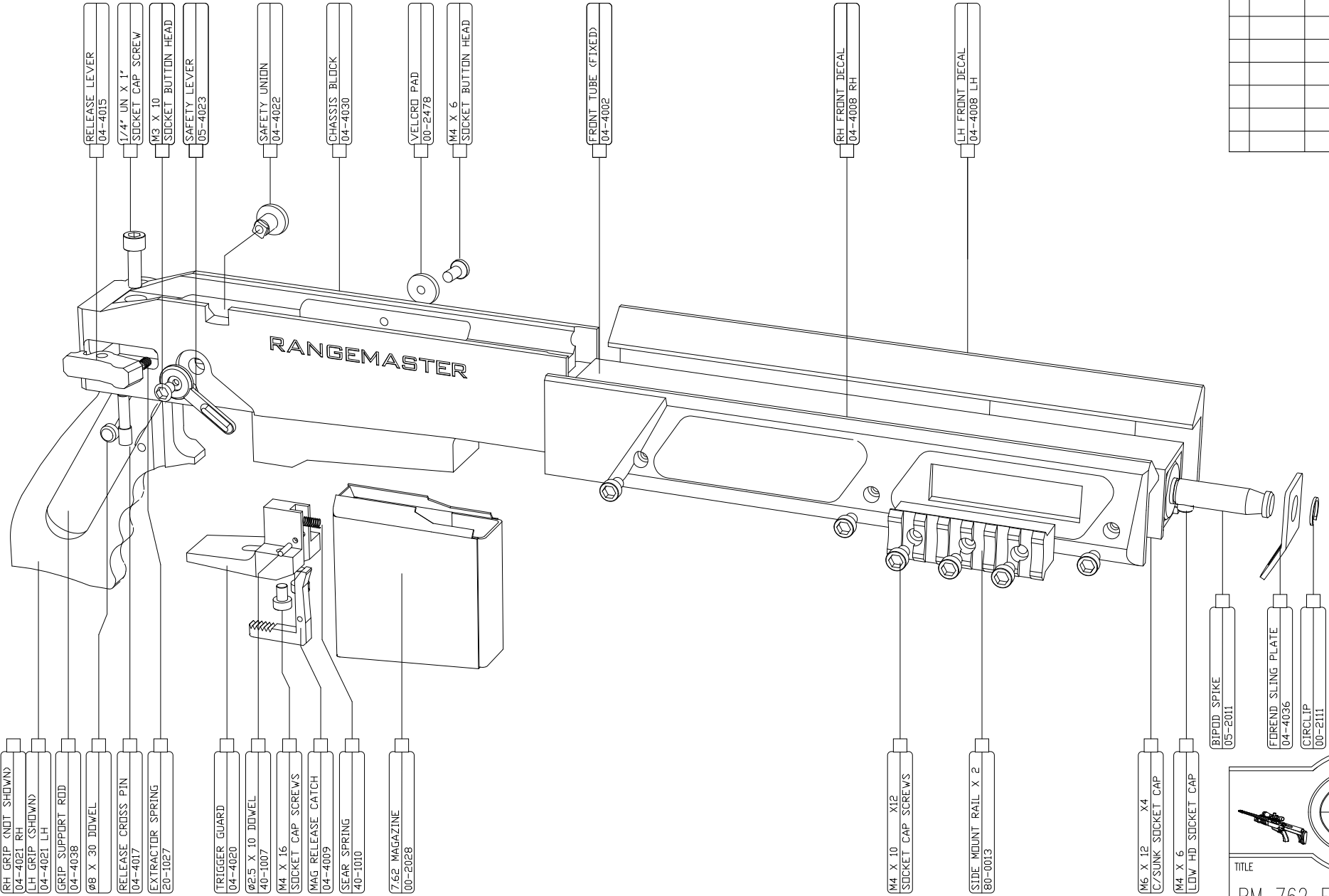
DRG. No. 03-0001

ALL DIMS IN mm



DO NOT SCALE

| Rev | Date | Description | Dr'n | Ch'kd | App'd |
|-----|----------|-------------|------|-------|-------|
| 0 | 01.01.07 | 1ST ISSUE | EL | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |



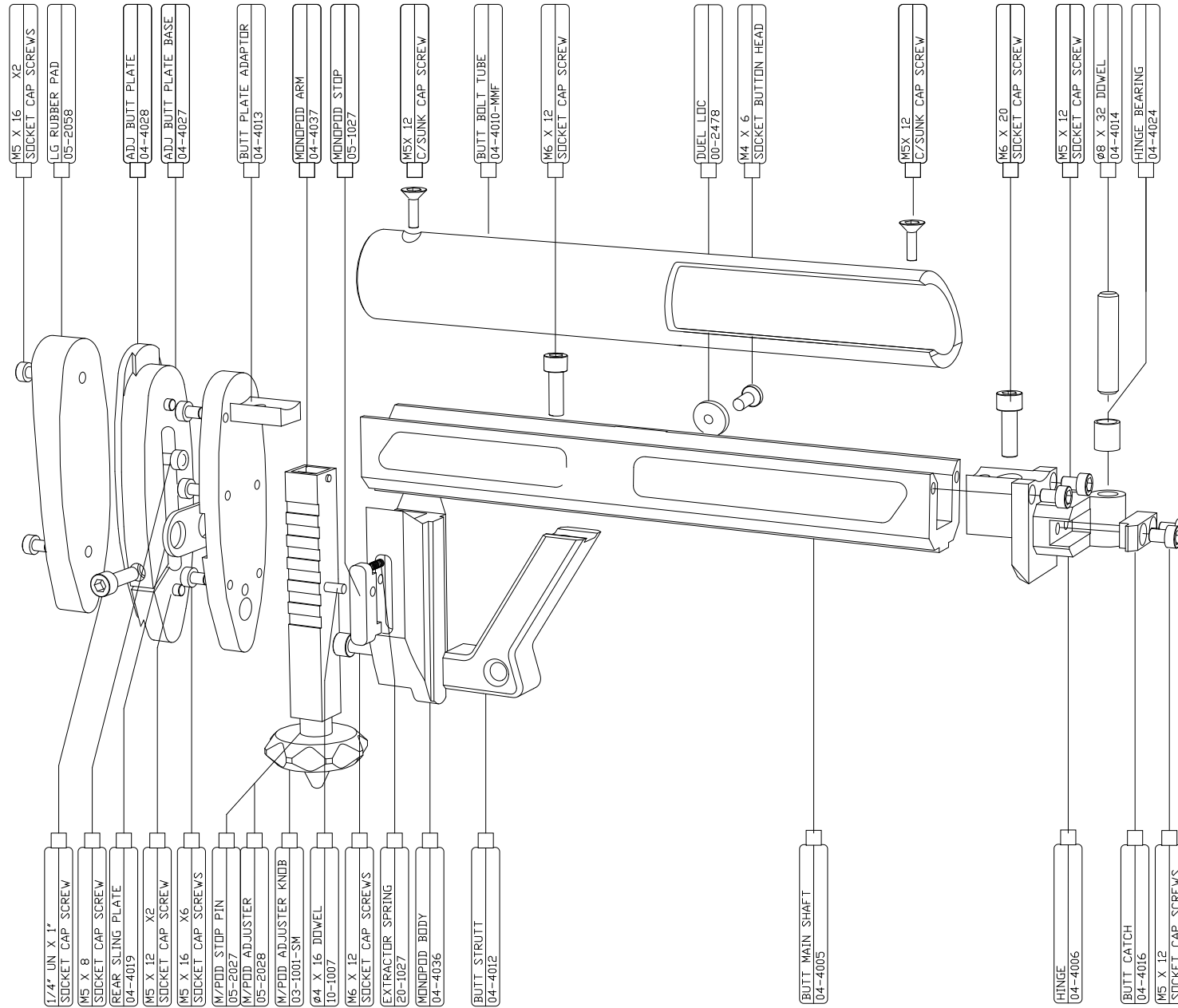
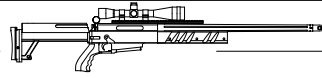
TITLE

RM 762 FRONT STOCK ASSY

DRG. No. 03-0024B-FS

ALL DIMS IN mm

DO NOT SCALE



| Rev | Date | Description | Dr'n | Ch'kd | App'd |
|-----|----------|-------------|------|-------|-------|
| 0 | 01.01.07 | 1ST ISSUE | EL | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

TITLE

RM 762 REAR STOCK ASSY

DRG. No. 03-0024A-FS