

How to: Disassemble and Reassemble

US-M1917 Bolt Action



Nomenclature Disclaimer: Depending on what technical resources you use, you may find different nomenclature conventions when labeling parts of a rifle.

An example of this: the m1917 bolt's spring is sometimes referred to as the **Main Spring** or the **Striker Spring**. Our intention is to establish a common operating language for the sake of the disassembly and reassembly instructions. This is why we have included a helpful parts legend.

These instructions are not meant to be a collector's reference to the correct nomenclatures, only a guide to disassembling.

Disassembly Instructions



1) Point rifle in safe direction.

Open the **bolt** and pull to rear.

Make sure rifle is not loaded.



2) Set the **safety** to safe position, as shown in **figure 2**.



3) While applying pressure forward on the **bolt handle** a gap will open between the **cocking piece** and the **bolt sleeve**. Place a penny or nickel in the gap.



4) Release the **bolt handle** so the gap closes and the coin is held in the gap between the **cocking piece** and **bolt sleeve**.

NOTE: Not all m1917 bolts will require the safety closed to produce the gap when the bolt handle is pressed forward.



5) Swing the **thumb piece** of the **bolt stop** and remove the **bolt**, while making sure not to disturb the coin.



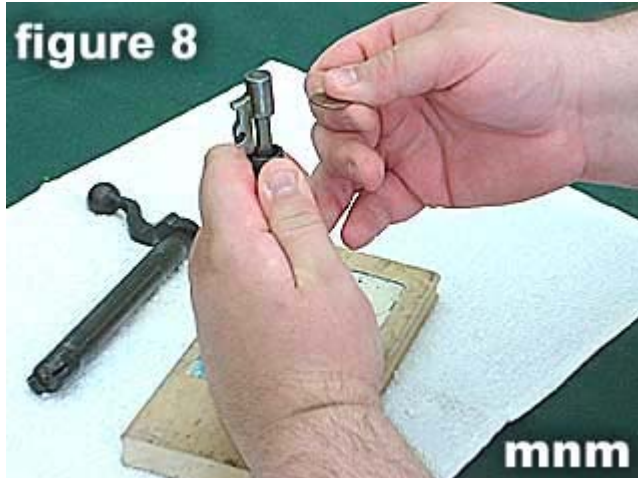
6) Turn the **bolt sleeve** counter-clockwise until you can separate it from the **bolt body**.



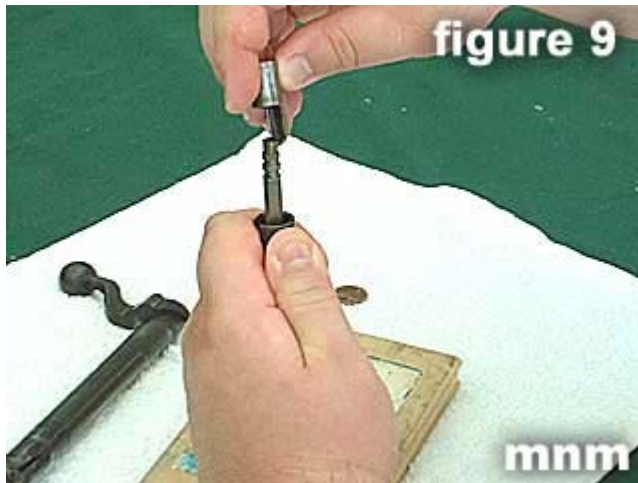
7) Separate the **bolt body** and **striker assembly**.

NOTE: The **striker assembly** while assembled is under considerable tension because of the **striker spring**. When disassembled, the **striker spring** can fly

out and cause bodily harm or damage to your surroundings.



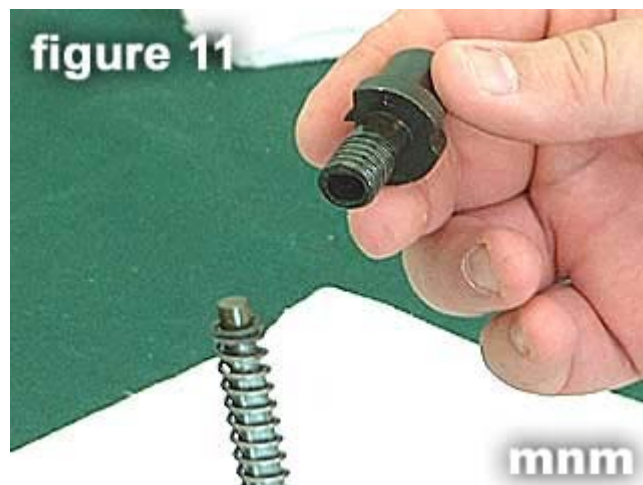
8) Using a block of wood, place the point of the **striker** on the wood. Grasp the **bolt sleeve** and compress the **striker spring**.



9) When the **bolt sleeve** clears the **cocking piece**, turn the **cocking piece** a quarter turn, in either direction and then remove it.



10) Slowly and very carefully allow the **striker spring** to expand.



11) Remove the **bolt sleeve**.



12) Remove the **striker spring** from the **striker**.



13) Turn the **extractor** (*clockwise*) so that it covers the **gas escape holes** in the **bolt body**.



14) Continue to push the **extractor** forward until it is free of the **extractor collar's T**.



15) Figure 15 shows the disassembled m1917 bolt.

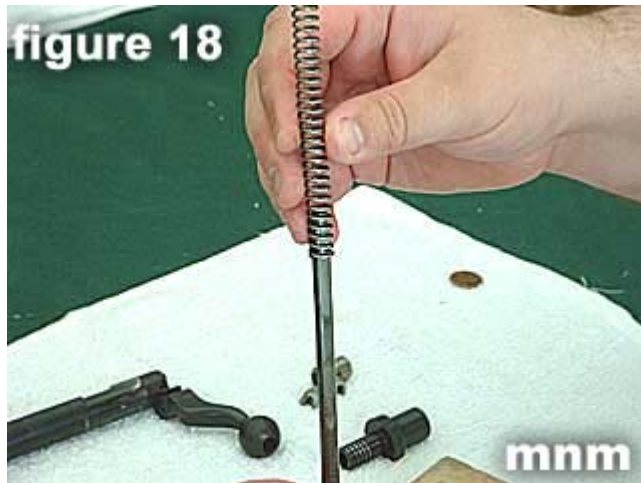
Reassembly Instructions



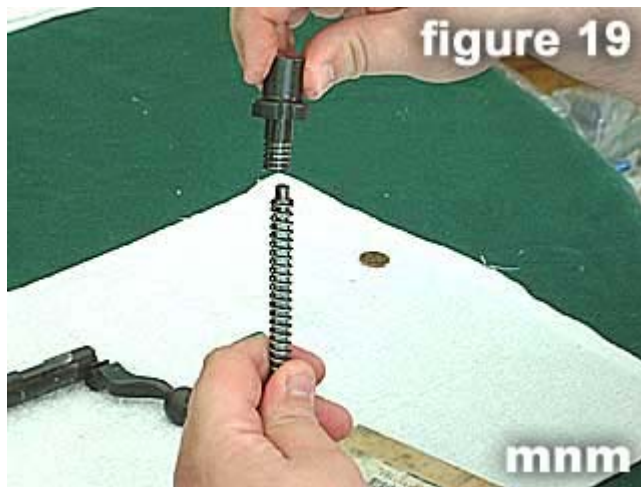
16) Slide the **extractor** over the T mount on the **extractor collar**.



17) Slide the **extractor** down onto the **bolt body** and move it counter-clockwise until it is in the groove at the front of the **bolt body**.



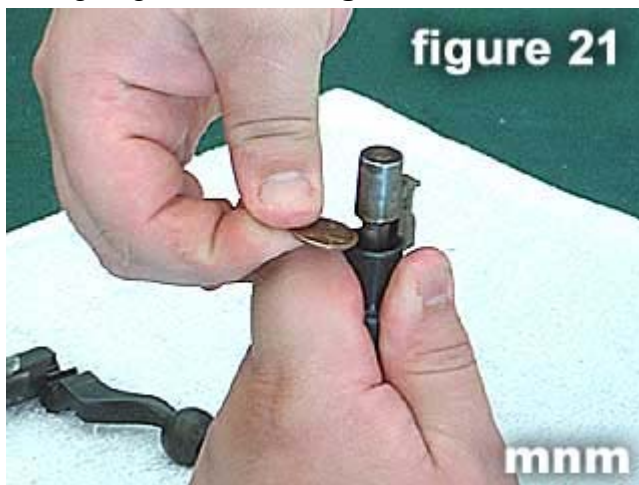
18) Place the **striker spring** on the **striker**.



19) Place the **bolt sleeve** over the **striker**.



20) Hold the **bolt sleeve** while compressing the **striker spring**, replace the **cocking piece** on the end of the **striker** and lock it by turning it a quarter turn so that its **lug** aligns with the **lug-slot** in the **bolt sleeve**.



21) With the **bolt sleeve** keeping the **striker spring** compressed, return the coin to the gap as shown in **figure 21**.



22) Insert **striker assembly** into the **bolt body** and turn clockwise.



23) Figure 23 shows the assembled m1917 bolt.



24) Align the **bolt's extractor** with right hand **locking lug** (solid - not slotted lug) on **bolt** and then insert into rear of **receiver**.

Make sure **cocking piece lug** is aligned with **cocking piece groove** in rear of **receiver** before pushing the **bolt** fully into **receiver**.



25) Make sure **safety** is engaged (*in safe position*).



26) Apply forward pressure on the **bolt handle** and remove the coin from gap.



27) Turn **safety** to **fire position** (forward) and insert bolt fully into receiver.

Figure 27 show the completed job.