

## MODEL 550-1 AUTOLOADING RIFLE

(SEE ILLUSTRATION)

### PRICE LIST

In ordering parts, specify model, outline, part number, part name and serial number of your rifle. All parts marked with an asterisk (\*) should be fitted at factory or by a qualified gunsmith.

Part No.	Part Name	Part No.	Part Name
454	Action Spring	17012W	Rear Pump Right Die (550-1P) (Small Aperture)
457	Action Spring Bushing	350	Rear Pump Right Assembly (550-1P) (includes: Rear Pump Right Die, Large Hole, Rear Pump Right Die, Rear Pump Right Pump Right Nut, Rear Right Bolt, Rear Right Elevation Indicator, Rear Right Elevation Plate, Rear Right Elevation Plate Screw, Rear Right Windage Plate Screw (2), Rear Right Base Screw)
458	Action Spring Guide	409	Rear Pump Right Nut (550-1P)
459	Action Spring Guide Retainer	417	Rear Right Base (550-1P)
4814P*	Extractor	17014	Rear Right Base Screw (550-1P)
58110P	Extractor (550-1P)	350	Rear Right Elevation Indicator (550-1P)
58115	Bolt	457	Rear Right Elevation Plate (550-1P)
5812	Bolt Assembly (includes Bolt, Extractor, Extractor Spring, Plunger and Firing Pin)	17011	Rear Right Elevation Plate Screw (550-1P) (2)
5813	Bolt Bushing	17020	Rear Right Screw (2)
17016	Bolt Flange	20730	Rear Right Stop
18106	Cartridge	421	Rear Right Windage Plate (550-1P)
20450	Cartridge Assembly Complete (includes Cartridge, Cartridge Retainer Spring, Cartridge Stop)	17013	Rear Right Windage Plate Screw (550-1P) (2)
350	Cartridge Spacer Bushing	20732	*Receiver Assembly (includes Receiver and Ejector)
18104	Cartridge Tension Spring	20736	*Receiver Assembly (includes Receiver and Ejector) (550-1P)
18104	Cartridge Stop	17044	Receiver Insert
18124	Cartridge Stop Detent	206	Receiver Insert Spacer
500	Cartridge Stop Detent Pin	303	Receiver Insert Spacer Pin
18182	Cartridge Stop Detent Spring	302	Receiver Plug
263	Connector	301	Receiver Plug Retainer
304	Connector Pin	184	Receiver Plug Retainer Screw
305	Connector Plunger	475	Receiver Plug Retainer Screw Lock Washer
404	Connector Spring	58110	*Revolving Chamber
404	Deflector	489	Safety
405	Deflector Screw	285	Safety Lever
18118	Extractor	272	Safety Screw
17047	Extractor Plunger	286	Sear (includes Sear and Bushing)
17010	Extractor Spring	304	Sear Pin
20450	Firing Pin (includes Firing Pin and Firing Pin Bush)	290	Sear Spring
10176	Front Sight	291	Sear Spring Case
129	Front Sight Ramp (550-1P)	293	Stock Assembly (includes Stock, Bolt Plate, Bolt Plate Screw (2), Take-Down Screw, Take-Down Screw Bushing, Trigger Guard, Trigger Guard Screw (2))
135	Front Sight Ramp Screw (550-1P) (2)	429	Stock Assembly (550-1P) (includes all component parts listed above)
87	Inner Magazine Tube	20745	Take-Down Screw
21080	Inner Magazine Tube Complete (includes Outer Magazine Tube, Magazine Tube, Magazine Spring, Magazine Pin, Magazine Plug)	282	Take-Down Screw Bushing
376	Magazine Follow-up	17018	Take-Down Screw Bushing
399	Magazine Pin	253	Trigger
52	Magazine Plug	36	Trigger Guard
53	Magazine Spring	17077	Trigger Guard Screw (2)
274	Magazine Screw	88	Trigger Pin
18179	Magazine Spring	409	Trigger Spring
36	Magazine Tube Support Screw	458	Trigger Spring Plunger
276	Main Spring	18170	Trigger Stop Pin
18212	Main Spring Plunger		
17229	Open Sight Leaf		
40	Outer Magazine Tube		
820	Outer Magazine Tube Assembly Complete (includes Outer Magazine Tube, Magazine Screw, Receiver Insert, Receiver Insert Spacer, Receiver Insert Spring Pin, Cartridge Stop, Cartridge Stop Spring, Cartridge Stop Detent Spring)		
17012W	Rear Pump Right Die (550-1P) (Large Aperture)		

# INSTRUCTIONS FOR OPERATION AND CARE

of the

# Remington

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MODEL 550-1



## AUTOLOADING RIFLE (Tubular Magazine)

Shoots .22 Short, Long, and Long Rifle Cartridges Interchangeably and Automatically without Adjustment

REMINGTON RIFLES COMPANY, INC. Ilion, N.Y., U.S.A.

## INSTRUCTIONS FOR OPERATION AND CARE

This rifle is shipped from the factory in take-down condition, as in Figure 1.



FIGURE 1

**Assemble Gun:** Place barrel and receiver in stock with trigger projecting through stock into guard, push rearward until receiver is firmly seated against end of slot in stock; then, tighten take-down screw into receiver until barrel and receiver are drawn firmly in stock.

**Load Magazine:** Tubular magazine is located at bottom of barrel. Turn knurled magazine plug at front end of magazine, pull out until loading opening forward of stock is uncovered, insert cartridges, with front end of cartridge toward muzzle, until visible at opening. Close tube upon cartridges, rotating slightly for passing shell head. Turn magazine plug to lock in closed position.

**Load Gun:** Grasp bolt handle, located on right side of receiver, and pull fully back. This motion causes carrier to raise cartridge. Release bolt handle quickly (do not ease bolt forward) to load first cartridge; gun is now ready to fire.

**To Make Safe:** Move safety lever rearward covering red dot on right side of receiver. This movement locks the trigger in position.

**Fire:** BE SURE GUN IS POINTED WHERE YOU WANT TO SHOOT. With action closed, push safety lever forward to "Off" position. Be sure deflector is fully rearward and deflector screw is tight. Pull trigger to fire.

**Repeat:** The trigger must be pulled for each shot. Pressure from the burning powder opens the bolt, ejects the empty shell, and reloads the barrel for the next shot until the magazine is empty.

**Unload Without Firing:** Move safety lever rearward to "On" position. Completely remove magazine tube and tip gun to pour cartridges from end of magazine. Replace and lock tube. THERE ARE STILL TWO CARTRIDGES IN GUN. Pull back bolt handle ejecting cartridge in barrel. Close bolt which puts second cartridge in barrel and again pull back bolt handle to eject last shell. Always operate action several times to assure yourself that gun is entirely empty.

## MODEL 550-1P

This is the same as 550-1 with exception of sights. Receiver has two screw holes in rear left side for attaching rear peep sight. One screw has a knurled head and peep hole interchangeable with peep disc when a larger aperture is desired. Elevating adjustment is made by loosening knurled binding screw in left side and swinging rear end of sight to proper graduation on scale, then tighten screw. Windage adjustment is made by loosening knurled peep disc and sliding to right or left to desired graduation, then tighten peep disc.



## MODEL 550-1 AUTOLOADING RIFLE COMPONENT PARTS



**Cleaning Action:** First, see that gun is neither loaded nor cocked. Remove barrel and receiver from stock. Unscrew receiver plug at rear end of receiver. Pull action spring assembly from receiver (keeping parts assembled as removed). Pull back bolt handle as far as possible and lift bolt handle from bolt. Slide bolt from receiver. Unscrew take-down screw bushing from bottom of receiver. Make sure carrier is in down position and push magazine tube into receiver as far as possible. Reach into ejection port with small screw driver and pry out recoiling chamber at extractor slots or jar out chamber by tapping rear end of receiver on some solid surface. Action can now be easily cleaned.

**Reassemble Action:** Replace recoiling chamber through ejection port. (Be sure to align feeding ramp with its clearance slot in the receiver insert.) Push magazine tube forward until front end of insert is flush with front end of receiver and replace take-down screw bushing. With carrier in upward position and trigger pulled back, replace bolt in receiver. (Be sure firing pin is in bolt.) Line up bolt handle hole in bolt with hole in rear end of bolt handle slot in receiver. With safety in forward or "Off" position pull back on trigger and with flat of bolt handle in upward position push bolt handle into hole in bolt as far as possible. Release trigger and push bolt handle fully forward. Replace action spring assembly in bolt making sure that main spring plunger has entered socket in rear of bolt. Push assembly forward to engage threads on bolt plug with receiver (keep springs aligned with center of hole in receiver when compressing). Screw bolt plug in place until ratchet teeth engage with bolt plug retainer.

**CAUTION:** If short cartridges are used to any great extent, care should be taken to clean the chamber of the barrel after shooting as a deposit of lead accumulates at the forward end of the chamber which, if left, will not permit the use of long rifle cartridges afterward until the deposit is removed.

The above condition is true in the case of any .22 caliber rifle chambered for long rifle cartridges.

## CARE OF RIFLE

Exclusive use of Remington Ammunition with KLEANBORE Priming or Peter's Ammunition with RUSTLESS Priming will reduce the amount of care necessary to keep the rifle in good condition. These cartridges are non-corrosive and will not cause rust or corrosion. With jacketed bullets cleaning is unnecessary, other than passing an oily rag through the bore to protect it against extreme moisture or when the gun is laid away for some time. Remington Gun Grease and Remington Oil are prepared especially for this purpose.

However, if corrosive ammunition is used, clean bore immediately after shooting to prevent residue from rusting or pitting the bore. Cleaning can be done by scrubbing bore with cloth or bristle brush saturated with Remington Powder Solvent. If this is not available, pour one pint of boiling water through barrel to dissolve residue. Use small funnel to prevent spilling. Wipe clean and dry, then lubricate with Remington Oil to prevent rusting. Repeat wiping and oiling again in a day or two.

Interior of barrel should be cleaned free of grease before firing to prevent a swelled bore or injury to barrel.

