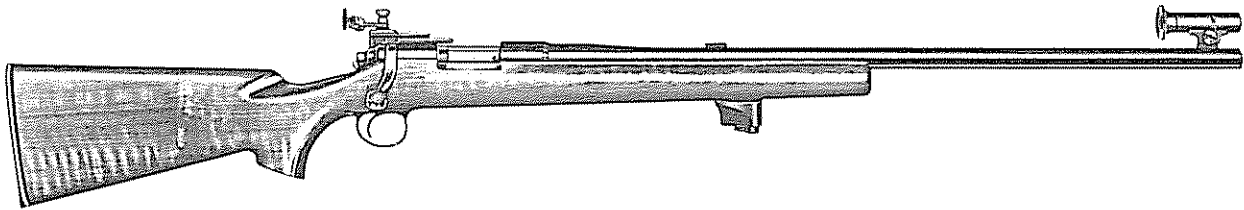


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MODEL 40-XB
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This service supplement for the Model 40-XB will include only those parts that are different from Model 40-X. See Model 40-X (or M/700) for parts not listed herein. Note also reference to existing assembly instructions as required.



SAFETY - features a 2-position design to rear of bolt handle. A corrugated non-slip thumbpiece can be rotated to rear for ON SAFE stop position and rotated forward to FIRE stop position. See Model 700 Manual for assembly instructions.

BOLT ASSEMBLY - introduced as "swept-back" handle design, similar to Model 700. See Model 40-X Manual for 22 Caliber "two piece" design. See Model 700 Manual for Center Fire "one piece" bolt design.

FRONT SWIVEL ASSEMBLY

Rim Fire - 22 Caliber - includes fore end rail, front rail screw (2), rear rail screw (2), front swivel, front swivel block, front swivel washer (2), front swivel bushing, front swivel screw, front swivel nut.

Center Fire Calibers - includes front swivel, front swivel base, front swivel block, front swivel bushing, front swivel nut, front swivel screw, front swivel washer. Note: Front swivel base screw (2) attach front swivel assembly to stock.

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FRONT SWIVEL ASSEMBLY Continued

FORE END RAIL - is a long channel design for full length adjustment of front swivel block. The center fire model still features the "short" design of front swivel base.

To Disassemble - Unscrew and remove four (4) rail screws at front and rear. Front guard screw (1) must also be removed. Lift out and disassemble loosened fore end rail from stock.

Note: Front swivel block (and fittings) may remain attached to rail. For center fire model, remove two (2) front swivel base screws to disassemble front swivel base.

To Service - Interchangeable as replacement. No factory assembly required.

To Reassemble - Position fore end rail (or front swivel base) to stock and assemble rail (or base) screws.

Note: When reassembling rail to 22 Caliber design make certain front guard screw tightens securely to receiver.

FRONT SWIVEL BLOCK - is designed for strap adjustment in any forward position. Turn swivel screw to loosen block for adjustment.

To Disassemble - (Rim Fire) Unscrew front swivel screw and disassemble all parts of the front swivel assembly from fore end rail.

To Service - All parts of assembly interchangeable. No factory assembly required.

To Reassemble - Position all parts in proper order and assemble front swivel screw to front swivel nut. Tighten front swivel block to fore end rail.

Note: See Model 700 Manual for Center Fire swivel instructions.

TRIGGER GUARD - is of light weight "short design, to rear of the long fore end rail.

To Disassemble - Unscrew and remove both rear and middle guard screws. Pull out guard and disassemble from stock.

To Service - Interchangeable as replacement. No factory assembly required.

To Reassemble - Locate properly over trigger and into stock. Assemble both screws and tighten guard securely to receiver.

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STOCK - now features a custom-style grip for better holding qualities. The rim fire model is also fitted with long fore end rail for full length swivel adjustment.

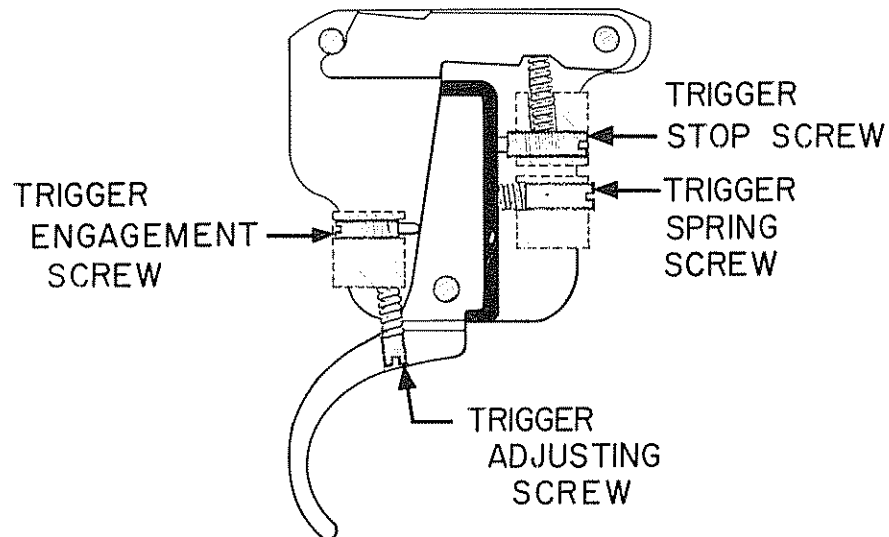
To Disassemble - Unscrew and remove rear guard screw, middle guard screw and front guard screw. See Sectional Assembly drawing on last page of this manual. Disassemble stock from action.

Note: Trigger guard will disassemble as stock is removed. Other stock fittings may be removed as required.

To Service - Interchangeable as replacement. No factory assembly required.

To Reassemble - Replace guard screws (and trigger guard) to stock. Tighten stock to action securely. Make certain barrel remains free-floating in stock.

TRIGGER (Rim Fire & Center Fire) - is adjusted for weight by using a small trigger adjusting key. Turn trigger adjusting screw with key. Trigger adjusting spring will hold screw and trigger under tension. See sketch below.



- For heavier weight pull turn screw inward.
- For lighter weight pull turn screw outward.

Note: See Model 700 Manual for other trigger assembly instructions.

