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INSTRUCTIONS FOR OPERATION AND CARE

OF THE

*Remington*

MODEL 25 REPEATING RIFLE

Made in either .25-20 or 32-20 caliber.



SOLID BREECH  
HAMMERLESS

*Remington*

SIDE EJECTION  
TAKEDOWN

FOREWORD

This gun has been thoroughly tested, targeted, and inspected, and is guaranteed to be entirely free of defects in workmanship and material.

Remington KLEANBORE Ammunition is recommended for best results.

The gun is shipped from the factory in the taken down condition, so advantageous for shipping and carrying.

The .25-20 or the .32-20 calibers with centerfire cartridges furnished in black or smokeless powder HIGH VELOCITY, or HI-SPEED smokeless powder, REMINGTON KLEANBORE AMMUNITION maintain accuracy up to 300 yards (with HI-SPEED) and will take any game from squirrels to deer.

The Model 25 is an economical, all-round rifle.

Magazine capacity—11 cartridges  
Barrel length—24 inches  
Total Weight—5½ lbs.  
Rifle metal butt plate  
Open sporting sights.

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REMINGTON ARMS COMPANY, INC.

REMINGTON ILION WORKS

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*Remington*



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## DIRECTIONS FOR OPERATING



Figure 1

This rifle has the famous Remington solid breech; is hammerless and takedown. Its slide action mechanism will positively feed the .25-20 and .32-20 cartridges regardless of any shortening of the cartridge, which has caused much trouble in other rifles.

**Safety Features:** The safety is conveniently located behind the trigger and operates crosswise, positively locking the trigger. As soon as the action is started rearward and until it is entirely closed and locked again, the trigger cannot be pulled or the arm fired.

The magazine indicates if loaded or empty.

All cartridges may be removed from the arm when trigger is securely locked.

**To Put Together:** Unscrew and pull take-down screw out as far as possible so it will clear trigger guard; insert the trigger guard into receiver, carefully aligning the tongue slot at front end, also dowel pins with holes at rear end of guard; and push together until the take-down screw may be turned up tightly.



Figure 2

**To Take Down:** Unscrew the assembling screw on the left side of the arm; pull screw out until it strikes the retainer which prevents it dropping out of the receiver, and pull stock portion away from the receiver and barrel. (Fig. 1).

**To Load Magazine:** Insert bullet end of the cartridge under rear end of loading door (Fig. 2) located in right side of action bar. The door will then open wide when cartridge is pushed forward its full length into the opening; press the head sidewise into the opening (Fig. 3) and the magazine spring will move this first cartridge rearward and expose the magazine follower, against which place bullet of next cartridge and push forward until its head will move sidewise, like the first one. Continue until ten cartridges are thus loaded into magazine. Before loading you can tell at a glance if there are any cartridges remaining in magazine (Fig. 4).



Figure 3

**To Load Barrel:** Press upward on timing lever exposed just forward of the trigger guard, move fore-end completely rearward to open action, and close again to feed first cartridge into the barrel. Another cartridge may now be placed in the magazine, making eleven in the arm. The rifle may be used as a single-

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loader when the magazine is empty by placing cartridge directly into the barrel and closing action.

**To Unload Without Firing:** Put safety "ON." Press timing lever; open action to eject cartridge. Close action. Repeat until arm is empty.

**To Unload Barrel Only:** Put safety "ON". Press timing lever. Open action slowly until cartridge is partially ejected. Remove cartridge by hand, and without completing rearward movement, close action.

**To Set Safety:** Move the safety located at rear of trigger from left to right.

**To Operate Action:** When ready to fire, move safety "OFF" by pushing from right to left; then pull trigger to fire. Pull fore-end rearward quickly to open action, which ejects empty shell and cocks the arm. During the first quarter inch of this movement, the action bar positively retracts the firing pin away from the primer so it will not drag and interfere with the downward unlocking movement of the breech block. The timing lever also locks the trigger until action is completely closed. During the movement of the action, the cartridge stop positively intercepts the column of cartridges and allows only one to pass upon the carrier. This insures correct feeding regardless of any shortening of the cartridge.

The forward movement of the action bar moves the carrier upward to feed a fresh cartridge to the level of the barrel and into the grasp of the extractor, when the breech block carries it into the barrel.

The final closing motion raises front end of breech block to engage its locking shoulder with the corresponding shoulder in receiver to lock the breech securely. The timing lever releases the trigger so it may be pulled and also locks the action bar forward so it cannot be opened unless arm is fired or the timing lever is pressed.

The breech block may be removed from the receiver by first taking the gun down. Pulling take-down screw out as far as possible, move action bar rearward until stopped; hold breech block into clearance space in top of receiver (Fig. 5); move action bar forward, and lift the breech block out of receiver (Fig. 6). The barrel may be easily cleaned and inspected from the breech end.

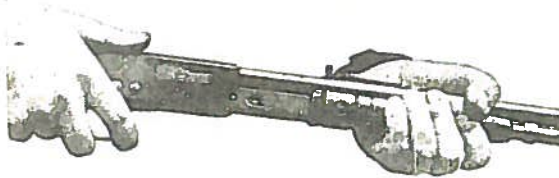


Figure 4

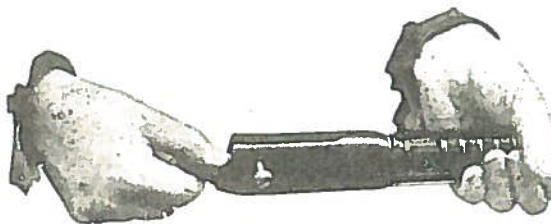


Figure 5



Figure 6

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## DIRECTIONS for DISMOUNTING and ASSEMBLING

1. Take down the arm.
2. **Breech Block.** Remove from the receiver (Figs. 5 and 6).
  - (a) Drive out extractor pin (36); remove extractor (35);
  - (b) Drive out ejector pin (33); remove retractor (103); spring (105) and plunger (104), ejector (32), ejector rod (34), firing pin spring (44), firing pin spring guide (45); pull back firing pin; remove firing pin front (42) and firing pin rear (43). Assemble in reverse order.
3. **Butt Plate.** Remove two butt plate screws (13).
4. **Stock Bolt.** Remove from rear of stock (114).
5. **Guard.** Remove from stock (114) by pulling forward.
  - (a) With hammer down, force rear end of main spring forward about one-quarter inch; insert a pin or small nail in main spring rod to hold main spring.
  - (b) Drive out hammer bushing (62); lift out hammer (61) with main spring rod (85) attached and main spring (84); lift out carrier (18) trigger spring case (131) and trigger spring (130).
  - (c) Drive out trigger pin (129) and remove trigger (128).
  - (d) Drive out safety plunger pin (112) and remove safety spring (113) and plunger (111), and push safety (110) out crosswise.
  - (e) Drive out timing lever pin (125) and remove timing lever (124) and spring (126).Assemble in reverse order.
6. **Cartridge Stop.** Remove cartridge stop screw (26) from left front end of receiver and take out cartridge stop (25).
7. **Magazine.** Remove magazine plug screw (79) and pull out magazine plug (78); pull out magazine spring (82) and magazine follower (77).
8. **Fore End.** Remove two locking screws (49); remove two fore end screws (48); slide action bar (1) rearward, and fore end (46) forward; remove magazine screw (81); turn out magazine tube (83), and pull out forward; remove fore end; slide action bar forward and unscrew magazine connector (76); slide action bar rearward through receiver, and lift out action bar cover (2).  
Assemble in reverse order.
9. **Action Bar.**
  - (a) Pull out loading door pin (69) from front of action bar; lift out loading door (68) and take out two loading door plungers (70) and two loading door springs (71).
  - (b) Remove carrier dog spring screw (21), carrier dog spring (20) and carrier dog (19).
  - (c) Drive out cartridge dog pin (23) and remove cartridge dog (22) and carrier dog spring (24).

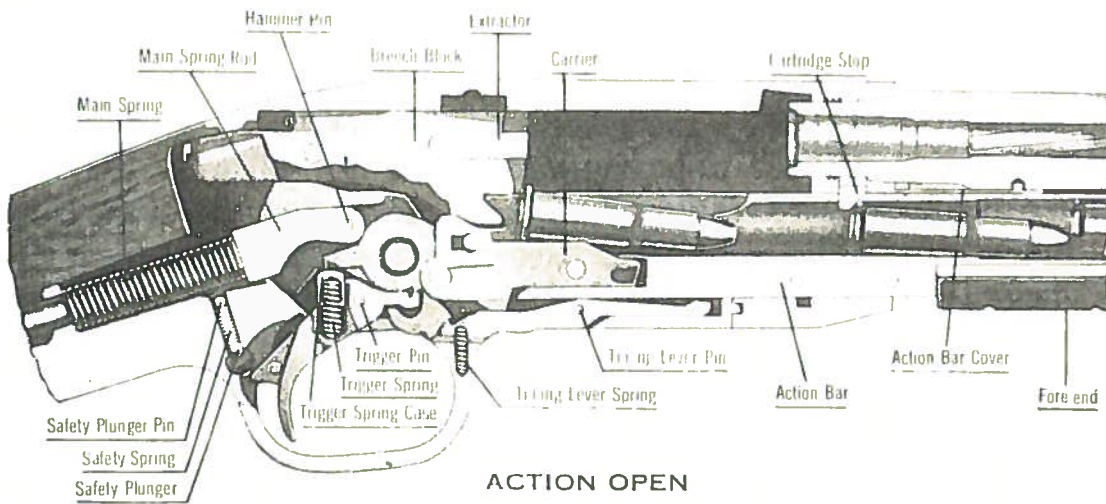
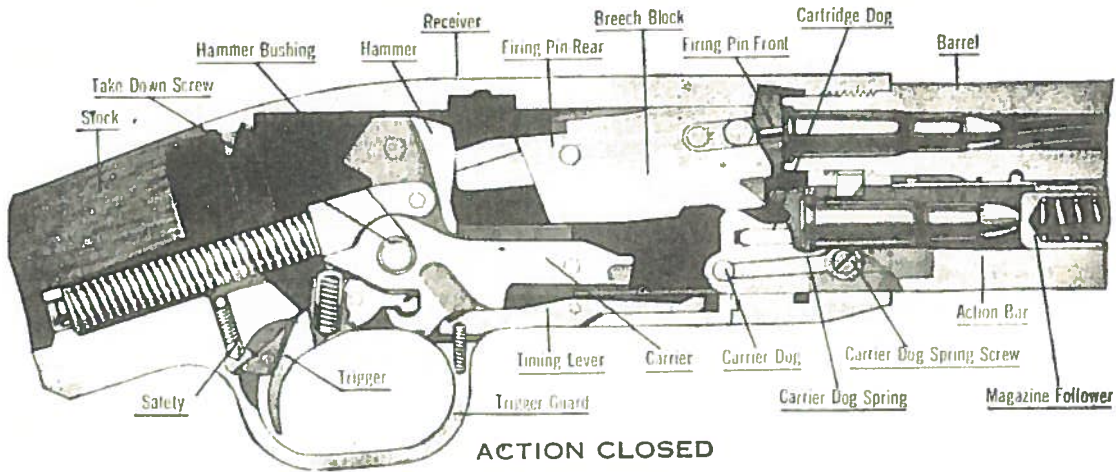
Assemble in reverse order.

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## SECTIONAL VIEWS



**REMINGTON ARMS COMPANY, INC.**

**REMINGTON UNION WORKS**

**ILION, N. Y., U. S. A.**

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## TO CLEAN

WHEN REMINGTON KLEANBORE AMMUNITION IS USED EXCLUSIVELY IN THIS GUN, THE BARREL WILL NOT RUST, AND DOES NOT HAVE TO BE CLEANED.

However, if you use old-fashioned ammunition, clean the gun immediately after shooting. Delay causes fouling, rusting, and pitting, and the accuracy will soon be destroyed.

**To Clean:** Scrub interior of the barrel thoroughly with a wire or bristle brush saturated with REMINGTON powder solvent. Wipe with clean rags, repeating the scrubbing and wiping until rags come through clean.

If a brush is not available, use REMINGTON Powder Solvent on rags. A brush reaches the corners of the rifling and is better than rags. When perfectly clean, oil thoroughly with Rem Oil.

Repeat same cleaning operation next day and oil with Rem Oil, or if the gun is to be put away for any length of time cover with REMINGTON Gun Grease.

If REMINGTON Powder Solvent is not available, to remove the fouling pour one quart of boiling water through the barrel. Run rags through until the barrel is thoroughly dried. Cover the inside of the barrel with REMINGTON Gun Grease. Remove grease before again using rifle. All metal parts should be cleaned and lubricated with a thin oil.

Rem Oil, which has been developed after long and careful experimental work at our arms factory, is recommended for this purpose.

Always clean the barrel from the breech. Any slight wear at the muzzle caused by the cleaning rod will make a perfect barrel inaccurate.

## NOTICE

Any information desired in the future as to the operation, repair or refinishing of this gun may be obtained by addressing the factory.

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## LIST OF COMPONENT PARTS

No.	Parts	Price	No.	Parts	Price
AA- 1	Action Bar .....	\$4.00	AA- 76	Magazine Connector.....	\$1.00
AA- 1½	Action Bar Complete....	6.00	AA- 77	Magazine Follower .....	.20
AA- 2	Action Bar Cover.....	.20	AA- 78	Magazine Plug.....	.20
AA- 8	Barrel .....	8.00	AA- 79	Magazine Plug Screw....	.10
AA- 10	Breech Block .....	4.00	AA- 80	Magazine Ring.....	.60
AA- 10½	Breech Block Complete	7.50	AA- 81	Magazine Screw.....	.10
AA- 12	Butt Plate .....	1.50	AA- 82	Magazine Spring.....	.20
AA- 13	Butt Plate Screw .....	.10	AA- 83	Magazine Tube .....	1.50
AA- 18	Carrier .....	1.00	AA- 84	Main Spring .....	.10
AA- 19	Carrier Dog .....	.10	AA- 85	Main Spring Rod .....	.40
AA- 20	Carrier Dog Spring.....	.20	AA- 90	Plug Screw .....	.10
AA- 21	Carrier Dog Spring Screw .....	.10	AA- 93	Rear Sight Base.....	1.60
AA- 22	Cartridge Dog .....	.60	AA- 93½	Rear Sight Complete....	2.00
AA- 23	Cartridge Dog Pin .....	.10	AA- 94	Rear Sight Slide.....	.20
AA- 24	Cartridge Dog Spring....	.10	AA- 95	Rear Sight Slide Screw	.10
AA- 25	Cartridge Stop .....	.60	AA- 96	Rear Sight Step.....	.20
AA- 26	Cartridge Stop Screw....	.10	AA- 97	Receiver .....	8.00
AA- 32	Ejector .....	.40	AA- 99	Receiver Bushing, Plain	.10
AA- 33	Ejector Pin .....	.10	AA-100	Receiver Bushing, Threaded .....	.10
AA- 34	Ejector Rod .....	.20	AA-102	Receiver Plug .....	.10
AA- 35	Extractor .....	.60	AA-103	Retractor .....	.60
AA- 36	Extractor Pin .....	.10	AA-104	Retractor Plunger .....	.10
AA- 37	Extractor Spring .....	.10	AA-105	Retractor Spring.....	.10
AA- 42	Firing Pin Front.....	.20	AA-110	Safety .....	.10
AA- 43	Firing Pin Rear.....	.20	AA-111	Safety Plunger.....	.10
AA- 44	Firing Pin Spring .....	.10	AA-112	Safety Plunger Pin.....	.10
AA- 45	Firing Pin Spring Guide	.10	AA-113	Safety Spring .....	.10
AA- 46	Fore End .....	1.25	AA-114	Stock .....	3.00
AA- 47	Fore End Escutcheon....	.20	AA-115	Stock Bolt .....	.10
AA- 48	Fore End Screw.....	.10	AA-116	Stock Bolt Washer.....	.10
AA- 49	Fore End Locking Screw .....	.10	AA-121	Take Down Screw.....	.20
AA- 50	Front Sight .....	.40	AA-123	Take Down Screw Retainer .....	.10
AA- 51	Front Sight Lock Screw	.10	AA-124	Timing Lever .....	.80
AA- 56	Guard .....	4.00	AA-125	Timing Lever Pin.....	.10
AA- 61	Hammer .....	.80	AA-126	Timing Lever Spring....	.10
AA- 62	Hammer Bushing.....	.15	AA-128	Trigger .....	.80
AA- 63	Hammer Pin .....	.10	AA-129	Trigger Pin.....	.10
AA- 68	Loading Door .....	.80	AA-130	Trigger Spring .....	.10
AA- 69	Loading Door Pin.....	.10	AA-131	Trigger Spring Case....	.10
AA- 70	Loading Door Plunger	.10	AA-138	Wiping Rod Handle....	.15
AA- 71	Loading Door Spring....	.10	AA-139	Wiping Rod Head.....	.15



# COMPONENT PARTS

## Model 25 Repeating Rifle

