

Collecting and Shooting the Military Surplus Rifle



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Number	Description
1	Bolt Body
2	Extractor
3	Cocking Piece
4	Bolt Sleeve
5	Main Spring



1) Point the rifle in safe direction.

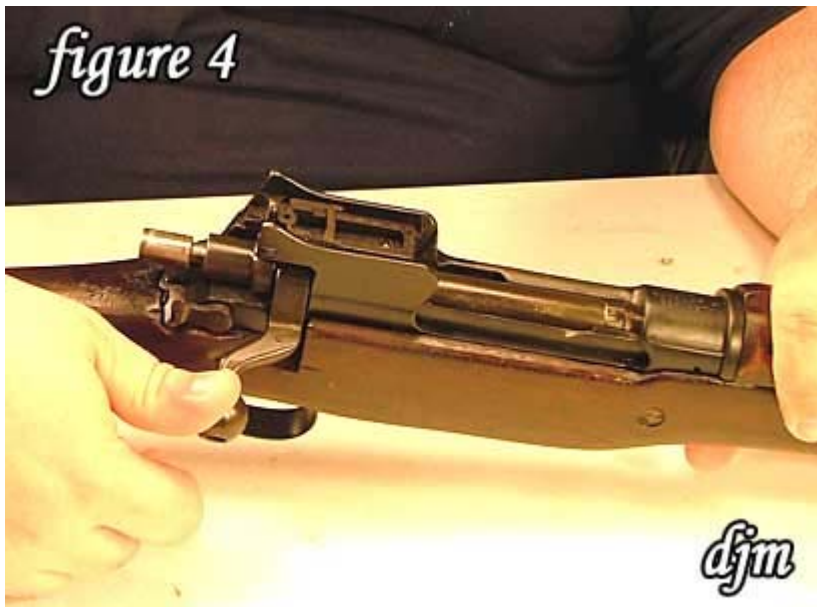
Open the bolt and pull to rear.

Make sure rifle is not loaded.



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

3) Close the bolt.



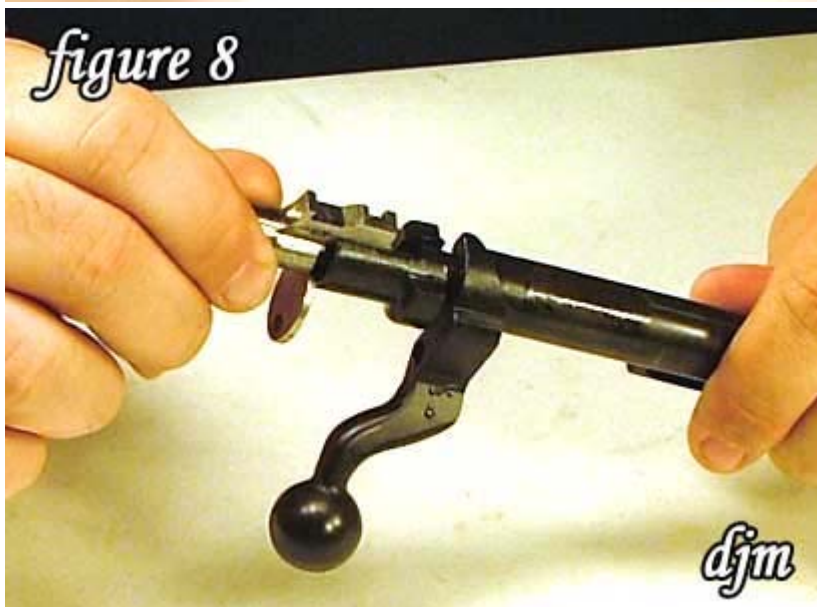
4) While applying pressure forward on the bolt handle a gap will open between the cocking piece and the bolt sleeve.

5) Place a coin (nickel) in the gap.



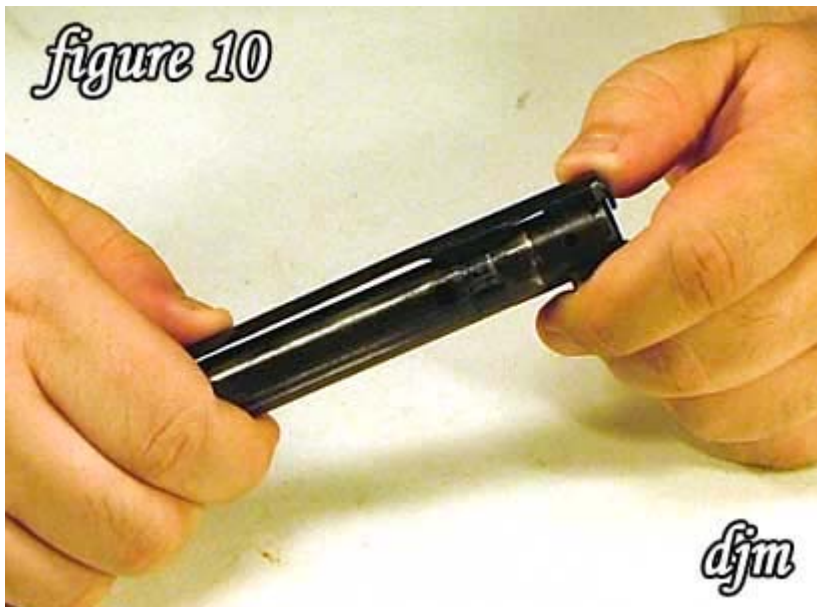
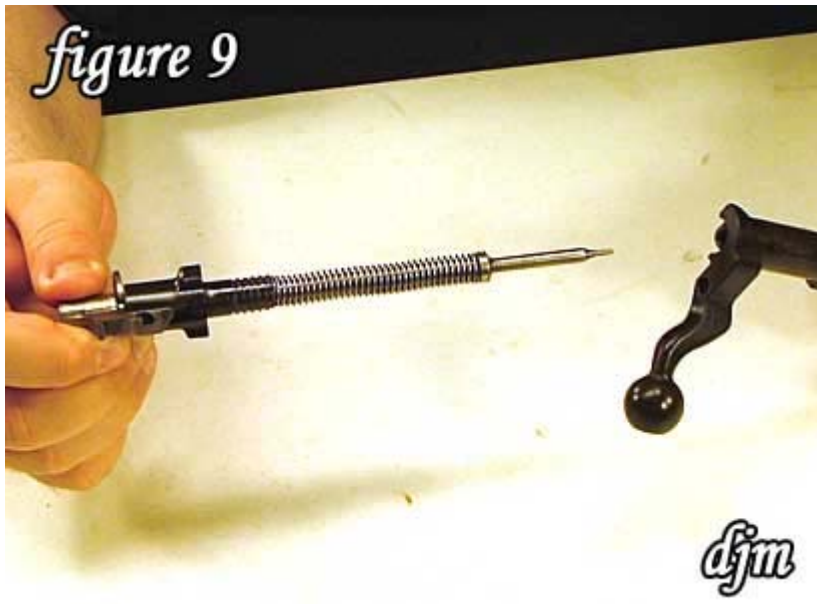
6) Release the bolt handle so the gap closes and the coin is held in the gap between the cocking piece and bolt sleeve.

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



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

9) Separate the bolt body and firing pin assembly.



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

11) Push the extractor forward until it is free of the extractor collar's T.



12) Remove the extractor.

13) Using a block of wood, place the point of the firing pin on the wood. Grasp the bolt sleeve and compress the main spring. Remove the coin.



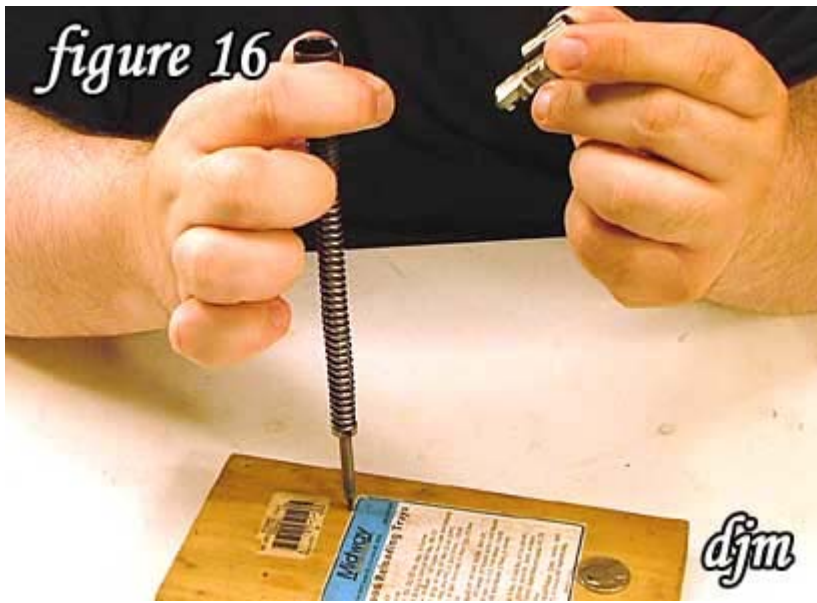
figure 13



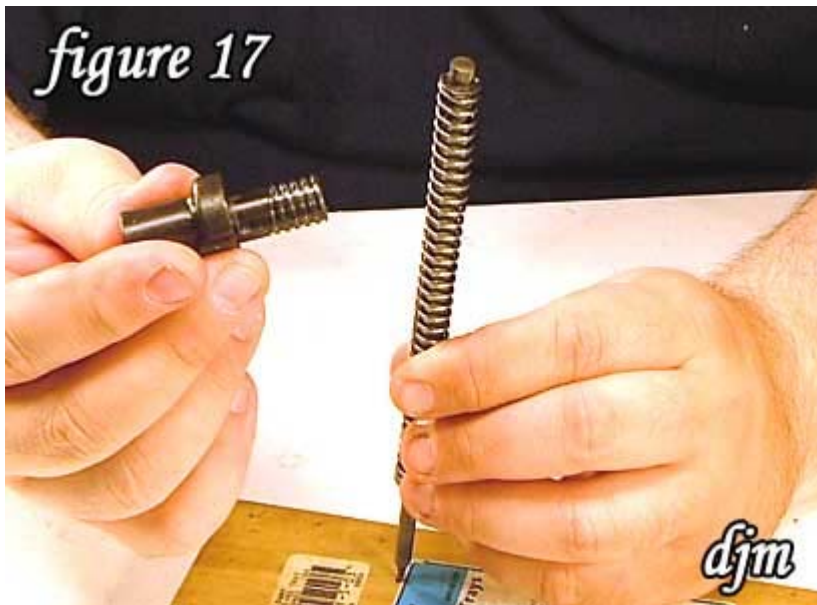
figure 14

14) When the bolt sleeve clears the cocking piece, turn the cocking piece a quarter turn, in either direction.

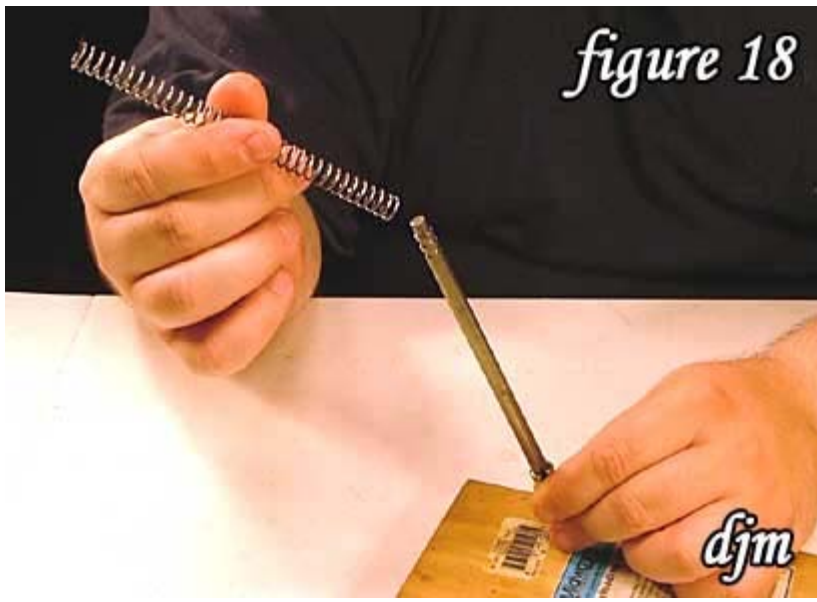
15) Remove the cocking piece.



16) Slowly and very carefully allow the main spring to expand.



17) Remove the bolt sleeve.



18) Remove the main spring from the striker.



19) Figure 19 shows the disassembled m1917 bolt.

Reassembly Instructions

20) Figure 20 shows the bottom of the extractor and the adjacent extractor collar.



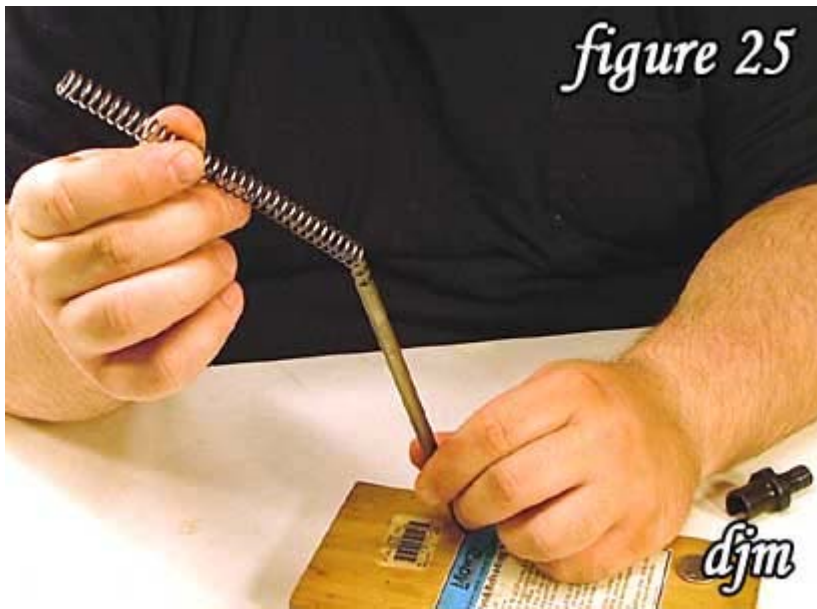
21) Slide the extractor over the T mount on the extractor collar.

22) Carefully lift the top of the extractor only enough to clear the edge of the face of the bolt. Slide the extractor down onto the bolt body and over the extractor collar.



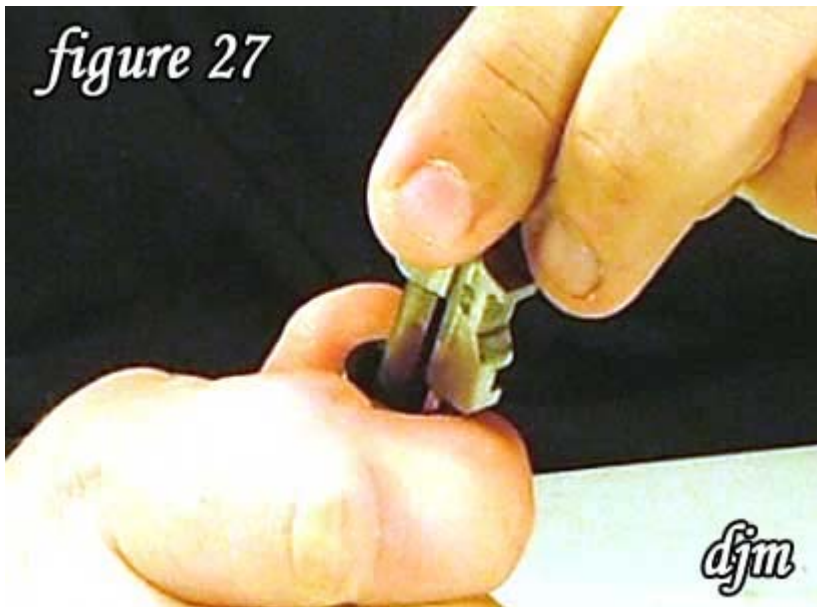
23) Rotate the extractor counter-clockwise until it is in the groove at the front of the bolt body.

24) Figure 24 shows the correctly installed extractor.



25) Place the main spring on the firing pin.

26) Place the bolt sleeve over the firing pin.



27) Hold the bolt sleeve while compressing the main spring, replace the cocking piece on the end of the firing pin.

28) Lock the cocking piece in place by turning it a quarter turn so that its lug aligns with the lug-slot in the bolt sleeve.



29) With the bolt sleeve keeping the main spring compressed, return the coin to the gap as shown in *figure 29*.

30) Insert firing pin assembly into the bolt body.



31) Turn the firing pin assembly clockwise.

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

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 and depress the magazine follower before pushing the bolt fully into receiver.



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

34) Open the bolt.



35) Turn safety to fire position (forward).

36) Depress the magazine follower and push the bolt forward and lock into place.



37) Figure 37 show the completed job.

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