



**XPR™**

Winchester® XPR™ Bolt-Action Rifle Owner's Manual

Important instructions for the

# Winchester® XPR™ Bolt-Action Rifle

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If you have any questions or comments regarding your new firearm, please feel free to write or call us. Use the space below to record information about your new firearm.

Model \_\_\_\_\_

Serial Number \_\_\_\_\_

Purchased From \_\_\_\_\_

Date of Purchase \_\_\_\_\_

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## STATE WARNING

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According to state law, California requires that firearm manufacturers, distributors and retailers include conspicuous, specific warnings with firearms sold in that state.

### **▲WARNING**

“Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fined or sent to prison.”

### **▲ADVERTENCIA**

“A los niños los atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte. Evite que los niños tengan acceso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las esté utilizando. Si usted tiene un arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarlo a la cárcel.”

## **WARNING: YOU ARE RESPONSIBLE FOR FIREARM SAFETY**

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### **▲WARNING**

**FAILURE TO FOLLOW ANY OF THE FOLLOWING WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

As a firearm owner, you accept a set of demanding responsibilities. How seriously you take these responsibilities can be the difference between life and death.

There is no excuse for careless or abusive handling of any firearm. At all times handle this firearm and all other firearms with intense respect for their power and potential danger.

Please read and understand all of the cautions, warnings, notices, proper handling procedures and instructions outlined in this owner’s manual before using your new firearm.

### **1 ALWAYS KEEP THE MUZZLE OF YOUR FIREARM POINTED IN A SAFE DIRECTION EVEN THOUGH YOU ARE CERTAIN IT IS UNLOADED.**

Never point any firearm at anything you do not intend to shoot. Be extremely alert and aware of all persons and property within the range of your ammunition.

### **2 NEVER RELY TOTALLY ON YOUR FIREARM’S MECHANICAL “SAFETY” DEVICE. LIKE ANY MECHANICAL DEVICE, A “SAFETY” CAN SOMETIMES FAIL; IT CAN BE JARRED OR INADVERTENTLY MANIPULATED INTO AN UNSAFE CONDITION.**

The word “safety” describes a firearm’s trigger block mechanism, sear block mechanism, hammer block mechanism or firing pin block mechanism. Mechanical “safeties” are designed to place your

firearm in a safer status, and no guarantee can be made that the firearm will not fire even if the “safety” is in the on safe position. Mechanical “safeties” merely aid safe gun handling and are no excuse for pointing your firearm’s muzzle in an unsafe direction. See “Operation of the ‘Safety’” on page 8 for instructions on the operation of this firearm’s “safety.”

Remember, safe gun handling does not stop with your firearm’s mechanical “safety” devices, it starts there. Always treat this firearm with the respect due a loaded, ready-to-fire firearm.

Some firearms do not have a mechanical “safety.” Many target firearms, lever-action firearms and pistols do not have manual “safety” mechanisms. Therefore it is critical to read and understand the owner’s manual for every firearm which explains the safe operation of the firearm.

While it is a good idea to “test” your firearm’s mechanical “safety” periodically for proper function, never test the “safety” while your firearm is loaded or pointed in an unsafe direction.

**3 WHENEVER YOU HANDLE ANY FIREARM, OR HAND IT TO SOMEONE, ALWAYS OPEN THE ACTION IMMEDIATELY AND VISUALLY CHECK THE FIREARM’S CHAMBER TO MAKE CERTAIN THAT THE FIREARM IS COMPLETELY UNLOADED.**

Make certain the firearm does not inadvertently contain any ammunition. Remember, merely removing the magazine does not mean the chamber is unloaded. Always keep the chamber empty and the “safety” in the on safe position unless shooting is imminent.

**4 ALWAYS WEAR EAR AND EYE PROTECTION WHEN SHOOTING.**

Unprotected, repeated exposure to gunfire can cause hearing damage. Wear hearing protection (shooting ear plugs or muffs) to guard against such damage.

Wear shooting glasses to protect your eyes from flying particles. Allow proper distance (eye relief) between a scope and your eye when firing a scoped pistol, rifle or shotgun. Do not use unorthodox shooting methods that could cause the rearward travel of the slide or bolt of a firearm to contact your eyes, face or hands. Always keep a safe distance between the muzzle of your firearm and any persons nearby, as muzzle blast, debris and ejecting cartridges could inflict serious injury.

Always wear eye protection when disassembling and cleaning any firearm to prevent the possibility of springs, spring-tensioned parts, solvents or other agents from contacting your eyes.

**5 KEEP ALL FIREARMS UNLOADED DURING TRANSPORT, EVEN WHEN STORED IN A HOLSTER, GUN CASE, SCABBARD OR OTHER CONTAINER.**

**6 DROPPING OR JARRING A LOADED FIREARM CAN CAUSE ACCIDENTAL DISCHARGE.**

This can occur even with the “safety” in the on safe position. Be extremely careful while hunting or during any shooting activity to avoid dropping any firearm.

**7 HUNTING FROM ELEVATED SURFACES SUCH AS TREESTANDS IS DANGEROUS.**

Doing so may increase the risk of mishandling a firearm. The following rules should always be observed by you and those you hunt with. Always make certain that the stand being used is safe and stable. Always make certain that your firearm is unloaded when it is being taken up and down from the stand. Always make certain that your firearm is not dropped from the stand, or dropped while it is being taken up or down from the stand. Remember, a loaded firearm may discharge when dropped, even with the “safety” in the on safe position.

**8 STORE YOUR FIREARM AND AMMUNITION SEPARATELY, WELL BEYOND THE REACH OF CHILDREN.**

Take prudent safeguards to ensure your firearm does not become available to untrained, inexperienced or unwelcome hands. Store all firearms in secure, locked cases or a gun safe. Keep your firearm unloaded when not in use.

**9 BEWARE OF BARREL OBSTRUCTIONS.**

Mud, snow and an infinite variety of other objects may inadvertently lodge in a barrel bore. It only takes a small obstruction to cause dangerously increased pressures that can damage your firearm and cause serious injury to yourself and others.

**BEFORE CHECKING FOR A BARREL OBSTRUCTION, BE CERTAIN YOUR FIREARM IS COMPLETELY UNLOADED, THERE IS NOT A LIVE CARTRIDGE IN THE CHAMBER AND THE “SAFETY” IS IN THE ON SAFE POSITION.**

After assuring yourself that the firearm is completely unloaded, open the breech or action and look through the barrel to be sure it is clear of obstructions. If an obstruction is seen, no matter how small it may be, clean the bore with a cleaning rod and patch as described on pages 23-25 of this owner’s manual.

**10 BE ALERT TO THE SIGNS OF AMMUNITION MALFUNCTION. IF YOU DETECT AN OFF SOUND OR LIGHT RECOIL WHEN A CARTRIDGE IS FIRED, DO NOT LOAD ANOTHER CARTRIDGE OR SHELL INTO THE CHAMBER.**

If your firearm fails to fire, keep the muzzle pointed in a safe direction for a minimum of 30 seconds. Rotate the ejection area of the firearm away from you, carefully open the action and remove the cartridge

from the chamber. If the primer is indented, the defective cartridge should be disposed of in a way that cannot cause harm. If the primer is not indented, your firearm should be examined by a qualified gunsmith and the cause of the malfunction corrected before further use. Glance down the barrel to make sure that no obstructions remain in the barrel. Completely clear the barrel before loading and firing again. Failure to follow these instructions can cause extensive damage to your firearm and possible serious injury to yourself and others.

**11 NEVER INSERT A CARTRIDGE OF THE INCORRECT CALIBER INTO ANY FIREARM.**

The caliber of your firearm is marked on the barrel. Store all cartridges of different calibers in completely separate and well-marked containers. Never store cartridges of mixed calibers in a common container or in your pockets. See pages 14-15 for more information on the correct ammunition for your firearm.

**12 EXAMINE EVERY CARTRIDGE YOU PUT IN YOUR FIREARM.**

We assume no responsibility for the use of unsafe or improper firearm and ammunition combinations or damage or injury caused by damaged ammunition. It is your responsibility to read and heed all warnings in this owner's manual and on ammunition boxes. See pages 14-15 for more information on the correct ammunition for your firearm.

**13 USE ONLY SAAMI APPROVED AMMUNITION.**

The barrel and action of this firearm have been made with substantial "safety" margins beyond the pressures developed by established American commercial loads. Nevertheless, we can assume no liability for incidents which occur through the use of cartridges of nonstandard dimensions or which develop pressures in excess of commercially available ammunition which has been loaded in accordance with standards established by the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI).

**14 MAKE SURE OF ADEQUATE VENTILATION IN THE AREA THAT YOU DISCHARGE A FIREARM. LEAD EXPOSURE CAN OCCUR FROM DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION.**

Lead is a substance that has been known to cause birth defects, reproductive harm and other serious injury. Wash hands thoroughly after exposure to ammunition or after cleaning a firearm.

**15 DO NOT SNAP THE FIRING PIN ON AN EMPTY CHAMBER; THE CHAMBER MAY NOT BE EMPTY!**

Treat every firearm with the respect due a loaded firearm, even though you are certain the firearm is unloaded.

**16 KEEP YOUR FINGERS AWAY FROM THE TRIGGER WHILE LOADING AND UNLOADING UNTIL SHOOTING IS IMMINENT.**

**17 BE SURE OF YOUR TARGET AND BACKSTOP, PARTICULARLY DURING LOW LIGHT PERIODS.**

Know the range of your ammunition. Never shoot at water or hard objects.

**18 ALWAYS UNLOAD YOUR FIREARM'S CHAMBER BEFORE CROSSING A FENCE, CLIMBING A TREE, JUMPING A DITCH OR NEGOTIATING OTHER OBSTACLES.**

Never place your firearm on or against a fence, tree, car or other similar object.

**19 BE DEFENSIVE AND ON GUARD AGAINST UNSAFE GUN HANDLING AROUND YOU AND OTHERS.**

Don't be timid when it comes to firearm safety. If you observe other shooters violating any of these safety precautions, politely suggest safer handling practices.

**20 BE CERTAIN YOUR FIREARM IS UNLOADED BEFORE CLEANING.**

Because so many firearm accidents occur when a firearm is being cleaned, special and extreme care should be taken to be sure your firearm is unloaded before disassembly, cleaning and reassembly.

Keep ammunition away from the cleaning location. Never test the mechanical function of any firearm with live ammunition.

**21 TEACH AND SUPERVISE FIREARMS SAFETY TO ALL MEMBERS OF YOUR FAMILY, ESPECIALLY TO CHILDREN AND NON-SHOOTERS.**

Closely supervise newcomers to the shooting sports. Encourage enrollment in hunting and shooting safety courses.

**22 NEVER DRINK ALCOHOLIC BEVERAGES OR TAKE ANY TYPE OF DRUGS BEFORE OR DURING SHOOTING.**

Your vision, motor skills and judgment could be dangerously impaired, making your gun handling unsafe to you and to others.

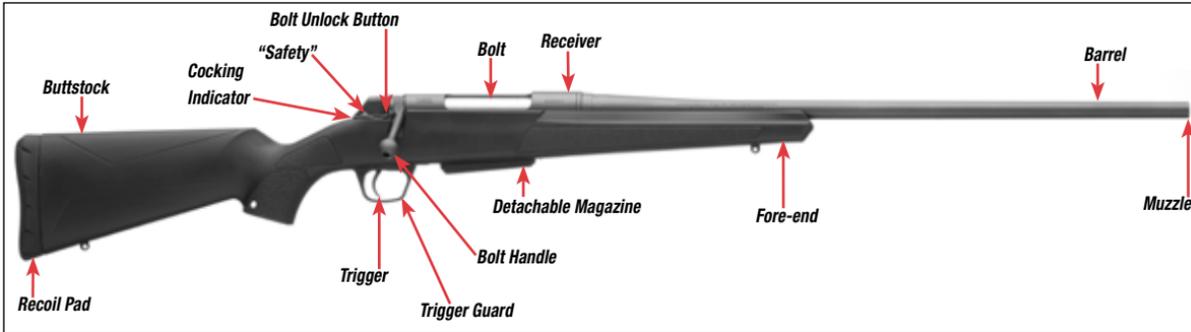
**23 READ AND HEED ALL WARNINGS IN THIS OWNER'S MANUAL, ON AMMUNITION BOXES AND WITH ALL ACCESSORIES THAT YOU INSTALL ON YOUR FIREARM.**

It is your responsibility to secure the most up-to-date information on the safe handling procedures of your Winchester firearm. We assume no liability for incidents which occur when unsafe or improper firearm accessories or ammunition combinations are used.

**24 PRACTICE PERIODIC MAINTENANCE, AVOID UNAUTHORIZED SERVICING.**

Your firearm is a mechanical device which will not last forever, and as such, is subject to wear and requires periodic inspection, adjustment and service. Winchester firearms should be serviced by a

**FIGURE 1**



Winchester Repeating Arms Authorized Repair Center or by our Service Center in Arnold, Missouri. We assume no responsibility for injuries suffered or caused by unauthorized servicing, alterations or modifications of Winchester firearms.

**25 WE RESERVE THE RIGHT TO REFUSE SERVICE ON FIREARMS THAT HAVE BEEN ALTERED, ADDED TO OR SUBSTANTIALLY CHANGED.**

Removal of metal from the barrel, or modifications of the firing mechanism and/or operating parts, may lead to a refusal of service on such firearms. We will charge you for parts and labor to return the firearm to original specifications.

**DO NOT, UNDER ANY CIRCUMSTANCES, ALTER THE TRIGGER, "SAFETY" OR OTHER PARTS OF**

**THE FIRING MECHANISM OF THIS OR ANY OTHER FIREARM. FAILURE TO OBEY THIS WARNING MAY RESULT IN INJURY OR DEATH TO YOURSELF OR OTHERS.**

**BE CAREFUL!**

## GENERAL DESCRIPTION AND OPERATION

### GENERAL DESCRIPTION

The bolt-action Winchester XPR shares the same quality and legendary performance with other rifles that have shared the Winchester name. Made from rugged materials using the most precise methods of modern manufacture, the XPR is sure to meet your shooting expectations.

### GENERAL OPERATION

The XPR is a bolt-action rifle that operates by lifting the bolt handle, drawing the bolt rearward and then sliding the bolt forward and rotating the bolt handle downward until it stops. This process takes a cartridge from the magazine and loads it into the chamber for firing.

Prior to using live ammunition, familiarize yourself thoroughly with the operating instructions in this owner's manual. Get accustomed to the feel of your new firearm and know the forces required to operate the action. Learn how to pull the trigger and, above all, know the location and operation of the "safety." Procedures for disassembly and operation of various components are outlined later in this owner's manual. Please read and study them thoroughly.

### NOMENCLATURE

In conventional firearm terminology the position and movement of firearm parts are described as they occur with the firearm horizontal and in the normal firing

position: i.e., the muzzle is forward or in front; the buttstock is rearward or to the rear; the trigger is downward or underneath; the sight is upward or on top. For general parts nomenclature, refer to Figure 1 on page 6. Figure 5 on pages 10 and 11 covers the general features and benefits of the XPR design.

Throughout this owner's manual the "action" refers to the mechanism of this rifle which loads and secures the cartridges in the chamber.

### SERIAL NUMBER

The serial number is located on the right side of the receiver, just forward of the ejection port. Record the serial number at the front of this owner's manual for future reference.

### INITIAL CLEANING AND OILING

#### **NOTICE**

**PLEASE TAKE NOTE OF THE FOLLOWING INFORMATION BEFORE CLEANING YOUR FIREARM.**

#### *CLEANING PARTS WITH SPECIAL FINISHES*

Be especially careful when cleaning firearms with camouflage, Dura-Touch® Armor Coating and other special finishes. Always prevent these surfaces from coming in contact with cleaning solvents, barrel scrubbers and other strong chemicals. It is preferable to clean these surfaces with a light gun oil containing no

solvents or with a damp cloth and mild dish soap (be sure to keep water out of the action). When cleaning your firearm's bore and action, protect the external finishes from any contact with chemicals used. Also, avoid any contact between external finishes and other strong chemicals like those found in DEET-containing insect repellents, sunscreens, etc. Damage to camouflage, Dura-Touch and other finishes caused by chemicals is irreversible and not repairable.

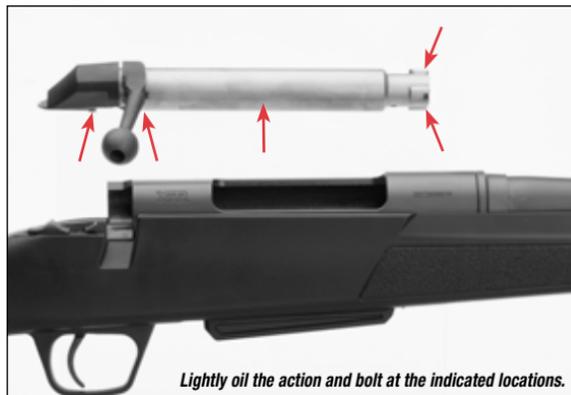
**▲WARNING**

**WEAR EYE PROTECTION WHEN ASSEMBLING AND DISASSEMBLING YOUR RIFLE TO PREVENT SPRINGS, SPRING-LOADED PARTS, SOLVENTS OR OTHER AGENTS FROM CONTACTING YOUR EYES, RESULTING IN INJURY.**

Some metal parts of your new firearm have been coated at the factory with a rust preventative compound. Before using your firearm, clean the anti-rust compound from the inside of the barrel, receiver, bolt mechanism and the action/chamber areas. A high quality, lightweight gun oil should be used to remove this compound and to give your new firearm its first lubrication. Clean the barrel using a cleaning rod and patch as explained under "Cleaning and Maintenance Suggestions" on pages 23-25 in this owner's manual.

Apply a few drops of quality oil on the surfaces shown in Figure 2. Avoid applying too much oil. Only a light film is necessary. Excessive oil should be wiped off, especially in cold weather.

**FIGURE 2**



**OPERATION OF THE "SAFETY"**

**▲WARNING**

**ALWAYS KEEP THE "SAFETY" IN THE ON SAFE POSITION UNLESS SHOOTING IS IMMINENT. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

The "safety" is located on the right side of the receiver to the rear of the bolt handle (when in the locked position).

When the "safety" is drawn to the rear, the "safety" is in the on safe position (Figure 3, page 9). This indirectly blocks the trigger and locks the bolt in the closed position.

**FIGURE 3**



When the "safety" is pushed forward, a red dot is exposed indicating that the "safety" is in the off safe position and the rifle is ready to fire (Figure 4).

**⚠WARNING**

**DO NOT DEPEND ON THE RED COLOR ALONE TO INDICATE YOUR FIREARM'S SAFETY STATUS. TIME, EXPOSURE TO THE ELEMENTS, AND THE ABRASIVE ACTION OF CLEANING AGENTS CAN ERASE IT. FAILURE TO FOLLOW THIS WARNING COULD RESULT IN SERIOUS INJURY OR DEATH.**

The "safety" mechanism, when engaged, is designed to prevent firing. However, this mechanism will not

**FIGURE 4**



necessarily prevent the accidental discharge of this firearm as a result of jarring or abuse such as occurs when a firearm is dropped.

Never rely totally on your firearm's "safety." It is merely an aid to safe gun handling. Like any mechanical device the "safety" can possibly fail; it can be bumped off or inadvertently manipulated into an unsafe condition. Always keep your rifle pointed in a safe direction.

At all times, keep the "safety" in the on safe position and the barrel pointed in a safe direction. It is advisable to never load your rifle until you are in the field, at the location you intend to begin hunting or you are at your bench on a range and it is clear to shoot. For extra safety

**FIGURE 5**



*The "safety" (left) is easy to operate with the thumb of the shooting hand. A Bolt Unlock Button allows the bolt to be operated with the "safety" in the on safe position.*

*A robust bolt design features three locking lugs for solid strength.*



*The M.O.A. Trigger System™ features a three-lever design that is crisp with virtually no take-up, creep or overtravel. Trigger pull is set at approximately 3½ pounds from the factory, and can be adjusted. Overtravel is also adjustable.*

*A premium Inflex Technology recoil pad uses integrated directional deflection ridges to pull the comb away from your face to minimize felt recoil and maximize shooting comfort.*

# XPR™

## RIFLE FEATURES

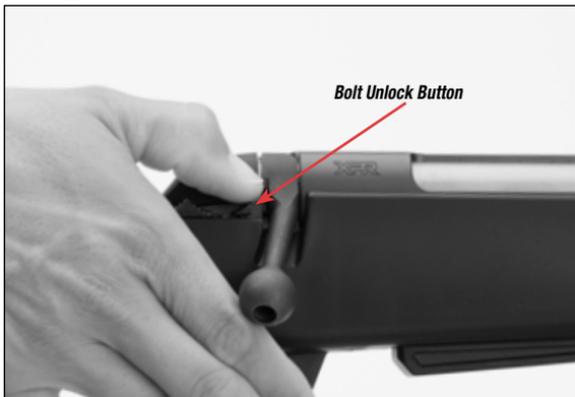
*Button rifled barrels give you the precision you're looking for.*

*The barrel crown is recessed to help prevent damage that can affect accuracy.*



*Textured gripping surfaces provide a solid hand hold in all weather conditions.*

**FIGURE 6**



on a range, and as a courtesy to others, fully unload the rifle and keep the action in the open position at all times other than when it is clear to shoot.

It is essential that you become very familiar with the feel, look and operation of the “safety” on this rifle before attempting to load and shoot it.

### **BOLT UNLOCK BUTTON**

The bolt unlock button is located between the bolt handle and “safety” (Figure 6). The bolt unlock button works in conjunction with the “safety” and allows the bolt to be operated to unload a cartridge from the chamber with the “safety” in the on safe position. To unload the chamber

**FIGURE 7**



with the “safety” in the on safe position, simply press the bolt unlock button down and rotate the bolt upward, then draw it completely rearward.

### **COCKING INDICATOR**

The cocking indicator is located to the rear of the bolt shroud. The indicator is marked with a red dot. When the rifle is cocked it may be felt with the thumb as well as easily seen with a quick glance downward (Figure 7). When the rifle is fired, the cocking indicator retracts into the bolt shroud and cannot be seen or felt.

**⚠️WARNING**

**DO NOT DEPEND ON THE RED COLOR ALONE TO INDICATE YOUR FIREARM'S "SAFETY" STATUS. TIME, EXPOSURE TO THE ELEMENTS, AND THE ABRASIVE ACTION OF CLEANING AGENTS CAN ERASE IT. FAILURE TO FOLLOW THIS WARNING COULD RESULT IN SERIOUS INJURY OR DEATH.**

**INSTALLING AND REMOVING THE BOLT**

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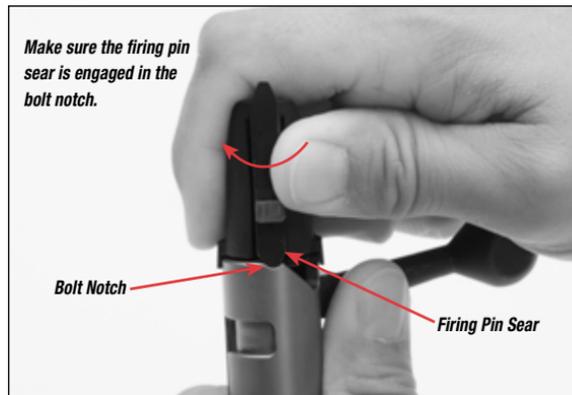
**⚠️WARNING**

**ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. BEFORE INSERTING OR REMOVING THE BOLT, VISUALLY INSPECT THE CHAMBER TO BE ABSOLUTELY CERTAIN THE FIREARM IS COMPLETELY UNLOADED. PLACE THE "SAFETY" IN THE ON SAFE POSITION. FAILURE TO FOLLOW THIS WARNING COULD RESULT IN SERIOUS INJURY OR DEATH.**

The bolt of your rifle may have been packed separately in the carton in which your rifle is shipped. You will need to insert the bolt into the action. In addition, it is always advisable to remove the bolt before cleaning.

Before inserting the bolt into your rifle, make sure the firing pin is cocked. When the firing pin is cocked, the cocking indicator is visible at the rear of the bolt. If the

**FIGURE 8**

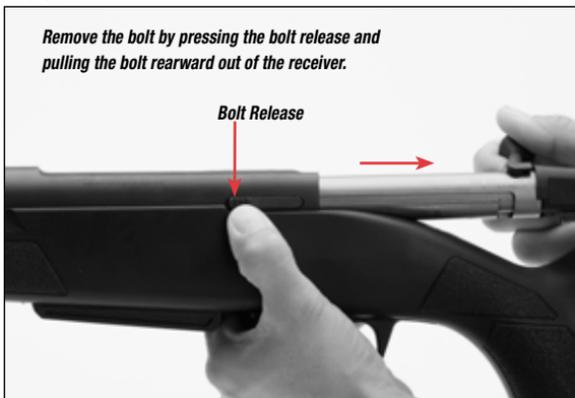


cocking indicator is not in the cocked position this means that the firing pin is not cocked. To cock the firing pin simply turn the rear section of the bolt clockwise (when viewed from the indicator end) until the firing pin sear engages the notch in the bolt handle (Figure 8). On a new rifle where surfaces are not yet burnished from use, it may be difficult to rotate the bolt sleeve by hand. If so, carefully grasp the firing pin sear in a padded vise and lift the bolt handle.

**BOLT INSTALLATION**

1. Align the front of the bolt in the rear opening of the receiver.

**FIGURE 9**



2. Push the bolt completely forward and rotate the handle down to lock it. It is not necessary to depress the bolt release to insert the bolt, but you may do so to ease the installation (Figure 9).
3. Immediately place the “safety” in the on safe position. The rifle is now completely assembled and may be operated normally.

#### **BOLT REMOVAL**

1. Place the “safety” in the on safe position.
2. Press the bolt unlock button and rotate the bolt handle upward.

3. The bolt release is the horizontal bar on the left side of the receiver (Figure 9). Press inward on the front of the bolt release and carefully draw the bolt to the rear and out of the receiver.

#### **NOTICE**

**WHEN REMOVING THE BOLT FROM THE RECEIVER, TAKE CARE TO PREVENT THE COCKING INDICATOR FROM STRIKING AND DAMAGING THE COMB OF THE STOCK.**

The bolt has been carefully selected and fitted at the factory to assure correct headspace. The bolt is etched with your rifle’s serial number for identification purposes. To assure your safety, never interchange bolts with another rifle, as they may not have the proper headspace. If the bolt is lost or damaged, return your rifle to the factory for replacement with a properly fitted bolt.

#### **AMMUNITION**

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#### **⚠WARNING**

**DO NOT USE AMMUNITION OTHER THAN WHAT IS INSCRIBED ON THE LEFT SIDE OF THE BARREL. EXAMINE EVERY CARTRIDGE YOU PUT IN YOUR FIREARM.**

**DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO CAUSE BIRTH**

**DEFECTS, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS THOROUGHLY AFTER HANDLING AMMUNITION.**

The barrel and action of this rifle have been made with substantial safety margins over the pressures developed by established American loads. However, we assume no responsibility for incidents which occur through the use of cartridges of nonstandard dimension or those developing pressures in excess of SAAMI (Sporting Arms and Ammunition Manufacturers' Institute) established standards.

### **MAGAZINE CAPACITY**

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The magazine capacity for standard and magnum calibers is three rounds. It is extremely important that you know the magazine capacity of your rifle. Under appropriate circumstances, at a range or other suitable shooting location, load your magazine to full capacity and confirm the number of cartridges. Remember, "total" capacity includes an additional round which can be loaded in the chamber in addition to a full magazine.

### **LOADING**

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**⚠WARNING**

**WHEN LOADING YOUR RIFLE ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION, ALWAYS PLACE THE**

**"SAFETY" IN THE ON SAFE POSITION AND KEEP YOUR FINGERS AWAY FROM THE TRIGGER. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

**TO AVOID ACCIDENTAL DISCHARGE DO NOT CARRY YOUR RIFLE WITH A CARTRIDGE IN THE CHAMBER. WHEN FIRING IS NO LONGER IMMINENT, PLACE THE "SAFETY" IN THE ON SAFE POSITION, PRESS THE BOLT UNLOCK BUTTON AND UNLOAD THE CHAMBER. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

There are two methods used to load a cartridge into the chamber of the rifle: 1) Loading from the magazine 2) Loading through the ejection port.

#### **LOADING THE MAGAZINE**

1. Eject the magazine from the rifle by pulling the magazine release, located on the forward edge of the magazine, rearward with your index finger. The magazine will drop into your hand (Figure 10, page 16).
2. Place the rim of a cartridge on the front of the follower and press down on the follower with the rim of the cartridge while simultaneously sliding the cartridge rearward into the magazine under the feed lips (Figure 11, page 16). Load subsequent cartridges into the magazine in the same manner.

FIGURE 10

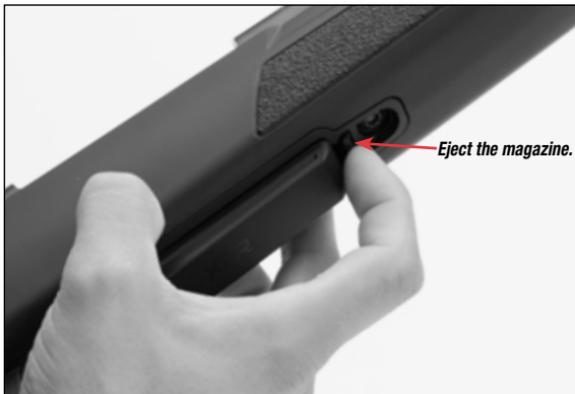


FIGURE 11



**NOTICE**

**THE BASE OF EACH CARTRIDGE MUST BE FLUSH WITH THE REAR OF THE MAGAZINE. IF THE NOSE OF A CARTRIDGE PROTRUDES BEYOND THE FRONT OF THE MAGAZINE, IT COULD CAUSE FEEDING PROBLEMS OR INTERFERE WHEN INSERTING THE MAGAZINE INTO THE RIFLE.**

**LOADING THE CHAMBER FROM THE MAGAZINE**

1. Close the bolt and place the “safety” in the on safe position.

2. Load the magazine as explained previously.
3. Insert the loaded magazine into the rifle by inserting it into the magazine well until it is retained in place by the magazine catch.
4. Load the chamber by pressing the bolt unlock button and simultaneously lifting the bolt handle completely up. Release the bolt unlock button and draw the bolt completely rearward, then push the bolt forward and rotate the bolt handle down.
5. Immediately verify that the “safety” is in the on safe position.

**⚠WARNING**

**THE RIFLE IS NOW READY TO FIRE BY SIMPLY MOVING THE “SAFETY” TO THE OFF SAFE POSITION AND PULLING THE TRIGGER.**

**LOADING THE RIFLE TO FULL CAPACITY**

1. Close the bolt and place the “safety” in the on safe position.
2. Load the magazine as explained previously.
3. Insert the loaded magazine into the rifle by inserting it into the magazine well until it is retained in place by the magazine catch.
4. Load the chamber by pressing the bolt unlock button and simultaneously lifting the bolt handle completely up. Release the bolt unlock button and draw the bolt completely rearward, then push the bolt forward and rotate the bolt handle down.
5. Immediately verify that the “safety” is in the on safe position.

**⚠WARNING**

**THE RIFLE IS NOW READY TO FIRE BY SIMPLY MOVING THE “SAFETY” TO THE OFF SAFE POSITION AND PULLING THE TRIGGER.**

6. Eject the magazine from the rifle by pulling the magazine release button rearward with your index finger. The magazine will drop into your hand.

7. Load a single cartridge into the magazine as explained previously.
8. Insert the fully-loaded magazine into the rifle.

**SINGLE SHOT LOADING FROM THE MAGAZINE**

If you wish to fire a single-shot from your rifle, it is recommended that you use the following loading procedure.

1. Remove the magazine from the rifle as explained on page 15.
2. Pull the bolt completely rearward and inspect the chamber to make sure it is empty.
3. Close the bolt and place the “safety” in the on safe position.
4. Load a single cartridge into the magazine.
5. Insert the magazine into the rifle.
6. When ready to shoot, cycle the bolt fully to load the single cartridge from the magazine into the chamber.
7. Immediately verify that the “safety” is in the on safe position.

**⚠WARNING**

**THE RIFLE IS NOW READY TO FIRE BY SIMPLY MOVING THE “SAFETY” TO THE OFF SAFE POSITION AND PULLING THE TRIGGER.**

### **SINGLE SHOT LOADING DIRECTLY TO THE CHAMBER**

You may also load your rifle by placing a cartridge directly into the chamber. To load the rifle in this manner, use the following loading procedure.

1. Insert an unloaded magazine into the rifle.
2. Pull the bolt rearward and inspect the chamber to make sure it is empty.
3. Insert a single cartridge into the ejection port and place it on top of the magazine.
4. When ready to shoot, push the bolt completely forward and rotate the bolt handle down to load the single cartridge into the chamber.
5. Immediately verify that the “safety” is in the on safe position.

#### **▲WARNING**

**THE RIFLE IS NOW READY TO FIRE BY SIMPLY MOVING THE “SAFETY” TO THE OFF SAFE POSITION AND PULLING THE TRIGGER.**

### **FIRING**

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#### **▲WARNING**

**NEVER CHAMBER A CARTRIDGE OR MOVE THE “SAFETY” FROM THE ON SAFE POSITION UNLESS SHOOTING IS IMMINENT. ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. FAILURE TO FOLLOW**

### **THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

1. Load a cartridge into the chamber (as explained previously) from the magazine or directly to the chamber.
2. With a cartridge in the chamber, you need only move the “safety” to the off safe position to make the rifle ready for firing.
3. When ready to fire, move the “safety” to the off safe position, take aim and squeeze the trigger.
4. After a cartridge is fired, cycle the bolt rearward to eject the empty case. If you wish to continue shooting, and the magazine contains ammunition, push the bolt fully forward. This picks up a loaded cartridge from the magazine and chambers it. You may continue to fire the rifle in this manner until the magazine is empty by pulling the trigger to fire each cartridge.
5. If you are done shooting, leave the bolt to the rear, with the breech in the open position so that you may visually inspect the chamber, barrel and magazine to be sure they contain no cartridges.

#### **▲WARNING**

**AFTER FIRING, OR WHEN SHOOTING IS NO LONGER IMMINENT, IMMEDIATELY PLACE THE “SAFETY” IN THE ON SAFE POSITION. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

**EVEN WITH THE BOLT OPEN AFTER SHOOTING, DO NOT ASSUME THE RIFLE IS UNLOADED. ALWAYS INSPECT THE CHAMBER, BARREL, FEED MECHANISM AND MAGAZINE TO BE CERTAIN THE RIFLE IS COMPLETELY UNLOADED. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

## **UNLOADING**

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### **⚠WARNING**

**WHEN UNLOADING YOUR RIFLE ALWAYS PLACE THE “SAFETY” IN THE ON SAFE POSITION. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AND YOUR FINGERS AWAY FROM THE TRIGGER. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

**ALWAYS INSPECT THE CHAMBER, BARREL AND MAGAZINE CAREFULLY AFTER UNLOADING TO BE SURE ALL LIVE CARTRIDGES ARE CLEARED FROM THE FIREARM.**

### **UNLOADING THE RIFLE**

1. Open the bolt and eject any cartridge in the chamber. Leave the bolt in the rearward position with the action open.
2. Look into the chamber to verify that it is unloaded.
3. Push the magazine release button rearward and remove the magazine.

4. With the chamber empty and the magazine removed, close the bolt and ensure the “safety” is in the on safe position.
5. Strip all the cartridges from the magazine as explained below.
6. Place the empty magazine into the rifle until it is retained by the magazine catch.

### **UNLOADING THE MAGAZINE**

1. Remove the magazine as explained previously.
2. Strip all the cartridges from the magazine by pushing forward on the rim of the top cartridge and slide each cartridge out of the magazine, one at a time.
3. Unload any extra magazines.

## **TRIGGER ADJUSTMENT**

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### **⚠WARNING**

**WHEN UNLOADING YOUR RIFLE ALWAYS PLACE THE “SAFETY” IN THE ON SAFE POSITION. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION AND YOUR FINGERS AWAY FROM THE TRIGGER. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

**CAREFULLY INSPECT THE CHAMBER, BARREL AND MAGAZINE AFTER UNLOADING TO BE SURE ALL LIVE CARTRIDGES ARE CLEARED FROM THE FIREARM.**

**FIGURE 12**



The M.O.A Trigger™ System (Minute of Angle) is pre-set at the factory at approximately 3½ pounds and can be adjusted within a range of 3 to 5 pounds. Though trigger adjustments should be unnecessary, the trigger pull weight and overtravel can be tuned to your specifications. We recommend this procedure be performed by a qualified gunsmith.

#### **ADJUSTING TRIGGER PULL WEIGHT**

1. Remove the magazine.
2. Open the bolt and ensure the rifle is completely unloaded. Remove the bolt as explained on page 14.
3. Remove the two action screws with a 4mm or 5/32" Allen wrench (Figure 12).

**FIGURE 13**



4. Lift the trigger guard and bottom plate from the stock (Figure 13).
5. Carefully lift the barreled action out of the stock (Figure 15, page 21).
6. There are two screws in front of the trigger housing. The screw that is furthest from the action can be turned to adjust trigger pull weight, and the screw that is closest to the action can be turned to adjust overtravel (Figure 15, page 21).

To decrease the trigger pull weight, turn the adjustment screw that is furthest from the action in a counterclockwise direction using a 1/16" Allen wrench.

**FIGURE 14**



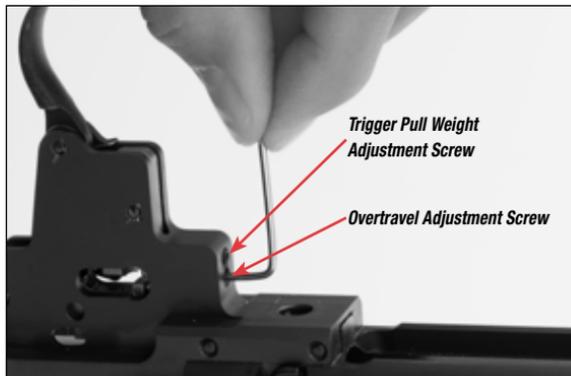
**NOTICE**

**THE TRIGGER PULL WEIGHT SCREW WILL FALL OUT WHEN THE TRIGGER HAS BEEN ADJUSTED TO ITS MINIMUM PULL WEIGHT OF 3 POUNDS.**

To increase the trigger pull weight, turn the adjustment screw that is furthest from the action in a clockwise direction using a  $\frac{1}{16}$ " Allen wrench.

**NOTICE! DO NOT TURN THE TRIGGER PULL WEIGHT SCREW IN TOO FAR. DOING SO WILL LIMIT THE TRIGGER TRAVEL, RENDERING THE TRIGGER INOPERATIVE, AND COULD DAMAGE THE PULL WEIGHT SPRING.**

**FIGURE 15**



7. Trigger pull weight can be measured, with the rifle completely unloaded and the bolt closed, using a very accurate spring scale or a commercially available set of trigger pull measuring weights. Most gunsmiths can also measure trigger weight pull for you.

**NOTICE**

**IF TRIGGER PULL WEIGHT IS INCREASED TOO MUCH, THE TRIGGER CANNOT BE PULLED. TURN THE SCREW COUNTERCLOCKWISE UNTIL THE TRIGGER CAN BE PULLED.**

8. When finished making the adjustment, place a drop of serviceable thread locker on the adjustment screw.

9. Place the barreled action back in the stock and reinstall the trigger guard and bottom plate (trigger guard end first). Torque the two action screws to 35 inch pounds.

#### ADJUSTING TRIGGER OVERTRAVEL

Overtravel is the amount the trigger moves after the firing pin has been released by the sear. It should not be necessary to adjust overtravel on your XPR. However, should overtravel require adjustment, perform the following procedures:

1. Remove the magazine.
2. Open the bolt and ensure the rifle is completely unloaded. Remove the bolt as explained on page 14.
3. Remove the two action screws with a 4mm or  $5/32$ " Allen wrench (Figure 12).
4. Lift the trigger guard from the stock (Figure 13).
5. Carefully lift the barreled action out of the stock (Figure 15, page 21).
6. There are two screws in front of the trigger housing. The screw that is furthest from the action can be turned to adjust trigger pull weight, and the screw that is closest to the action can be turned to adjust overtravel (Figure 15, page 21).

To increase the amount of overtravel, turn the adjustment screw closest to the action in a counterclockwise direction using a  $1/16$ " Allen wrench.

To decrease the amount of overtravel, turn the adjustment screw closest to the action in a clockwise direction using a  $1/16$ " Allen wrench.

#### **NOTICE**

**IF THE OVERTRAVEL SCREW IS TURNED IN TOO FAR, THE TRIGGER CANNOT BE PULLED FAR ENOUGH TO RELEASE THE SEAR AND FIRE THE RIFLE. TURN THE SCREW COUNTERCLOCKWISE UNTIL THE TRIGGER CAN BE PULLED.**

7. When finished making the adjustment, place a drop of serviceable thread locker on the adjustment screw.
8. Place the barreled action back in the stock and reinstall the trigger guard. Torque the two action screws to 35 inch-pounds.

#### MOUNTING A SCOPE

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#### **⚠WARNING**

**BEFORE MOUNTING A SCOPE, SIGHT OR OTHER ACCESSORIES TO YOUR RIFLE, PLACE THE "SAFETY" IN THE ON SAFE POSITION. PRESS THE "SAFETY" BUTTON, OPEN THE ACTION AND MAKE CERTAIN YOUR RIFLE IS COMPLETELY UNLOADED. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

The top of the XPR receiver is drilled and tapped for scope bases. Each scope base is mounted using two 8-40 screws. The scope base holes are usually fitted with filler screws.

### **NOTICE**

#### **ALWAYS USE THE CORRECT BASES FOR THIS RIFLE AND THE APPROPRIATE LENGTH SCREWS.**

1. Place your rifle in a gun vise or on a table or other safe/secure location. Protect the finish with rags or other padding.
2. You should have a compatible one- or two-piece style base and four screws of the correct length.
3. Clean all oil, grease or dirt from the receiver top and from the scope base parts.
4. Position your rifle with the top of the receiver upward.
5. Remove the four plugs from the top of the receiver using a very small, thin-bladed gunsmithing-type screwdriver.
6. Pre-position the bases on the receiver top to determine the best orientation of the bases.
7. Insert the screws through the bases and screw them into the receiver top using the correct tool.

You must use 8-40 screws of the appropriate length to ensure proper thread engagement. Once the bases are installed, check inside the receiver to verify that the base mounting screws are not too long and interfering with the operation of the bolt.

Many gunsmiths find it helpful to use a drop of serviceable thread locking compound to assure the screws stay tight. Make sure the thread locking compound does not get into the action or trigger.

Be careful to assure that the threads of each screw engage properly in the threads in the receiver to prevent stripping the threads in the receiver.

8. Tighten the screws snugly, but do not overtighten.
9. Mount your scope rings and scope as outlined in the instructions supplied with your scope rings and/or scope. Always make sure you have the proper eye relief. Always make sure that the saddle crossbolts and cap bolts are fully tightened before using your firearm.

### **CLEANING AND MAINTENANCE SUGGESTIONS**

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#### **NOTICE**

#### **PLEASE TAKE NOTE OF THE FOLLOWING INFORMATION BEFORE CLEANING YOUR FIREARM.**

##### *CLEANING PARTS WITH SPECIAL FINISHES*

Be especially careful when cleaning firearms with camouflage, Dura-Touch® Armor Coating and other special finishes. Always prevent these surfaces from coming in contact with cleaning solvents, barrel scrubbers and other strong chemicals. It is preferable to clean these surfaces with a light gun oil containing no solvents or with a damp cloth and mild dish soap (be sure to keep water out of the action). When cleaning your firearm's

bore and action, protect the external finishes from any contact with chemicals used. Also, avoid any contact between external finishes and other strong chemicals like those found in DEET-containing insect repellents, sunscreens, etc. Damage to camouflage, Dura-Touch and other finishes caused by chemicals is irreversible and not repairable.

**⚠️WARNING**

**BEFORE PERFORMING CLEANING PROCEDURES, PLACE THE “SAFETY” IN THE ON SAFE POSITION. PRESS THE BOLT UNLOCK BUTTON, OPEN THE ACTION AND MAKE CERTAIN YOUR RIFLE IS COMPLETELY UNLOADED. KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

**⚠️WARNING**

**WEAR EYE PROTECTION WHEN DISASSEMBLING AND CLEANING YOUR RIFLE TO PREVENT SPRINGS, SPRING-LOADED PARTS, SOLVENTS OR OTHER AGENTS FROM CONTACTING YOUR EYES, RESULTING IN INJURY.**

**⚠️WARNING**

**KEEP ALL AMMUNITION AWAY FROM THE CLEANING AREA. NEVER TEST THE MECHANICAL FUNCTION OF YOUR RIFLE WITH LIVE AMMUNITION. FAILURE TO FOLLOW THESE WARNINGS COULD RESULT IN SERIOUS INJURY OR DEATH.**

## **CLEANING PROCEDURES**

Your XPR will function better and more reliably over a longer period of time if it is properly maintained and kept clean. Clean your firearm after every day of shooting, and more often if it becomes excessively dirty. A minimum cleaning includes wiping down the firearm and oiling key parts. Regular maintenance also includes cleaning the barrel.

If you encounter a function problem be sure to give your firearm a thorough cleaning to see if it solves the problem before seeking the services of a Winchester Authorized Repair Center or our Service Center in Arnold, Missouri or a qualified gunsmith.

1. Remove the bolt as explained previously.
2. Inspect the chamber and bore for powder fouling. A normal amount of powder residue can be expected and is not serious. It can usually be removed with a patch saturated with nitro solvent.

Use a cleaning rod with a tip and patch large enough for a snug fit in the bore. Insert the rod and patch into the barrel at the breech end and run it back and forth several times. Care should be exercised to ensure that the cleaning rod does not strike the crown of the muzzle, as damage to this area can affect the accuracy of your rifle.

If, or when, fouling should become heavy, it can be removed with a brass bore brush. Dip or spray the brush with nitro solvent and scrub the chamber and bore until the fouling is removed. To prevent brass

bristles from breaking off, the brush should be pushed completely through the barrel before being withdrawn.

To maintain the utmost accuracy of your rifle it is recommended you clean the bore with a copper solvent. Modern bullet jackets are made mainly of copper. Residues from copper bullet jackets stick to the barrel and require more frequent cleaning. Magnum calibers will require more frequent inspection and cleaning. Swab the bore of your rifle with a good copper solvent using the manufacturer's recommended procedure.

3. After all fouling has been removed, the chamber and bore should be wiped dry. When the bore is dry, pass a slightly oiled patch through it for preservation. A fine, light gun oil is recommended.
4. Inspect the barrel and chamber to be certain no patches have inadvertently been left in them. Remove any that remain.
5. Use a small brush or rag to remove dirt or other foreign matter from inside the receiver and other parts of the action. Lightly lubricate all moving parts with a high-quality, light gun oil. Use oil sparingly, a very light film is sufficient. A fine, light gun oil is ideally suited for this purpose.

#### **NOTICE**

**DO NOT POUR LARGE QUANTITIES OF OIL INTO THE RECEIVER OR OTHER PARTS. IT CAN DRAIN INTO THE WOOD AND SOFTEN IT, CAUSING PERMANENT DAMAGE AND LOOSENING OF THE STOCK.**

6. Wipe all exposed metal surfaces with a lightly oiled cloth making certain that all finger marks are removed. Finger marks provide a place where moisture can accumulate. The metal of the gun should receive a light film of oil any time the rifle has been exposed to weather or handling.
7. Wood surfaces can also be wiped with a quality, lightweight gun oil or they can be polished with any quality furniture wax (but not both).

#### **CLEANING THE MAGAZINE**

Frequently inspect magazines to determine the need for cleaning as lubricant and dirt will gradually collect in the mechanism. Normally, the magazine should be cleaned after firing 500 to 1,000 cartridges.

#### **NOTICE**

#### **DO NOT DISASSEMBLE THE MAGAZINE.**

1. Clean the magazine by spraying it with a metal and polymer-safe gun cleaning solvent. Spray the magazine with this solvent, both inside and out, to loosen debris.
2. Place your finger over the loading port and shake it vigorously (with the loading port away from you) to remove solvent and residue from the magazine.
3. Use compressed air to dry the magazine or allow it to air dry.

## **NOTICE**

**NEVER ATTEMPT TO TAKE YOUR FIREARM APART FURTHER THAN EXPLAINED IN THIS OWNER'S MANUAL. YOUR FIREARM IS A SPECIALIZED, FINELY FITTED MECHANISM. YOU MAY PERMANENTLY DAMAGE IT BY ATTEMPTING TO DISASSEMBLE THE INNER MECHANISM. IF FURTHER DISASSEMBLY FOR SERVICE OR CLEANING IS REQUIRED, TAKE YOUR FIREARM TO A QUALIFIED GUNSMITH, OR CONTACT OUR ARNOLD, MISSOURI SERVICE FACILITY AS EXPLAINED UNDER "PARTS, SERVICE, REPAIR AND QUESTIONS" BELOW.**

## **PARTS, SERVICE, REPAIR AND QUESTIONS**

If your Winchester firearm should ever need service or repair, it is often best to utilize one of our Authorized Repair Centers. In some cases it is appropriate to use the Winchester Repeating Arms Service Center in Arnold, Missouri. A list of Authorized Repair Centers was included with your new firearm. If you need a new listing, contact us. We can help you determine the best place to service your firearm.

In order to avoid delays, it is important to never send your firearm directly to our facility without direct authorization from one of our service specialists. This avoids possible delays in obtaining service. Contact us at (800) 322-4626 for details on how to receive service before sending your firearm.

Parts listings, Authorized Repair Centers, service procedures, Service/Repair Form and general product information are also found on the web at: [winchesterguns.com](http://winchesterguns.com).

When returning your firearm for servicing, you must do the following:

1. Be sure it is completely unloaded.
2. Remove the scope or other optics.
3. Package it securely in a cardboard container.
4. Enclose the service/repair form available at [winchesterguns.com](http://winchesterguns.com) or a letter that clearly describes the trouble experienced, the ammunition used and the repairs desired. Also include your name and a daytime phone number where you can be reached.
5. If convenient, send a copy of the service/repair form or letter to us separately.
6. Never return ammunition with your firearm. It is against postal and most commerce regulations.

## ***PARTS, SERVICE, REPAIR STATUS AND TECHNICAL QUESTIONS***

**Winchester Repeating Arms Parts and Service**  
3005 Arnold Tenbrook Road  
Arnold, MO 63010-9406  
(800) 322-4626

## GENERAL PRODUCT AND HISTORICAL QUESTIONS

### Winchester Repeating Arms Customer Service

275 Winchester Avenue  
Morgan, UT 84050-9333  
(800) 945-5237

#### **⚠WARNING**

**PARTS ARE MADE FOR WINCHESTER BRAND FIREARMS MANUFACTURED BY OR FOR WINCHESTER REPEATING ARMS, AND SHOULD NOT BE USED IN OTHER FIREARMS, EVEN THOUGH MODELS MAY BE SIMILAR. IMPROPERLY FITTED PARTS MAY BE DANGEROUS.**

#### WEBSITE INFORMATION

An information resource for Winchester Repeating Arms is found on the World Wide Web.

- List of Authorized Repair Centers.
- Customer Service information.
- Firearm Service/Repair Form.
- Answers to many technical and historical questions.
- Links to helpful sites.

Go to: [winchesterguns.com](http://winchesterguns.com)

## NOTES

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Winchester Repeating Arms

275 Winchester Avenue

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[winchesterguns.com](http://winchesterguns.com)

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