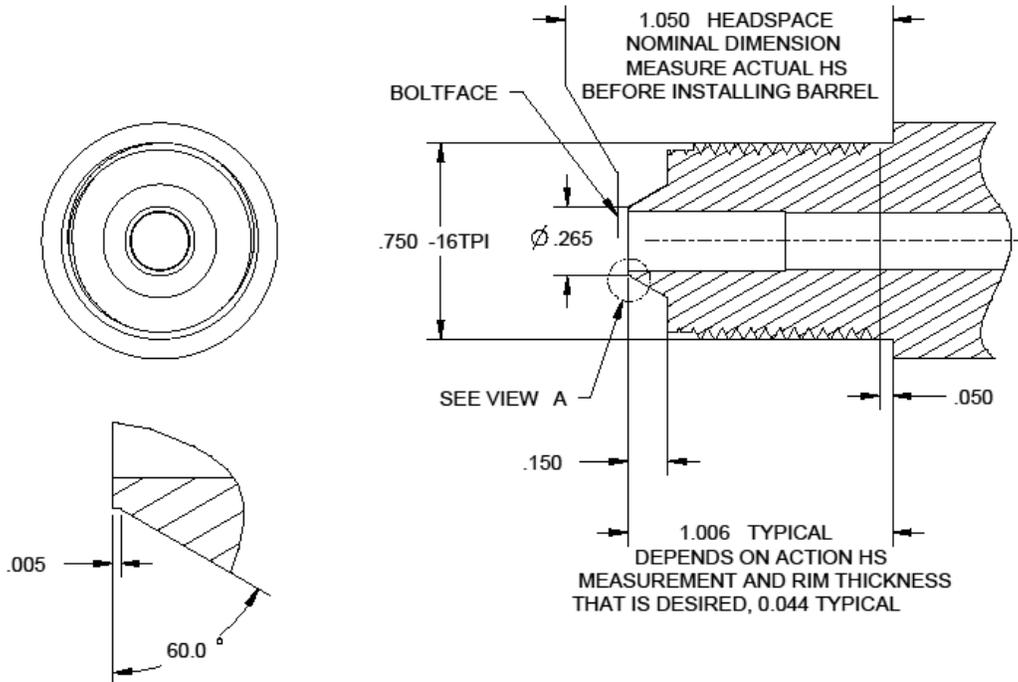


# INSTRUCTIONS FOR USING THE SPF 2500X ACTIONS

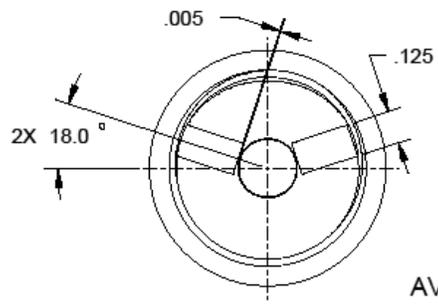
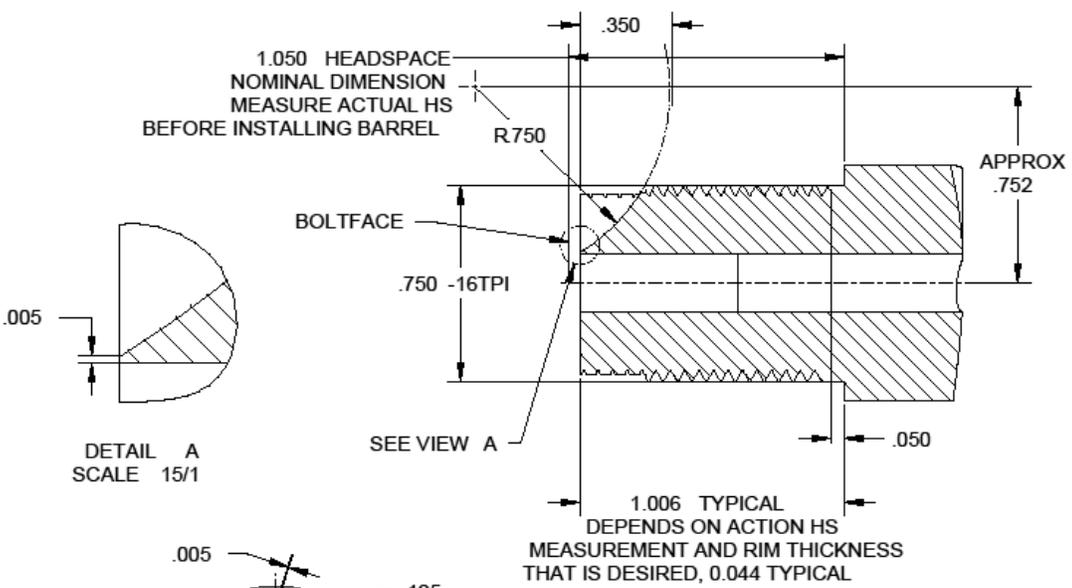
1. Fit barrel up per included drawings. **USE THE ENCLOSED DRAWINGS FOR CUTTING EITHER THE CONE OR EXTRACTOR SLOTTED BARREL TENON.**
2. The threads are an **ANSI class 2 fit for 0.750 – 16 TPI**. If a currently chambered barrel that fits another action does not fit, it is out of ANSI standard tolerance.
3. **ALWAYS, use anti-seize when installing a barrel, oil is NOT good enough.** If it feels like it is galling during installation or removal, stop, put in Kroil and very easily work it back and forth to try and save it. If it does not work, stop, cut off the barrel and have your gunsmith or us machine out the stub. This is standard on all stainless steel actions.
4. **DO NOT heat the action** up to help loosen a stuck barrel. If it is galled into the action, heating it will only make it worse.
5. **DO NOT lap the lugs.** They are factory lapped before the bolts are processed with the **Melonite process**. By lapping them, you will only remove the coating and increase the potential for the bolt to gall.
6. **ALWAYS put bolt grease** on the lugs during use. Failure to do so will cause galling of the bolt lugs to the lug faces inside the action.
7. **Any Remington Model 700** pattern trigger will fit this action.
8. The scope bases required are **2 front bases for a Model 700**. SPF has one piece scope bases available.
9. **Removal of the firing pin** from the bolt requires the use of a firing pin removal tool. **SPF sells one for this action. A standard Remington one will not work.** The tool must pull the pins back 0.50 inches to clear the extractors. To remove the pin assembly, turn out the setscrew on the bottom of the bolt at least 2 turns, use the tool to pull back the pin and unscrew the assembly. IF the pins hit the extractors you can bust or bend them. **Do not force it.** Fully pull back the pin or remove the extractors. When re-assembling them, **use care to align the pin with the front hole.**
10. Disassembly of the firing pin uses the **firing pin disassembly tool sold by SPF**. Take the pin assembly and screw it into the tool until the cocking piece touches the pipe. Then turn in the bolt until the cocking piece pin is exposed and push out with a punch. Remove the cocking piece and then remove the bolt. **Be careful if the spring is still loaded.**
11. The pin on the side of the shroud aligns the shroud to the action. **It is not a button to hold the firing pin back etc.** DO NOT push it in further. It cannot be pulled back out.

## SAFETY CONCERNS FOR USING THE 2500X ACTION

1. Always keep your **head clear of the port and from behind the bolt** when discharging the weapon for the first time after changing barrels, etc.
2. Always make sure barrel is **clear before discharging**.
3. Always make sure the ammunition is correct for the chamber in use.
4. If anything seems out of the ordinary, **STOP and investigate before discharging**.
5. **IF THERE ARE ANY PROBLEMS, QUESTIONS OR CONCERNS PLEASE CONTACT STILLER'S PRECISION FIREARMS, LLC FOR ASSISTANCE.**



**BARREL SHANK/CHAMBERING DIMENSIONS  
STILLER'S PRECISION FIREARMS, LLC  
2500X RIMFIRE WITH A CONED BREACH**



**BARREL SHANK/CHAMBERING DIMENSIONS  
STILLER'S PRECISION FIREARMS, LLC  
2500X RIMFIRE WITH A SLOTTED BREACH  
0.752 AND 0.350 DIMENSIONS APPLY  
TO 1.50 DIAMETER SLITTING SAW, MSC HAS  
AVAILABILITY IN 0.125 THICK AND 0.75 ARBOR**