

Owner's Manual

Marlin®

MODEL XL7

**BOLT ACTION
CENTERFIRE RIFLE**

IMPORTANT

This manual contains operating, care and maintenance instructions. To assure safe operation, any user of this firearm must read this manual carefully. Failure to follow the instructions and warnings in this manual can cause accidents resulting in injury or death. This manual should always accompany this firearm, and be transferred with it upon change of ownership.

The warranty card bound into this manual must be filled out and mailed within 10 days of purchase.
WARNING: KEEP THIS FIREARM OUT OF THE REACH OF CHILDREN, UNAUTHORIZED INDIVIDUALS, AND OTHERS UNFAMILIAR WITH THE SAFE HANDLING OF FIREARMS.

COMES WITH MARLIN'S 5-YEAR WARRANTY

How Your Rifle is Made

Your rifle has been made to Marlin's strictest standards of safety and reliability. It has been proof tested with a high pressure load, function fired, and checked for accuracy at the factory. Built with tradition and engineered to last, your rifle is the product of over 135 years of Marlin technology.

Before You Use This Firearm

It is very important that you read and understand this manual before using your new rifle. Warnings should be read and heeded carefully. Also follow the safety rules listed in "Marlin's Guide to Gun Safety", printed on this page.

- **WARNING:** Marlin firearms are designed and manufactured to handle standard factory-loaded ammunition which conforms to SAAMI (Sporting Arms and Ammunition Manufacturers' Institute Inc.) standards with dependability and safety. Due to the many bullet and load options available, the element of judgement involved, the skill required, and the fact that serious injuries have resulted from dangerous handloads, Marlin does not make any recommendations with regard to handloaded ammunition.
- **WARNING:** Your rifle should not be assembled, used or disassembled without fully reading and understanding the instructions in this manual.
- **WARNING:** It is a violation of federal law to alter or deface the serial number of any firearm.

Marlin's Guide to Gun Safety

1. Read and understand the owner's manual before using a firearm.
2. If you are unfamiliar with firearms, attend a firearms safety class taught by a certified instructor.
3. Handle every firearm as if it were loaded and ready to fire.
4. Control the muzzle, and never point a firearm at anything you don't want to shoot.
5. Keep the safety on SAFE until you are ready to shoot.
6. Unless you are hunting, carry your firearm empty, with the action open.
7. Before shooting, be sure you have an adequate backstop. All ammunition is dangerous beyond your line of sight.
8. Avoid ricochets by never shooting at water or any hard, flat surface.
9. Do not run, climb, or jump over an obstacle with a loaded firearm.
10. Do not climb into or out of a tree or tree stand with a loaded firearm. Do not allow others to pass loaded firearms to you while in a tree stand.
11. Do not enter or ride in a motor vehicle with loaded firearms.
12. Do not lean a loaded firearm against anything.
13. Do not bump, drop or jar a loaded firearm.
14. Do not pull a firearm toward you by the muzzle.
15. Wear hearing protectors when shooting.
16. Wear impact-protective glasses when shooting, disassembling or cleaning firearms.
17. Avoid alcoholic beverages and drugs before and during shooting.
18. Use only ammunition of the correct gauge, caliber, size and bullet shape for your firearm.
19. Do not use damaged, dirty, modified, or improperly handloaded ammunition.
20. Keep the barrel and mechanism of the firearm free of obstructions.
21. Do not use a firearm that fails to function properly. Do not try to force a jammed action.
22. Be sure no one is in the path of ejecting shells or cartridges.
23. Do not interchange parts between firearms, and be sure disassembly and reassembly are correct and complete.
24. Before cleaning, be sure the chamber, action and magazine are completely unloaded.
25. Unload firearms before storing, transporting, or leaving unattended.
26. Store firearms and ammunition separately, locked and out of the reach of children.

Failure to follow these rules, or other instructions in this manual, can result in personal injury.

Bolt Installation

To install the bolt, first check to ensure the chamber is empty. Line up the locking lugs with the recesses at the rear of the receiver and push the bolt forward. (If bolt sleeve/cocking piece are out of location, do not force. Consult a gunsmith or call Marlin Gun Service Dept.)

How to Operate the Safety

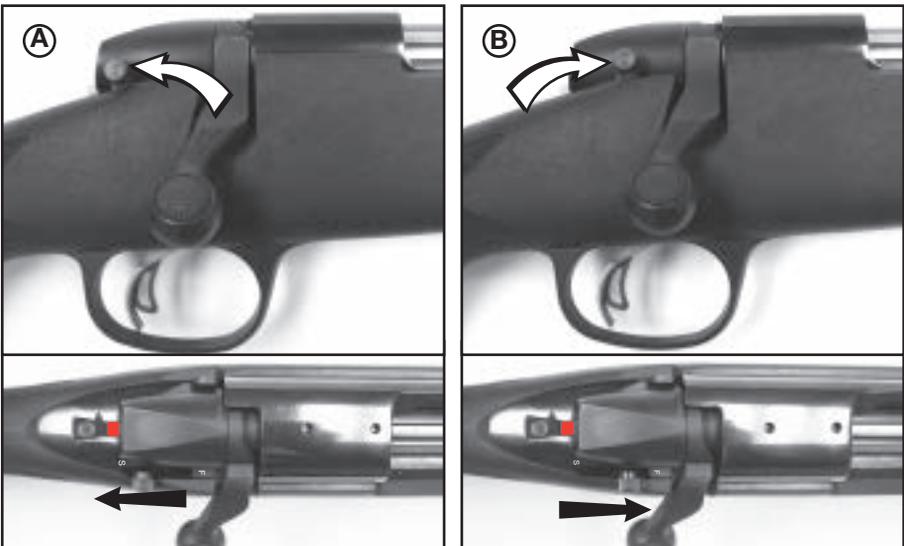
The safety button is round and located on the right side of the receiver behind the bolt handle. The letters “F” and “S” are engraved on either side of the safety button.

- **WARNING:** Prior to firing, know and understand the operation of the safety by practicing with the rifle unloaded. Do not touch the trigger while operating the safety, or at any other time, unless you are ready to shoot.
- **WARNING:** Never put the safety between the SAFE and FIRE positions. Always place it in either the forward position (FIRE) or rearward position (SAFE). Unless the safety is in either the forward or rearward position, you cannot be certain whether it is on SAFE or FIRE.

This rifle is equipped with a two-position safety which will operate when the bolt is open, or closed and rifle is cocked. When cocked, a red indicator is visible beneath the bolt sleeve (See Figures A and B). To cock the rifle, rotate the bolt handle all the way up and pull the bolt rearward until you can see the chamber and magazine to ensure they are empty. Then push the bolt forward and rotate the handle down to its original position. The rifle is now empty and cocked and the red indicator will be visible.

The two safety positions.

- 1. Fully to the rear “S”** (See A). This is the SAFE position. With the safety in this position, the trigger is blocked, the bolt is not. This position should be used for carrying in the field and during loading and unloading the chamber and magazine.
- 2. Fully forward “F”** (See B). This is the FIRE position. If the chamber is loaded and the trigger is pulled with the safety in this position, the rifle will fire.



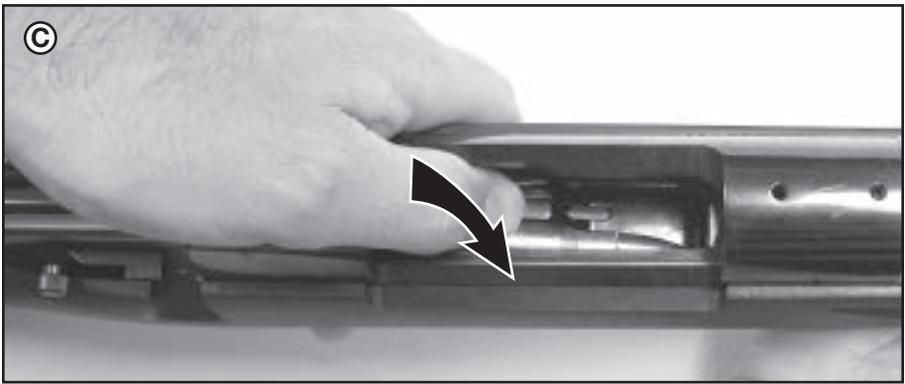
Fully to rear, safe

Fully forward, fire

- **WARNING:** Never disassemble the safety. It has been correctly designed, fitted and tested. Any mechanical device can fail, however, so never rely on the safety to justify careless handling. Never use a firearm with a safety that does not function properly. (See instructions for factory maintenance in this manual.)

How to Load

- **WARNING:** Before loading, be sure that all grease, oil or any obstruction has been removed from the barrel and chamber. Use only the ammunition type inscribed on the barrel of your rifle.
1. With the rifle pointed in a safe direction and the safety in the safe position (See A, pg. 3), lift the bolt handle and pull the bolt back as far as it will go.
Note: If bolt is not cocked, safety cannot be moved. In this case, open bolt and move safety to safe position (See A, pg. 3).
 2. Push cartridges, one at a time, straight down into the magazine. Ensure each cartridge is against the rear wall of the magazine. (See C).



Loading the magazine

3. One additional cartridge can be loaded directly into the chamber (See D). This is not recommended unless you are ready to aim and fire your rifle.
4. Using your thumb to push the cartridges in the magazine all the way down, slide the bolt forward slowly, so that it passes over the top of the cartridges in the magazine (See E).
5. Push the bolt handle all the way down. The chamber and magazine are now loaded. Your rifle is now cocked, with a round in the chamber, and will fire if the safety is placed in the fire position and the trigger is pulled.



Loading the chamber



Closing the bolt over the loaded magazine

How to Fire

- **WARNING:** Before firing your rifle, always be sure of your intended target and that there is a safe backstop beyond.

With the rifle pointed at the target, push the safety to the FIRE position (See B, pg. 3) and pull the trigger.

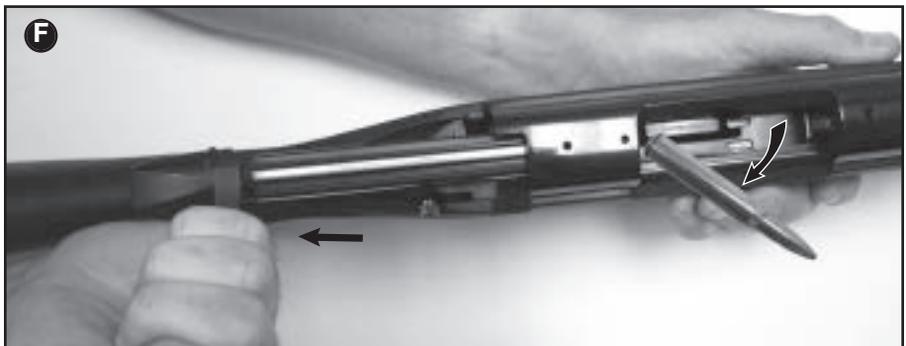
After firing, lift the bolt handle and pull it all the way back, ejecting the fired cartridge case. If you do not want to fire again, see “How to Unload”.

To chamber the next cartridge, push the bolt forward and the handle fully down. Your rifle is cocked and ready to fire again. If you do not want to fire again, put the safety in the SAFE position before closing the bolt (See A, pg. 3).

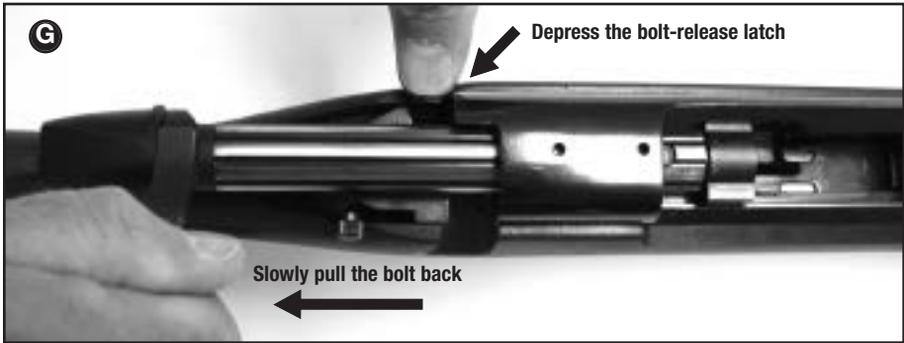
- **WARNING:** A “squib” or underpowered shot, can normally be detected by the unusually low report it makes. Because the bullet may actually still be in the barrel, you must unload completely and, with the bolt removed, look through the barrel from the breech end to see if there is an obstruction. If there is, it must be removed before firing. Otherwise, personal injury or severe damage could result.

How to Unload

With the rifle pointed in a safe direction, and the safety in the SAFE position (See A, pg. 3), lift the bolt handle. Pull the bolt handle back slowly to eject the cartridge from the chamber (See F).



Ejecting cartridges



Removing the bolt

Close the bolt and push the handle all the way down. Lift the handle and pull it all the way back slowly to eject the next cartridge. Repeat this procedure until the chamber and magazine are empty.

- **WARNING:** Check chamber and magazine to be certain that no cartridges remain. If possible, leave the bolt open. If it must be closed, be sure the safety is on.

How to Clean Your Rifle

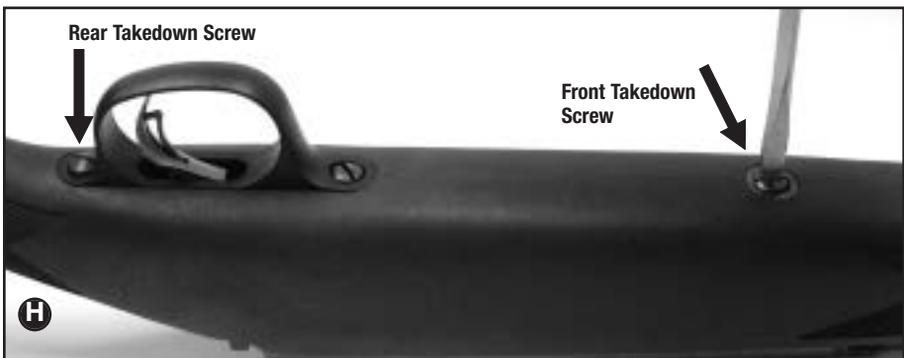
- **WARNING:** Before cleaning your rifle, be certain it is completely unloaded and the bolt has been removed.
- **WARNING:** Never attempt to wipe down or clean a loaded firearm. Follow instructions under "How to Unload" before cleaning.

With the rifle unloaded and pointed in a safe direction, open the bolt and put the safety in the SAFE position (See A, pg. 3). To remove the bolt, lift the bolt handle and slowly pull the bolt back, while depressing the bolt-release latch with your other hand (See G).

With the bolt removed, clean the bore from the breech (chamber) end, using the proper caliber cleaning rod, cleaning patches and powder solvent. Clean and oil the breech bolt and other exposed metal surfaces.

Caution: Before using any solvent or other gun cleaning product, read the label carefully to be sure it will not damage either the finish or any parts of this firearm.

To remove the barreled action from the stock, first remove the bolt, as described above. Turn the rifle upside down and remove the rear takedown screw and the front takedown screw (See H), in that order. Screw heads are either slotted, as shown, or have a 9/64 Allen head.



Removing takedown screws. Note: If screws are slotted, use a screwdriver, as shown. If screws are Allen heads, use a 9/64 Allen Key.

Separate the barreled action from the stock. When separating, note proper magazine spring placement in stock inletting (See I). Clean and oil exposed metal surfaces, and put a small amount of gun grease on the cocking cam surface (See J). (Further disassembly is not recommended.) (Do not attempt to disassemble bolt. Firing pin assembly is under strong spring load and can be dangerous.)

Reassemble the rifle by placing the barreled action back into the stock aligning the magazine spring with the stock inletting notch to ensure proper functioning (See I). Replace the two screws; the front takedown screw followed by the rear takedown screw. Be sure the screws are tightened securely when reassembling, or accuracy will be adversely affected, and damage to the rifle may result when firing.

To reinstall the bolt, line up the locking lugs with the recesses at the rear of the receiver and push the bolt forward. (If bolt sleeve/cocking piece are out of location, do not force. Consult a gunsmith or call Marlin Gun Service Dept.)

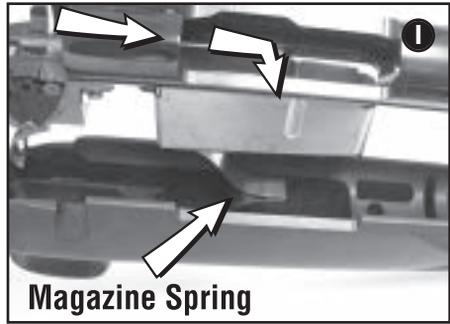
Note: Use a very thin coat of light oil during below freezing conditions. Condensation droplets will form soon after the rifle is brought into a warm room, or the rifle may become wet during inclement weather. In any case, all moisture should be removed. Exterior metal finishes may be wiped down with a slightly oiled cloth. For long term storage, lightly oil the bore, barrel and action with gun oil. Your rifle should be completely unloaded and stored in a dry, ventilated area. Do not store it in a carrying case.

Pro-Fire™ Adjustable Trigger

The XL7 bolt action rifle is equipped with Marlin's custom-designed Pro-Fire™ adjustable trigger system. With safety as our primary concern, the Pro-Fire™ design requires the user to place their finger squarely over the trigger release (see K, pg. 8). pulling the trigger from the side or not directly rearward may not disengage the trigger release and not allow the trigger to move.

Trigger Pull Adjustment

- **WARNING:** The XL7 bolt action rifle has a specially designed adjustable trigger. The trigger pull on this firearm has been preset at the factory for field and hunting use. Rifles with trigger pull settings lower than set at the factory are considered target firearms used only for precision shooting under firing range or bench firing conditions. It is the sole responsibility of the user to exercise extreme caution while adjusting and using these firearms. Marlin Firearms accepts no responsibility or liability for any direct and/or consequential damage and/or injury resulting from the misuse, lack of maintenance, adjustment, and/or mishandling of a firearm.



Aligning the magazine spring with the stock inletting notch



Put a small amount of grease on the cocking cam surface

• **WARNING:** Safe ownership and use of this firearm is solely your responsibility. Before adjusting the trigger pull, please thoroughly read and understand the instruction manual in its entirety.

• **WARNING:** Make sure the bolt is open and the firearm is unloaded before removing the stock and adjusting the trigger.

1. Remove the stock (see section “How to Clean Your Rifle” for instruction).

2. Loosen, but do not remove, the jam nut (See K) using a 3/8" open end wrench (not included).

3. Insert a 3/32" hex key wrench into adjusting screw as shown (hex key wrench not included). To increase the trigger pull, turn the hex key wrench clockwise. To decrease the trigger pull, turn the hex key wrench counter-clockwise (See L and M).

Note: If the trigger pull is increased too much, the trigger cannot be pulled. Turn the adjusting screw counter-clockwise until the trigger can be pulled.

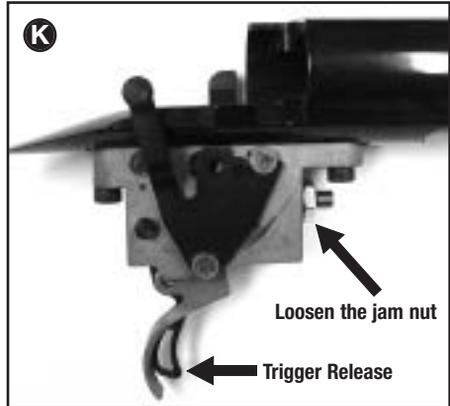
4. After adjusting pull weight tighten the jam nut.

5. **FOLLOWING ADJUSTMENT, WITH NO AMMUNITION IN THE FIREARM AND THE MUZZLE POINTING IN A SAFE DIRECTION**, close the bolt and verify that the “TWO POSITION SAFETY” is fully operational as explained in the section “How to Operate the Safety”. (You can check adjusted trigger pull weight by using a trigger pull gauge.)

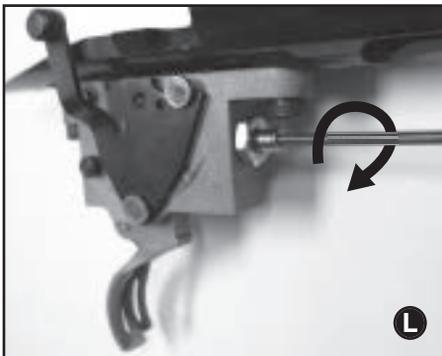
Note: Be sure that you are comfortable with the force that is necessary to pull the trigger. If not, follow the instructions carefully to readjust the trigger for the conditions under which you will use this rifle.

Note: Marlin recommends the trigger pull, as adjusted at the factory (3 pounds +), for field/hunting use. Reduced trigger pulls should only be set for precision/target shooting.

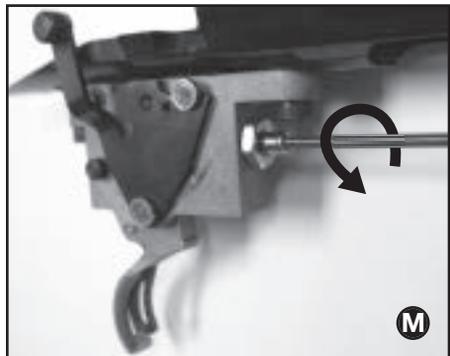
Note: At no time should you tamper with the trigger release or trigger release spring.



- Pro-Fire™ Trigger Release shown
- Trigger pull adjustment, jam nut shown



Trigger pull adjustment: Turn adjusting screw clockwise to increase trigger pull



Trigger pull adjustment: Turn adjusting screw counter-clockwise to decrease trigger pull

How to Obtain Parts and Service From Marlin® Firearms Company

Repair Services:

If there is a defect with your Marlin firearm that (i) you believe is, or should be, covered by the Warranty, (ii) you would like Marlin to address at your cost and expense, or (iii) you would otherwise like to discuss with Marlin, please contact Marlin Consumer Services at 1-800-544-8892, Mon.-Fri 9:00AM – 5:00PM. Please do not send your firearm or other item to Marlin without first (a) calling this number, (b) receiving instructions from the Marlin representative, and (c) obtaining a Service Request document containing your Service Repair Number. With regards to the Service Request document, Marlin will either e-mail this document to you or, if you do not have an e-mail address Marlin will mail it to you. Please be sure to store your Service Request document in your records so that it is both safe and accessible. Finally, to the extent you seek Warranty coverage, please review the Warranty for your Marlin firearm and note that you may void your Warranty by taking action without first contacting Marlin.

If shipment of your firearm is required, a SRN must be obtained prior to shipment and please follow the following instructions:

- Record the serial number of your firearm before shipping.
- Pack your firearm for safety and to prevent further damage in shipping and handling
- Remove all accessories from the firearm to prevent loss or damage.
- Place your approved Service Repair Number (SRN) on the shipping label.
- Check your government guidelines before shipping.
- Marlin is not responsible for damage or loss during shipment. You may elect to purchase insurance from your carrier.

PARTS LIST BOLT ACTION XL7 RIFLE

For parts prices, call 1-800-544-8892

Be sure to mention gun serial number when ordering parts

ILL. NO.	PART NAME	PART NUMBER	ILL. NO.	PART NAME	PART NUMBER
**1	Barrel, 270 Win.	117320	**41	Sear	277051
**1	Barrel, 30-06 Spr.	117220	**42	Sear Bolt Stop Pin	477790
**1	Barrel, 25-06 Rem.	117230	**43	Sear Spring	477294
**2	Barrel Nut	477194	**44	Sear Stop Pin	477990
**3A	Breech Bolt Assembly	577385	45	Stock: Black Synthetic	577070
**3	Bolt Assembly	577085	45	Stock: Camo	577170
**4	Bolt Friction Washer	477153	46	Swivel Studs	420793
**5	Bolt Head	177085	**47	Trigger	277043
**6	Bolt Head Retaining Pin	477997	48	Trigger Guard	277158
**7	Bolt Sleeve	277088	49	Trigger Guard Screw	477690
**8	Bolt Stop	377281	50A	Fire Control Assembly	577160
**9	Bolt Stop Spring	477694	50	Trigger Pull Adj. Screw	477890
**10	Cocking Piece	277054	51	Trigger Pull Jam Nut	477052
**11	Ejector	477068	**52	Trigger Release	377182
**12	Ejector Retaining Pin	320798	**53	Trigger Release Pin	477190
**13	Ejector Spring	477894	**53	Trigger Release Pin	477191
**14	Extractor	277069	**53	Trigger Release Pin	477192
**15	Extractor Ball	401182	**53	Trigger Release Pin	477193
**16	Extractor Spring	477994	**54	Trigger Release Pivot Pin	477390
**17	Fire Control Housing	477160	**55	Trigger Release Spring	477494
**18A	Firing Pin Assembly	577620	**56	Trigger Safety Lever Pin	477189
**18	Firing Pin	477099	**57	Trigger Spring	477594
**19	Firing Pin Sleeve	477253			
**20	Firing Pin Spring	417794			
**21	Firing Pin, Cocking Piece Pin	477998			
22	Front Fire Control Mt Screw	477090			
23	Front Takedown Screw	477490			
24	Magazine Box	477046			
25	Magazine Box Screw	417193			
26	Magazine Follower	477024			
27	Magazine Spring	417194			
28	Rear Fire Control Mt Screw	477290			
29	Rear Takedown Screw	477590			
**30	Receiver	120060			
**31	Recoil Lug	177918			
32	Recoil Pad	477002			
33	Recoil Pad Screw	477995			
**34	Retaining Ring	420752			
**35	Retaining Ring	418152			
**36	Safety	377181			
**37	Safety Plunger	477089			
**38	Safety Plunger Spring	477394			
39	Scope Mount Base	477131			
40	Scope Mount Base Screw	320190			

*Restricted availability—Part sent to qualified gunsmith only.

**Restricted availability—Parts installed at factory only.

Firearm Owner's Record

Model: _____

Serial # _____

Date Purchased: _____

Purchased From: _____

Price Paid: _____

Remember to complete and return the Firearm Warranty Registration Card in order to obtain full benefit of your Limited Five Year Firearm Warranty.

A WORD ON THE MAINTENANCE AND CARE OF YOUR MARLIN FIREARM

Don't Alter or Modify Your Firearm and Have it Serviced Regularly.

Your firearm has been designed to operate according to certain factory specifications. You'll jeopardize your safety and that of others around you by attempting to alter its trigger, mechanical safety or other mechanisms. Never alter or modify your firearm in any way.

Marlin recommends that you have your firearm professionally serviced annually. You should also have your firearm professionally serviced after prolonged storage, or if there is ever any question pertaining to the proper functioning characteristics of your firearm.

Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure optimum safety and performance. Only a qualified service facility should service, repair or modify your Marlin firearm. Consult your instruction manual for location of the nearest Authorized Marlin Repair Center.

Proper cleaning and lubrication are also important to firearm maintenance and are necessary to assure accuracy, safety, and reliability. Before cleaning, always make sure that your firearm is completely unloaded. And always clean the barrel from the chamber end to the muzzle when possible.

Firearm Sale or Transfer:

If your firearm has been adjusted or changed in any way and you intend to sell or otherwise transfer possession of your firearm, you must: 1) provide a complete service record, (2) warn the purchaser or recipient of your firearm that it has been adjusted or modified, and (3) give the purchaser or recipient this owner's manual for review and reference. If you do not wish to sell or transfer your firearm in an adjusted condition (recommended), return it to a Marlin Authorized Repair Center for restoration of your firearm to the original factory conditions. Do Not attempt to restore the firearm to factory conditions yourself.

WARNING! NEVER alter or modify any part of the firearm. Improper alterations can make the firearm unsafe and result in personal injury or death to you or others.

This firearm should not be sold where prohibited by federal, state or local laws.