The highest quality “Sako-style” extractor on the market.

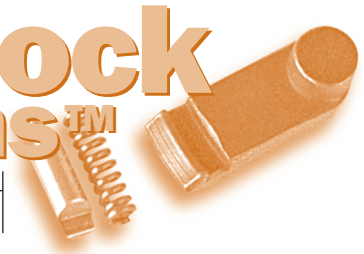
Superior Shooting Systems Inc.™ offers precision made Tubb Extractor kits (extractor, plunger and spring) for installation into modified Remington® bolt action rifles. These kits feature the highest quality “Sako-style” extractor on the market and are available to fit a variety of bolt face diameters and cartridge applications. The parts are carefully engineered and machined using correct materials to ensure consistency, performance, and durability.

Tubb Extractors are used to replace the Remington® factory riveted extractors as well as the newer rivetless design. These extractors give a gunsmith not only a way to repair bolts but also to greatly improve extraction function. We believe that any Remington® rifle intended for serious use should be fitted with one of these extractors. Whether a rifle is intended for competitive shooting or dangerous game hunting, extraction failures can be catastrophic! Installation of these parts is considered mandatory by most custom gunsmiths when building a custom Remington® bolt action rifle.

Sizes & Designations

There are 5 different sizes to fit specific needs. The “TUBB 2000” extractor (unmarked) is a direct replacement for the TUBB 2000 rifle and also replaces the “small” Sako extractor commonly used for Remington® bolt actions. The “A” stamped extractor is suitable for installation on rifles chambered from .22-250 to .458 Winchester Magnum or .375 H&H — any Remington® centerfire bolt sized for a 0.470 case head or the full range of magnum sized (0.530) bolt faces. The “B” model is for .404, Lazzeroni .284, and 7.21 Firehawk. “C” fits .378 Weatherby to .460 Weatherby and .416 Rigby. The “D” stamped part is for Lazzeroni .243, 6.17 Spitfire, and 6.71 Phantom.

SpeedLock Systems™



We recommend installation of the TUBB 2000 extractor (small Sako) where possible as it requires less metal removal from the bolt.

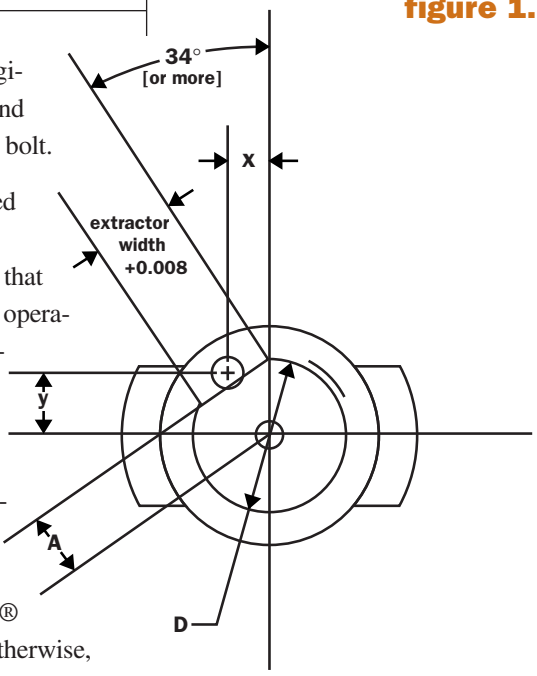
The following installation instructions apply to Remington® Models 721, 722, 725, 700, 600, 660, 40-X centerfire, XP-100, Model 7, and Sportsman 78.

Caution!

The bolt modifications necessary to install these parts are permanent and non-reversible, and will, therefore, void the factory warranty. If you have never made this modification before we recommend you practice cutting the slot and drilling the required holes using a piece of 0.750" diameter mild-steel round stock. It is strongly recommended that only experienced gunsmiths who are properly equipped and practiced in this type of work perform this job. If you have any doubts about your ability to correctly install this product, do not do it! Carefully read all instructions before proceeding.

Bolt Modifications

figure 1.



1. Remove firing pin, original extractor, ejector, and ejector spring from the bolt.

2. The bolt must be rotated to an angle of 34° (or greater) and secured at that orientation for the first operation. This provides correct positioning of the replacement extractor. The easiest way to secure and position the bolt is with an "Extractor Installation Jig" [Brownell's® part #100-000-123]. Otherwise, use a V-block or other secure means to mount the bolt horizontally in the milling machine. Center the milling cutter to the firing pin hole.

	A	X	Y	D
Magnum	0.2160	0.1476	0.2189	0.5471
Standard	0.1860	0.1311	0.1944	0.4861
PPC	0.1700	0.1222	0.1811	0.4545
.223 Rem.	0.1390	0.1046	0.1550	0.3991

3. Use the appropriate end mill to cut the groove for the extractor. The length of the slot cut is shown in Figure 2. The depth of the slot is dependent on the diameter of the case the gun is chambered for. Refer to Figure 1 and its accompanying table for the correct slot depths and dimensions for different applications. Cut the slot in several passes; do not attempt to make the cut in one pass. Figure 3 shows the relationship of the slot to the bolt face.

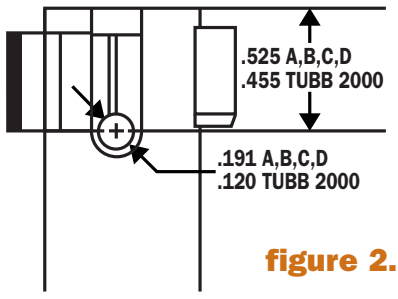


figure 2.

4. Check the width of the slot and adjust the slot to fit. We recommend .004" clearance per side.

5. Measure the extractor retaining finger and drill a hole .010" larger at the rear of the slot. This hole should be located so the rear edge of the hole touches the rear edge of the slot. Drill through into the firing pin hole in the center of the bolt body (Figure 2 and 3).

6. Test fit the extractor in the slot. Place the rim of a dummy round into the bolt face. Make sure the extractor will cam over the rim of a case without being forced. If it will not cam over the edge, enlarge the hole slightly to give more clearance.

7. Change the bolt to a vertical position in the milling machine with the bolt face pointing upward. Drill a .104" diameter hole .450" deep for the extractor spring. This hole should be centered in the back of the slot and appropriately spaced from the bottom of the slot. (Figure 1 and 3)

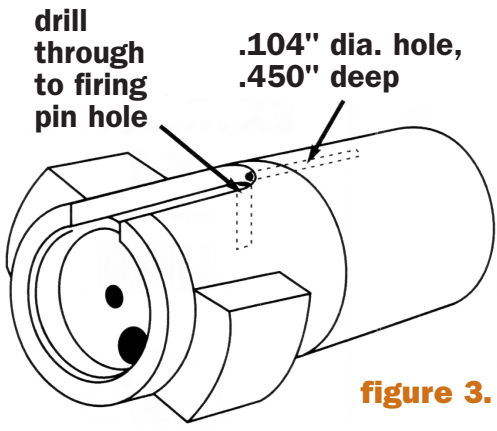


figure 3.

8. Install the extractor by putting the spring and plunger into the .104" inch diameter hole just drilled. The notch on the plunger must face the center of the bolt. Push the extractor back and down until the round shank drops into the retaining finger hole in the bolt body and the plunger rides up over the small flat at the rear of the extractor.

9. Use dummy rounds to check the new extractor for function. Reassemble the firearm according to manufacturer instructions. Check again for proper functioning using dummy rounds. If these tests prove satisfactory, test fire with live ammunition in a safe and appropriate manner.

Check www.SuperiorShootingSystems.com for more information and to see the complete *Superior Shooting Systems Inc.* product line.