



# Model 1918

*Self Loading Rifle (SLR)*



Licensed Trademark of Colt's Manufacturing Company LLC  
Manufactured for Colt under License by Ohio Ordnance Works, Inc.



## **READ, UNDERSTAND, AND FOLLOW ALL THE INSTRUCTIONS IN THIS MANUAL**

before disassembling, loading, or using this firearm. Failure to do so could result in the catastrophic failure of your rifle, serious injury, or death.

**Caution:** If unfamiliar with firearms, seek further advice through Gun Safety Organizations, Local Gun Clubs, NRA Approved Instructors, or similar qualified organizations.

**Warning:** If this firearm is carelessly or improperly handled, unintentional discharge could result and could cause injury, death, or damage to property.

**Caution:** The Model 1918 SLR is chambered for and accepts only .30-06 cartridges. Use only clean, dry, high quality commercially manufactured ammunition. Make sure your ammunition is the correct caliber (.30-06).





## Table of Contents

Section 1. Firearms Safety	(4)
Section 2. Product Description	(10)
Section 3. Diagrams	(12)
Section 4. Features	(15)
Section 5. Principles of Operation	(17)
Section 6. Disassembly	(22)
Section 7. Cleaning	(32)
Section 8. Inspection	(39)
Section 9. Reassembly	(44)
Section 10. Operating the Rifle	(53)
Section 11. Trouble Shooting	(61)
Section 12. Warranty	(66)



Image courtesy of Aberdeen Proving Grounds Museum



## Section 1. The Fundamentals Of Firearms Safety

### The three basic general rules of safe gun handling.

1. Always point the muzzle in a safe direction; never point a firearm at anyone or anything you don't want to shoot.
2. Keep your finger off the trigger and outside the trigger guard until you are ready to shoot.
3. Keep the action open and the gun unloaded until you are ready to use it.

### Additional Specific Rules Of Safe Gun Handling

#### Safety Rules Related to the Shooter and His Behavior.

1. Treat every firearm as if it were loaded.
2. Never pass a firearm to another person, or accept a firearm from another person, until the cylinder or action is open and you've personally checked that the weapon is completely unloaded.

3. Before handling any firearm, understand its operation.
4. Never rely on any mechanical device for safety.
5. Think before shooting: once you pull the trigger you can't take back the shot you've just fired!
6. Never joke around or engage in horseplay while handling or using firearms.
7. Be alert at all times; never shoot if you're tired, cold or impaired in any way. Don't mix alcohol or drugs with shooting.
8. Don't sleep with a loaded firearm in your bedroom if you sleepwalk, have nightmares, sleep restlessly or have other sleep problems.
9. Safeguard your sight, hearing and health. Always wear eye and ear protection. Endeavor to limit your exposure to heavy metal particulates and gases, and minimize your contact with aromatic organic solvents (such as those commonly used in



gun cleaning products).

10. If you see unsafe behavior any time when firearms are being handled or used, speak up and take action to correct the unsafe behavior at once.
11. Receive competent instruction from a qualified person before beginning to shoot. If questions arise later, after you've been shooting for a period of time, get answers to those questions from a competent authority.

### **Safety Rules Related to Your Target.**

1. Positively identify your target and the threat it poses before firing at it.
2. What's behind your target? Always make sure that a stray shot, or a bullet which penetrates its intended target through and through, will be safely stopped.
3. Never shoot at a hard surface, or at water -- your shot may glance off, ricochet and injure someone.

4. Never shoot at glass bottles, living trees, or inappropriate targets which would create a hazard for other persons or damage the environment.
5. Never shoot directly upwards, or at a high angle of elevation. Even a rimfire .22 bullet fired at an angle into the air can have enough energy a mile and a half away to accidentally kill someone!
6. Never shoot across a highway or other roadway.
7. Never vandalize a road sign (or other public or private property) by using it as a target.
8. Never poach a game animal out of season, or shoot any game animal you don't intend to eat.

### **Safety Rules Related to Your Firearm.**

1. Make sure your firearm is in good mechanical condition before firing it. Periodically have your firearm checked for signs of erosion, cracking, or wear by the manufacturer – Ohio Ordnance Works, Inc.



## Model 1918 SLR Manual

2. Never try to fire a gun which may have a plugged or partially obstructed barrel.
3. Insure that any modifications made to a firearm are made by the manufacturer (Ohio Ordnance Works, Inc.), and that those modifications don't interfere with your firearm's safety features.
4. Be sure all accessories are compatible with the firearm and won't interfere with its safe operation. If you are unsure contact Ohio Ordnance Works, Inc.
5. It is your responsibility to insure that your firearm is always either about your person and under your personal control, or positively secured from access by children or other unauthorized parties. Prevent tragedy: lock down your firearms when they aren't in use.
6. When storing a firearm for a long period of time, consider storing the slide, bolt, or other critical components of the firearm separately under separate lock and key.
7. Do not unload a firearm by working the cartridges through the action one-at-a-time; drop the magazine and then eject the

round which may be left in the chamber, instead.

8. Never use a scope mounted on a firearm as a general purpose spotting scope: while observing an area you may end up accidentally aiming your firearm at person, or other non-targets.
9. Do not try to catch a live round by cupping your hand around the ejection port while retracting the slide; doing so may result in an accidental discharge.

### Safety Rules Related To Ammunition

1. Be sure your gun and ammunition are compatible. Shooting incorrect ammunition in a firearm may cause it to be damaged or even make it blow up.
2. Use only ammunition recommended for your firearm by its manufacturer. Never fire ammunition which exceeds industry standard pressure specifications. Over-pressure ammunition will reduce the service life of your rifle, and puts you and those around you at risk of a catastrophic firearm failure. Ohio Ordnance Works, Inc. will assume no responsibility or liability





for incidents that occur from the use of reloaded or cartridges of non-standard dimensions, or commercially available ammunition that does not comply with the SAAMI standards (Sporting Arms and Ammunition Manufacturers' Institute). The use of reloaded ammunition will void this firearm's warranty.

3. Store ammunition that isn't being used under lock and key, inaccessible to unauthorized parties and children.
4. Dispose of unwanted ammunition safely.

### Miscellaneous Safety Rules.

1. At a range, obey the commands of the range officers, or any individual calling `cease fire,' at once. Read, know and follow any rules peculiar to a particular range which you may be using.
2. Be careful of hot gases and metal shavings ejected from the rifle.
3. Keep your fingers and other parts of your body away from the muzzle, gas cylinder, and the ejection area of the rifle.

4. In the event of a misfire, keep the firearm pointed in a safe direction, remove your finger from the trigger, wait 30 seconds, then eject the cartridge and dispose of it properly.
5. If you hear an unusual sound upon squeezing the trigger or feel an unusual recoil, stop shooting and investigate. You may have experienced a "squib" load (or under-powered cartridge), and it may have caused a bore obstruction. Keep the firearm pointed in a safe direction, remove your finger from the trigger, wait 30 seconds, then unload the firearm and safely examine the barrel, checking carefully for any possible obstructions before reloading and resuming shooting.

6. Never —

- Climb a tree with a loaded firearm,
- Cross a fence with a loaded firearm,
- Jump a ditch or ford a stream with a loaded firearm,
- Scale or descend a steep incline or hill with a loaded firearm,





## Model 1918 SLR Manual

- Climb a tree, or climb into a hunting stand with a loaded firearm,
  - Prop or lean a loaded firearm against a tree or other surface which may allow it to slide, or
  - Transport a cased loaded firearm.
7. Always carry your firearms in a way which will allow you to control where the muzzle is pointing, should you stumble or fall.
  8. Circumstances may require additional safety rules unique to a particular situation.

## Safe Gun Storage

When you are not using your firearm, you should insure that it is stored safely. Affirmative measures designed to prevent unauthorized access to a defensive firearm by minors, or firearm theft, include:

1. Use of a simplex-type locking box for securing firearms which

need to be kept loaded yet available for ready-access defensive use, and

2. Use of trigger locks or padlocks to secure firearms which don't need to be kept immediately available for defensive use.

### Also note that:

3. Gun security devices which rely solely on physical strength to secure firearms from unauthorized use are generally undesirable since ingenious children can potentially employ leverage or tools to overcome those devices.
4. "Hiding" a firearm won't secure it from discovery and possible misuse by curious children or intruders.
5. Metal gun cabinets or gun safes can be used to safeguard firearms from unauthorized access or theft in many circumstances and metal gun cabinets or gun safes are generally preferable to open racks or glass-front cabinets.





6. Firearms should be stored unloaded and separate from ammunition.
7. You may want to store critical components of a firearm (such as the gun's bolt or slide) separately from the rest of the firearm when the gun won't be used in the immediate future.
8. Consider engraving your firearms with your social security number, driver's license number, or concealed firearms license number to deter theft and facilitate return of stolen firearms which may happen to be recovered.
9. Explore "gun-proofing" your child by proper training, and by controlled and closely supervised access to firearms to reduce your child's natural unsatisfied curiosity about firearms.



## Section 2. Product Description

The Model 1918 SLR is a magazine fed, gas operated, air-cooled, shoulder fired rifle. It fires in semi-automatic mode (a single shot each time the trigger is pulled) from a closed bolt position.



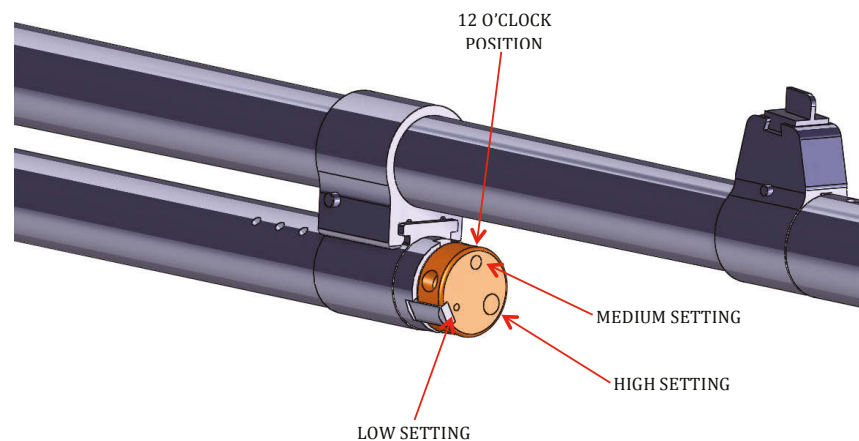


## Model 1918 SLR Manual

The Model 1918 SLR is equipped with a 3-position, adjustable gas regulator for controlling gas flow.

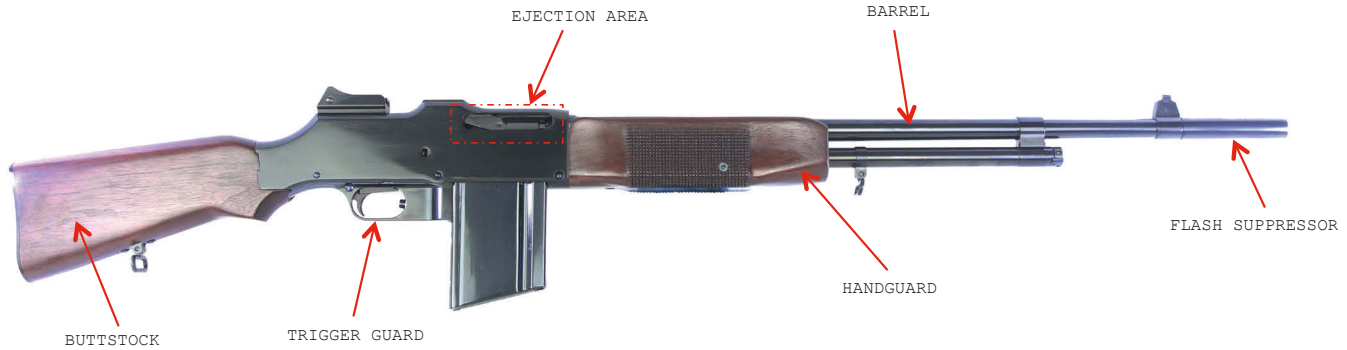
The medium gas setting is for normal use. The low setting is for use with a blank firing device. The high setting is for increased gas pressure for use in the field when your rifle is excessively dirty and you are unable to perform immediate maintenance.

The circle in the 12 o'clock (or top) position indicates which setting the gas regulator is utilizing and sets the amount of gas flow into the gas tube.



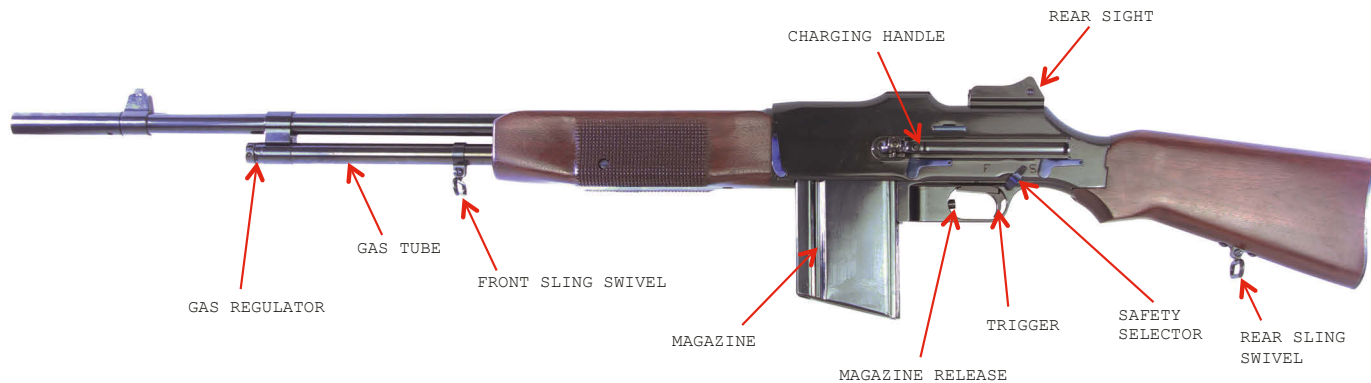


## Section 3. Diagrams



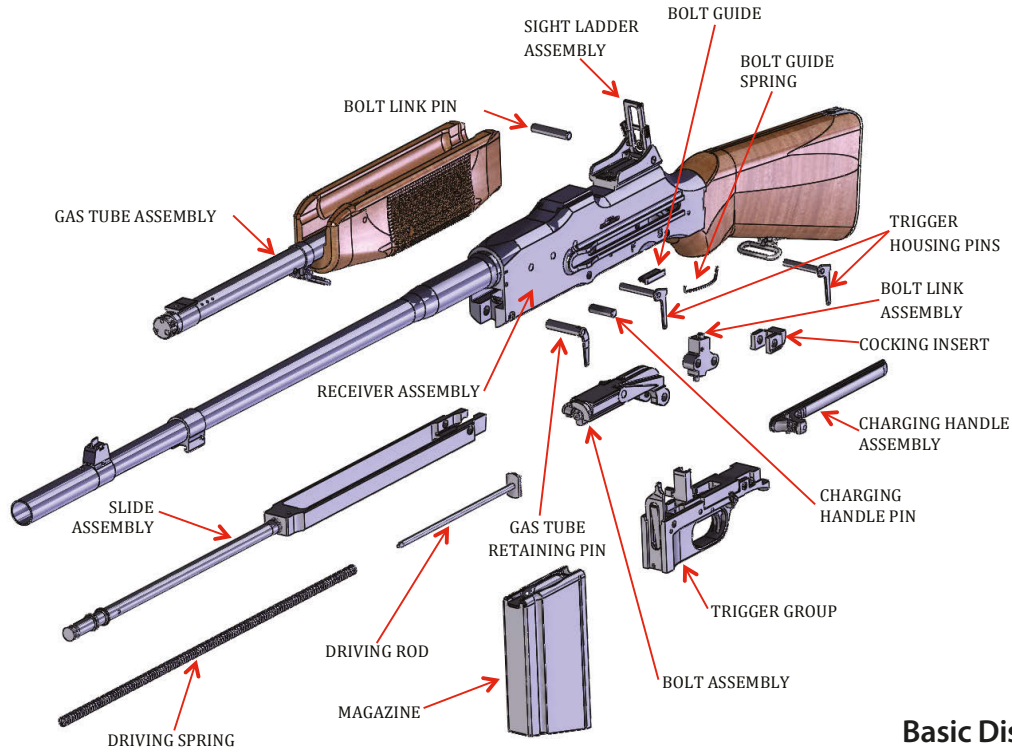
Right Hand View





Left Hand View





Basic Disassembly



## Section 4. Features

The Model 1918 SLR is a magazine fed, gas operated, air-cooled, shoulder fired rifle. It fires in semi-automatic mode (a single shot each time the trigger is pulled) from a closed bolt position.

- Caliber – .30-06
- Weight – 16.45lbs. (unloaded)
- Overall Length – 47 in.
- Barrel – Chrome Moly, 4 groove, right-hand 1/10 twist , .67-28 NS-2 muzzle thread
- Action – semi-automatic , closed action
- Bolt – closed bolt toggle/shoulder locking system
- Firing System – hammer fired with patented multi-stage/ interrupted firing pin system (Patent Number 5,614,691)
- Trigger – single stage
- Gas System – adjustable (3 position); piston driven
- Feed System – detachable box magazine
- Magazine Release – ambidextrous
- Ejection – right hand
- Charging Handle – left side, non-reciprocating
- Safety Selector – left side, lever style
- Sighting – folding rear sight with adjustable elevation
- Handguard – American black walnut
- Buttstock – American black walnut
- Protective Finish – metal components receive one of the following final protective finish coatings based on material type, mechanical properties, and application
  - Black Oxide - aka decorative bluing
  - Nitre Blue



## Section 5. Principles Of Operation



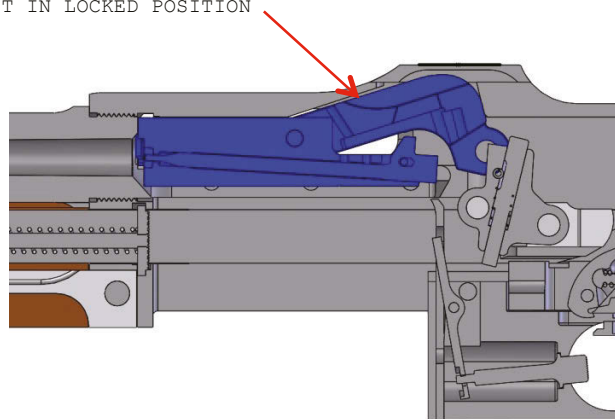




## Model 1918 SLR Manual

1. A loaded magazine is installed into the receiver.
2. The charging handle assembly is pulled to the rear and released.
3. The bolt travels forward pushing a cartridge from the magazine into the feed ramp of the barrel and into the chamber.
4. When the cartridge is seated in the chamber the toggle/lock of the bolt cams upward locking into "battery" with the receiver.

BOLT IN LOCKED POSITION

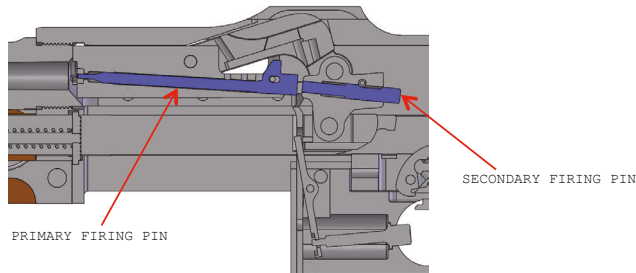


VIEW SHOWN WITHOUT MAGAZINE FOR CLARITY

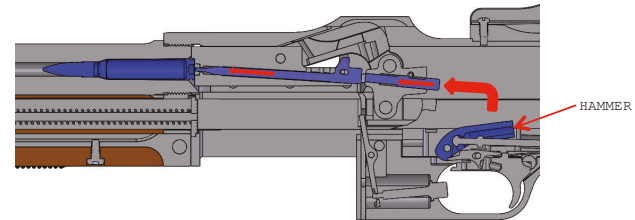


## Model 1918 SLR Manual

- The slide continues forward until it contacts the gas tube, rotating the secondary firing pin in the bolt link assembly into alignment with the primary firing pin.



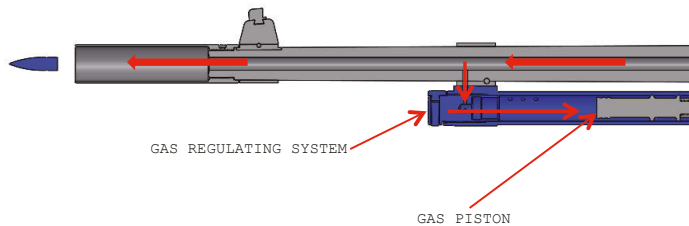
- The safety selector is moved from to the "FIRE" position.
- The trigger is pulled rearward until it releases the hammer.
- The hammer rotates upward and strikes the secondary firing pin.
- The secondary firing pin strikes the primary firing pin.
- The firing pin strikes the primer in the cartridge, igniting the powder which burns and creates pressure on the projectile.



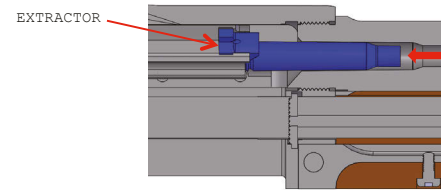


## Model 1918 SLR Manual

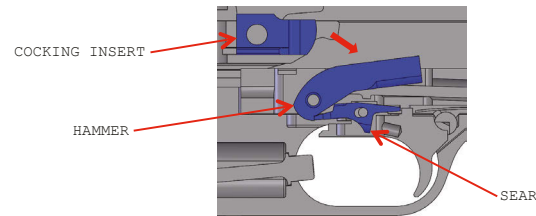
11. The projectile is forced down the bore of the barrel under the pressure of the burning powder.
12. The projectile leaves the barrel and continues down range.
13. Excess gas from the burning powder travels down the gas holes in the barrel, gas tube, and gas cylinder body forcing against the face of the gas piston.
14. The gas pressure forces the slide assembly rearward.



15. The extractor in the bolt assembly grabs onto the empty cartridge case and pulls it rearward as the slide/bolt assembly move as one unit.



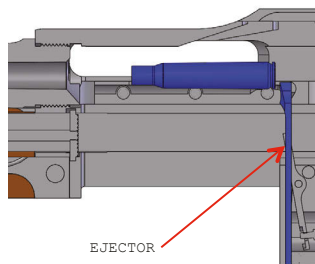
16. The cocking insert in the slide pushes down on the hammer. The sear catches the hammer and holds it until the trigger is reset and pulled again.



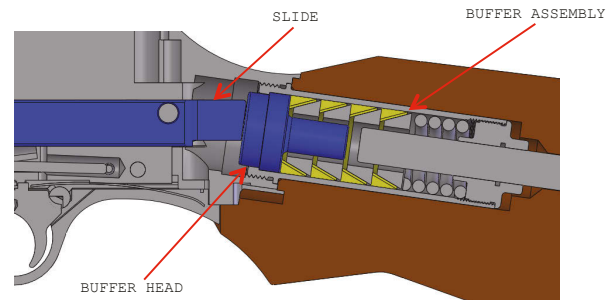


## Model 1918 SLR Manual

17. During rearward travel the empty cartridge case contacts the ejector, mounted in the trigger group, and is ejected from the receiver.



18. The slide travels to the rear until it is stopped by the buffer head and then returns forward under the force of the driving spring.





## Model 1918 SLR Manual

19. When the bolt passes over the top of the magazine an unfired cartridge is pushed upward by the follower and spring in the magazine getting it ready for loading into the barrel.
20. As the slide/bolt assembly returns forward the next cartridge is loaded into the barrel and the rifle is ready to fire when the trigger is pulled again.
21. This cycle is repeated until the magazine is empty.



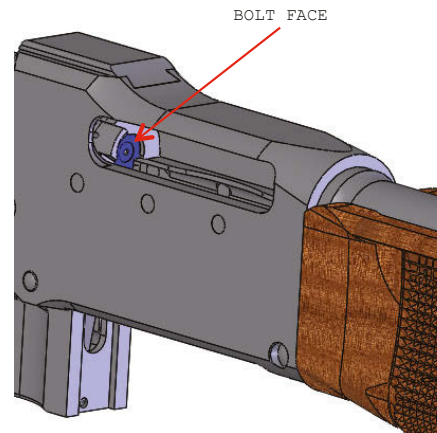
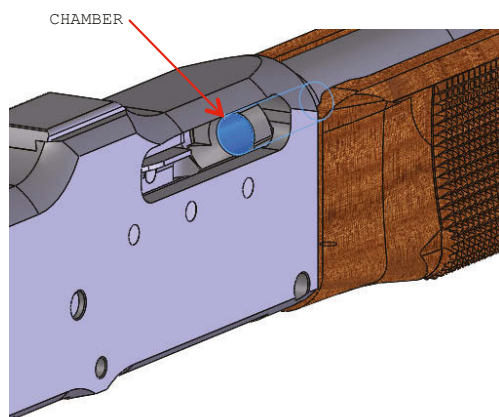
## Section 6. Disassembly



**Warning!** Some components are under spring tension! Always wear eye protection when disassembling your rifle!

With the magazine removed, pull the charging handle fully to the rear and inspect the chamber and the face of the bolt to ensure that the rifle is free and clear of any ammunition. Release the charging handle to allow the bolt to return to the home position.

**Warning!** Keep your fingers out of the ejection and magazine slot.

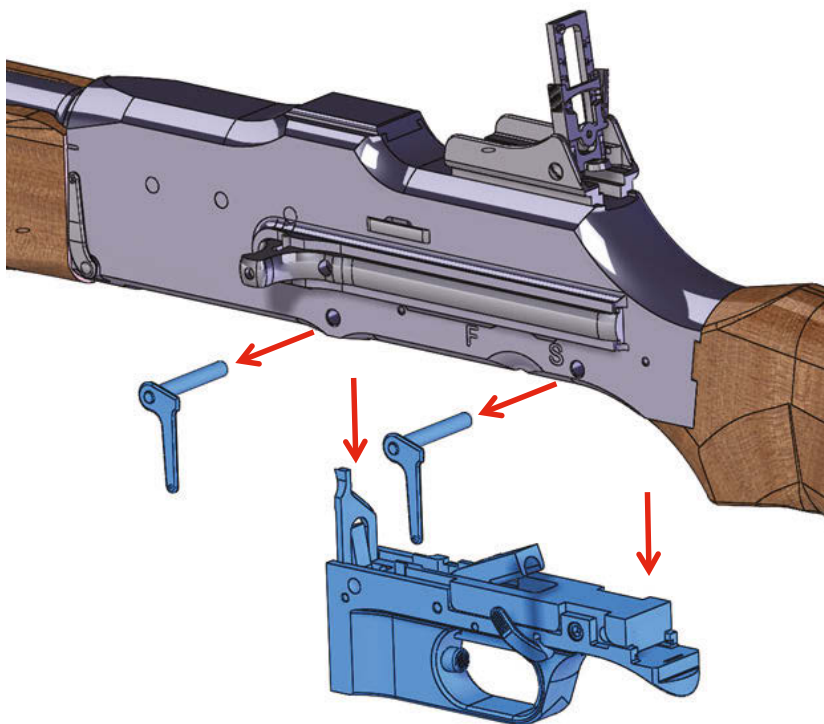




## Model 1918 SLR Manual

Rotate trigger housing pins to unlock and remove from receiver. Remove the trigger group from the bottom of the receiver.

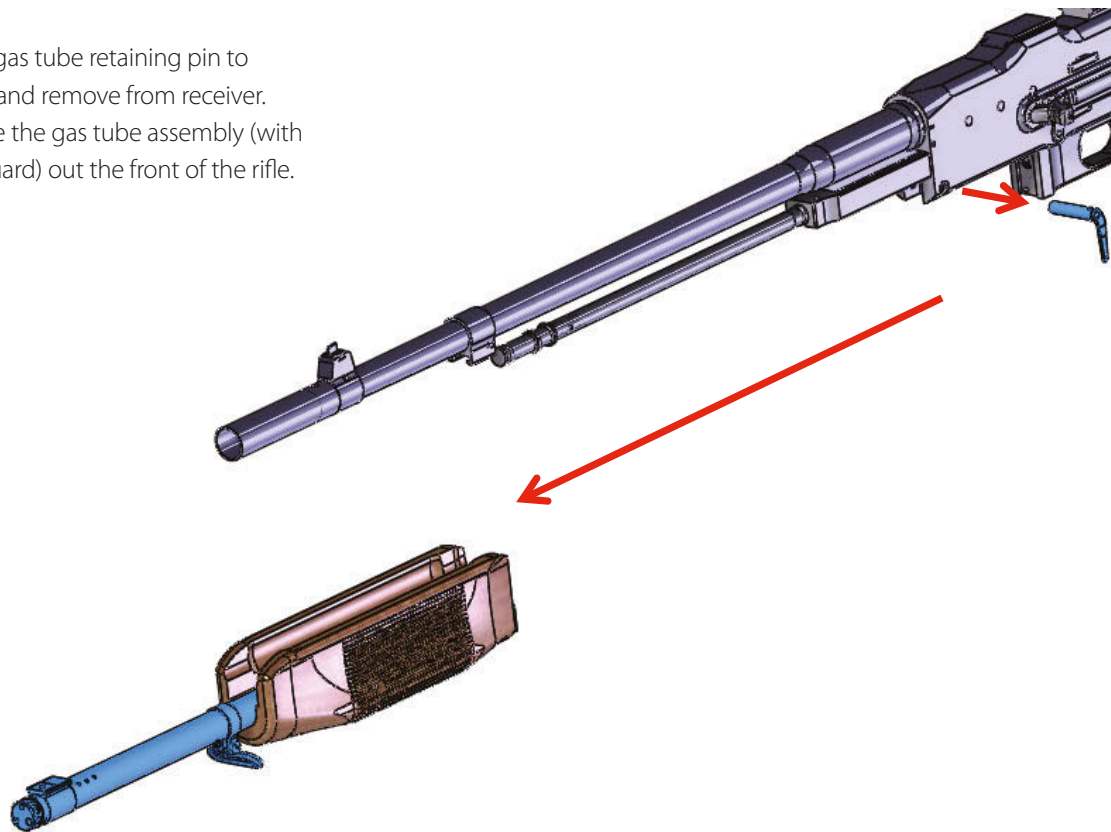
**Note:** The hammer must be cocked in order to remove the trigger group from the receiver.





## Model 1918 SLR Manual

Rotate gas tube retaining pin to unlock and remove from receiver.  
Remove the gas tube assembly (with handguard) out the front of the rifle.



pg. 24

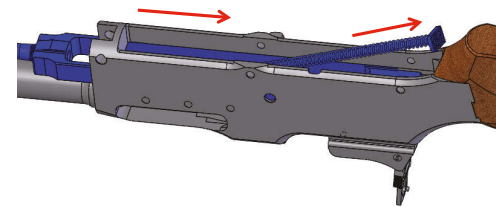
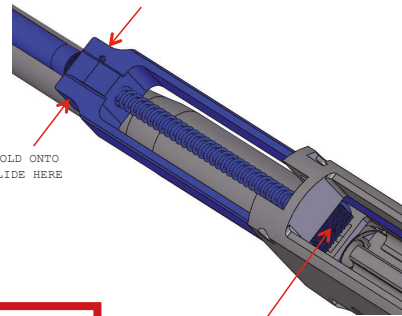
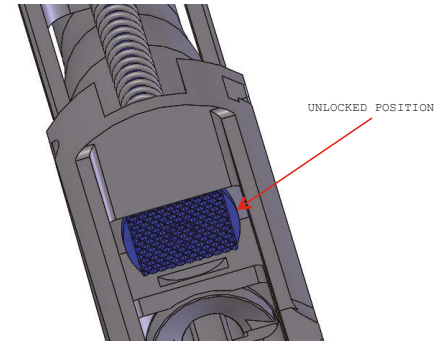
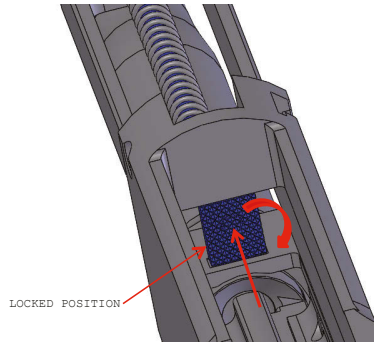
Colt's Manufacturing Company LLC 







1. With the bottom of the rifle facing upward, remove the driving rod and spring by pushing it slightly forward and then rotating it 90°. Once the driving rod is unlocked from the retaining slot you will feel pressure on your finger from the driving spring. Grab the sides of the slide with your other hand and move the slide, driving rod, and spring rearward simultaneously. Once the slide has been retracted into the receiver, continue to hold onto it while you slowly remove the driving rod and spring.



KEEP FINGER ON DRIVING ROD



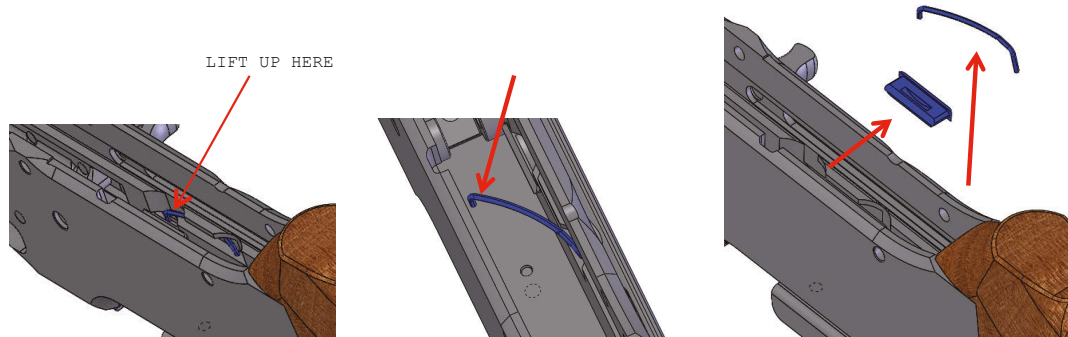
**Warning!** Keep face and body out of the way to prevent injury in the event of losing control of the driving/rod/spring.





## Model 1918 SLR Manual

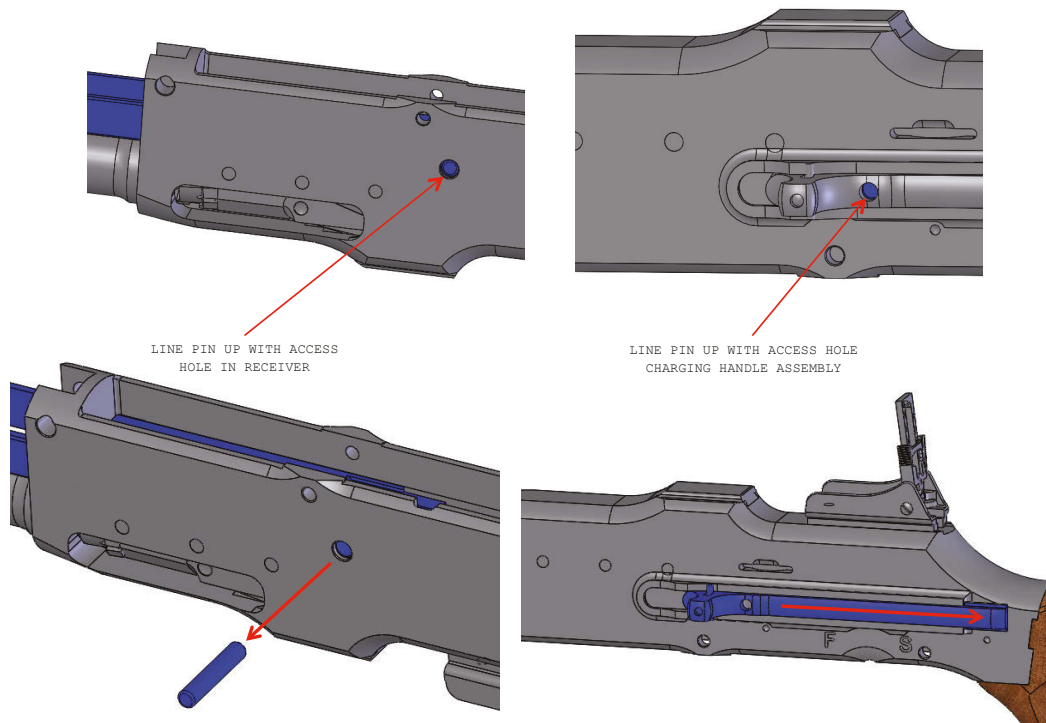
2. With the slide in the forward position, use a hook tool to lift the bolt guide spring from the bolt guide slot. Remove the bolt guide from the side of the receiver. Remove the bolt guide spring from the receiver.





## Model 1918 SLR Manual

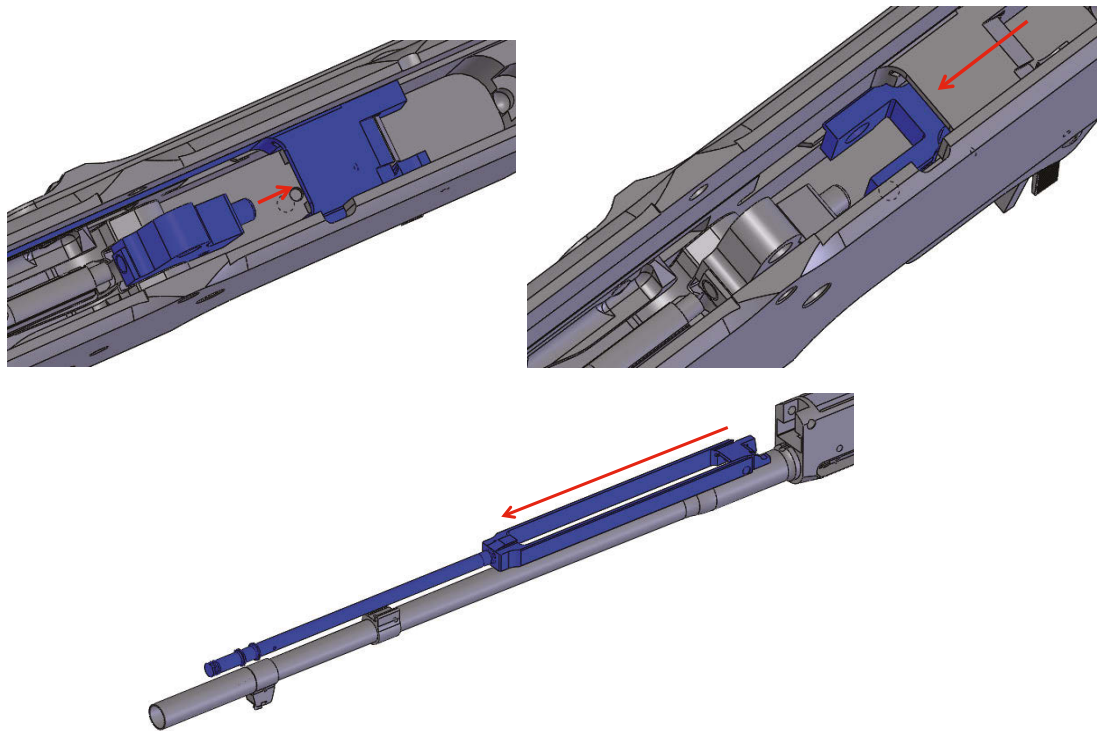
3. Move the slide in the receiver until the charging handle pin lines up with the access hole in the right side of the receiver. Move the charging handle assembly rearward until the access hole lines up with the charging handle pin. Once the charging handle assembly access hole, the charging handle pin, and the receiver access hole are all in alignment push the pin out the right side of the receiver. The charging handle assembly can now be removed from the receiver.





## Model 1918 SLR Manual

4. Move the slide rearward to clear the bolt link assembly. With one hand hold onto the front of the slide at the front of the receiver and with the other hand push the cocking insert forward to remove it from the slide. The slide can now be removed from the receiver.



pg. 28

Colt's Manufacturing Company LLC 

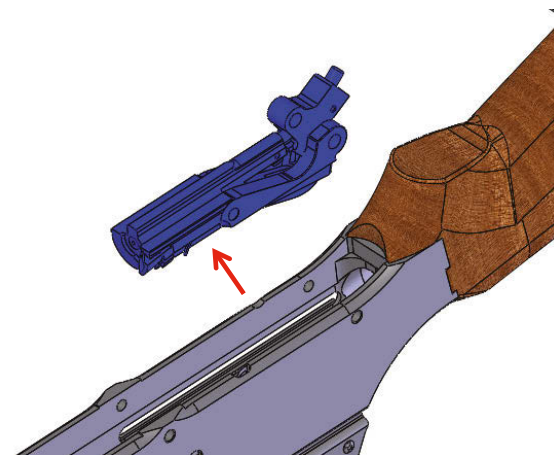
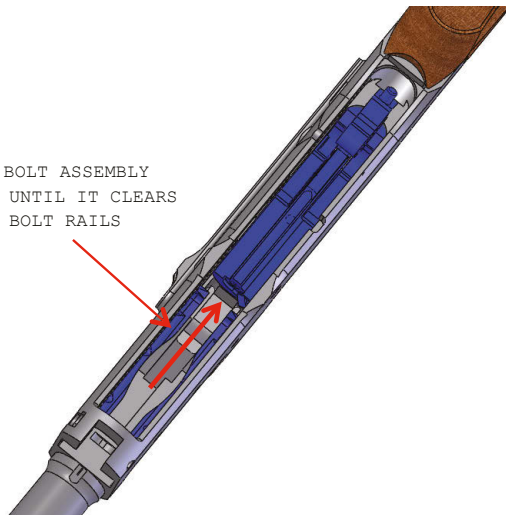




## Model 1918 SLR Manual

5. Lift up on the bolt link assembly to lift the bolt tail from the lock area in the receiver. Pull the assembly rearward until the bolt clears the bolt rails and then remove it from the receiver.

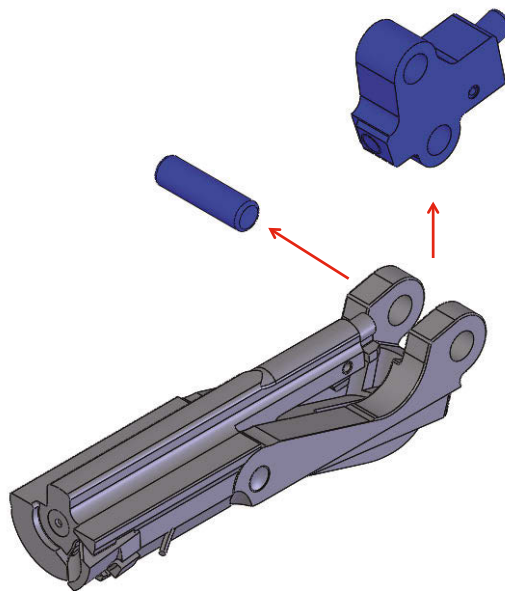
SLIDE BOLT ASSEMBLY  
REARWARD UNTIL IT CLEARS  
THE BOLT RAILS





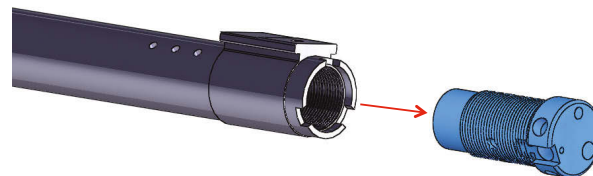
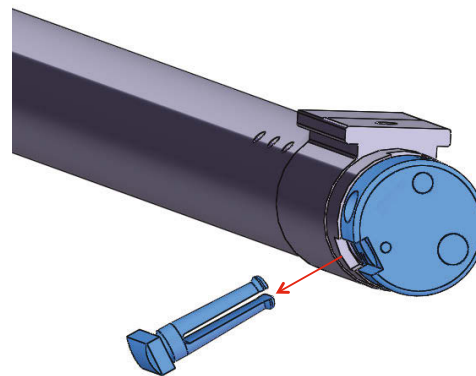
## Model 1918 SLR Manual

- Remove the bolt link pin to remove the bolt link assembly from the bolt.







- Using a punch, remove the gas regulator lock from the gas regulator body. Failure to remove the gas regulator lock can result in damaging the gas tube when the gas regulator body is removed. Remove the gas regulator body from the front of the gas tube.








## Section 7. Cleaning


 **Warning!** Always make sure that the rifle is free and clear of any ammunition before cleaning, disassembly, or reassembly.


 **Warning!** Always disassemble your rifle according to the instructions outlined in this manual prior to cleaning. Do not attempt to clean your rifle with the slide locked to the rear. Attempting to do so may result in the accidental release of the slide causing personal injury from the bolt closing on your fingers. The bolt face and chamber may also become damaged from closing on your cleaning equipment.

 **Warning!** Lead may be present in a dirty rifle. Use proper protective equipment (eye protection, gloves, etc.) to guard yourself against contact. Thoroughly wash your hands after cleaning the rifle to avoid ingestion.

 **Warning!** Always wear proper eye and skin protection when handling solvents and lubricants.

 **Warning!** Always perform cleaning in a well ventilated area.

 **Warning!** Always use solvents and lubricants in accordance with the manufacturer's instructions.

 **Warning!** Dispose of solvent and oil soaked patches, rags, etc. in accordance with manufacturer's instructions and Federal, State, and Local government regulations.







## Model 1918 SLR Manual

There is a large variety of cleaning supplies and accessories for firearms. Always use high quality equipment, solvents, and lubricants that are intended for firearms use when cleaning your rifle. Below is a list of the basic equipment you will need in order to clean your rifle.

1. A cleaning rod of sufficient length
2. Nylon all-purpose brush
3. CLP (cleaner, lubricant, preservative)
4. Brass/Bronze Wire Bristle Bore Brush – do not use a stainless bore brush
5. Patch holder
6. Patches
7. Brass/bronze wire bristle brush for cleaning the gas tube.
8. (Not Included) Bore cleaning solvent




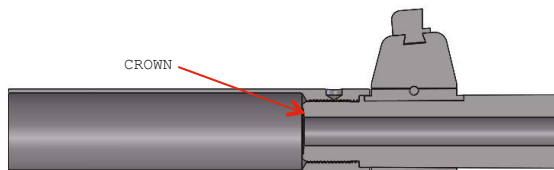


## Model 1918 SLR Manual

### Cleaning the bore

**Caution!** Be careful not to damage the crown of the barrel while cleaning the bore. Damage to the crown can negatively affect the accuracy of the rifle.

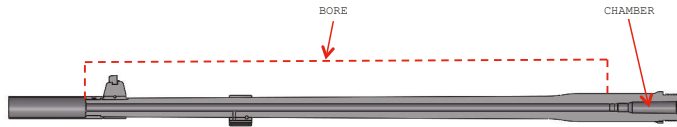
 **Warning!** Always disassemble your rifle according to the instructions outlined in this manual prior to cleaning (see Section 6 – Disassembly).



1. Attach the patch holder to the cleaning rod, dampen the patch with CLP, and run it thru the bore (aka “swab” the bore).
2. If the bore is experiencing heavy fouling then attach the bore brush to the cleaning rod, apply solvent to the brush, and scrub the bore until the fouling is removed. Warning – When using a cleaning rod, push the bore brush thru the full length of the bore and out the end before reversing directions. Changing directions in the middle of the bore can damage the bore brush.
3. After the fouling has been removed, run patches thru the bore until it is clean and dry.
4. Visually inspect the bore and chamber to ensure that they are clean and free of debris.
5. When the bore is dry, dampen a patch with CLP and run it thru the bore for preservation.

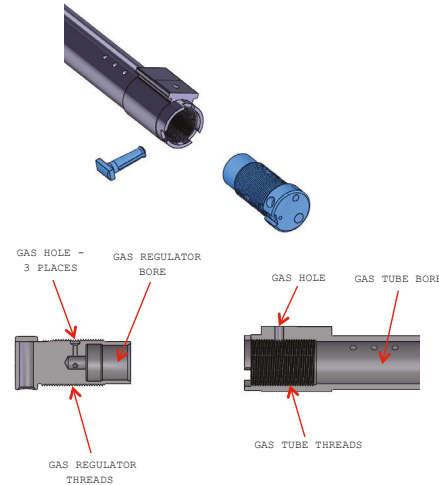


**Warning!** Always clean, dry, and inspect the bore and chamber of your rifle before shooting! Firing a firearm with solvents or preservatives in the bore can cause increased pressures which can result in the catastrophic failure of the firearm, severe injury, and death.



### Cleaning The Gas System

1. Disassemble the gas system as previously outlined in this manual.
2. Using solvent and brushes, remove all carbon and debris from the gas tube and gas regulator. Ensure all of the gas holes are free of carbon and unobstructed as this will cause functioning problems. Ensure all threads and mating diameters are clean to ensure smooth reassembly.

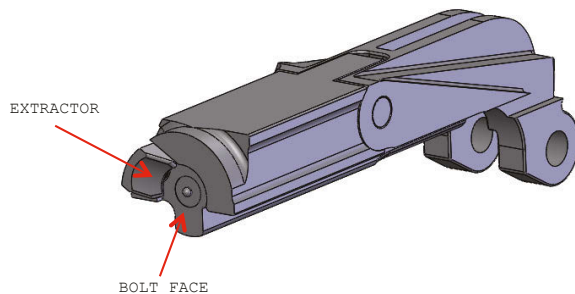




## Model 1918 SLR Manual

### Cleaning The Bolt Assembly

1. Remove the bolt assembly from the receiver as previously outlined in this manual.
1. Clean the face of the bolt and the extractor to remove any brass shavings, unburned powder, and other debris.
1. Wipe clean all other surfaces of the bolt to remove any debris.



### Cleaning The Slide Assembly


1. Remove the bolt assembly from the receiver as previously outlined in this manual.
2. Using solvent and an all-purpose brush, remove all carbon and debris from the gas piston.
3. Wipe clean all other surfaces of the slide assembly to remove any debris.

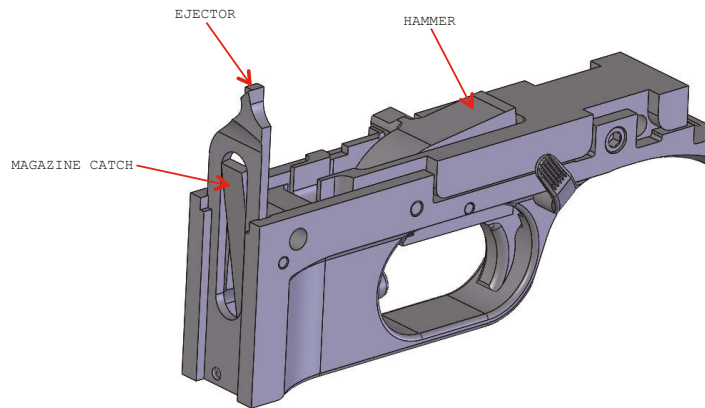




### Cleaning The Trigger Group

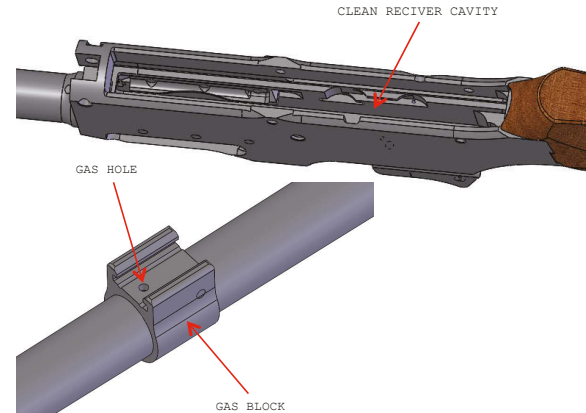
1. Remove the bolt assembly from the receiver as previously outlined in this manual.
2. Wipe clean the ejector, magazine catch, and hammer.

 **Warning!** Do not tamper with the trigger mechanism. This could result in the catastrophic failure of your rifle, serious injury, or death. Tampering with the trigger mechanism will also void your warranty.



### Cleaning The Receiver Assembly

1. Remove sub-assemblies and components as previously outlined in this manual.
2. Wipe the inside cavity of the receiver clean to remove all debris for easy of function of the bolt assembly and slide assembly.
3. Using solvent and an all-purpose brush, remove all carbon and debris from the gas block. Ensure that the gas hole is free of carbon and unobstructed as this will cause functioning problems.






## Model 1918 SLR Manual

### Lubrication:

During reassembly, apply CLP to the side walls of the receiver, the gas piston, the gas tube, bolt assembly, and all other moving components. This is extremely important for proper functionality. Operating the rifle without lubrication can result in feeding and ejection problems.

 **Warning!** Always clean, dry, and inspect the bore and chamber of your rifle before shooting! Firing a firearm with solvents or preservatives in the bore can cause increased pressures which can result in the catastrophic failure of the firearm, severe injury, and death.

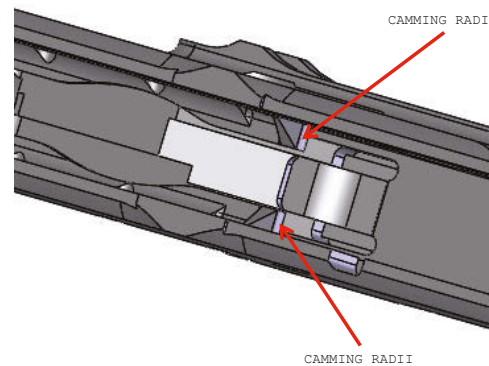
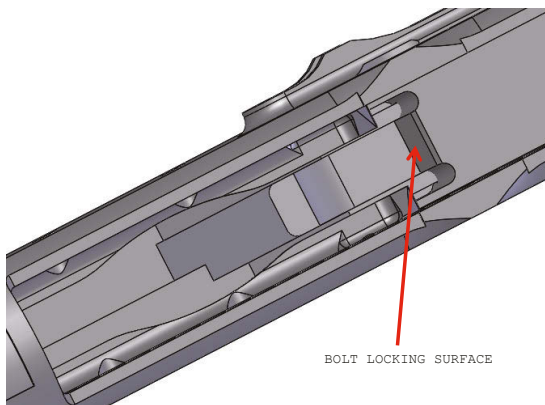


## Section 8. Inspection

### Receiver assembly

- Visually inspect the lock area for heavy wear or damage.

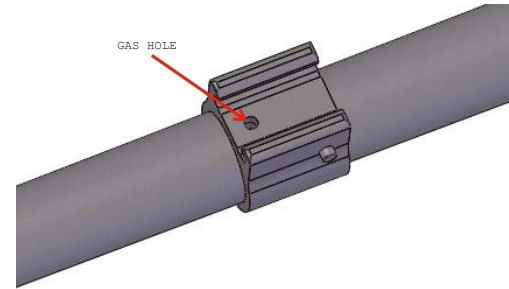
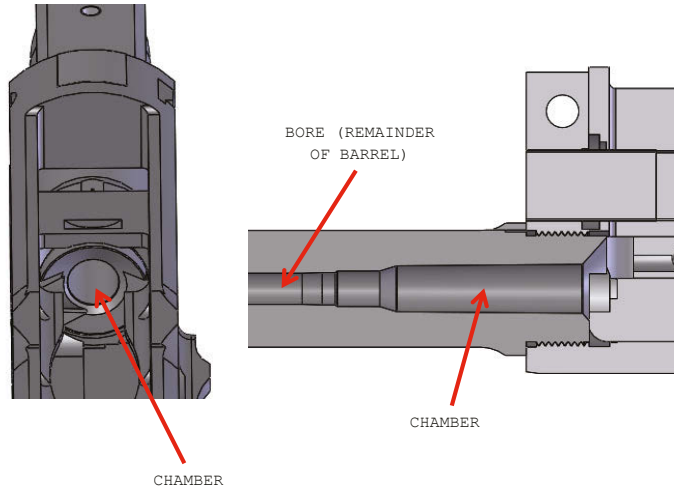
- Visually inspect the camming radii of the bolt rails for heavy wear or damage.





## Model 1918 SLR Manual

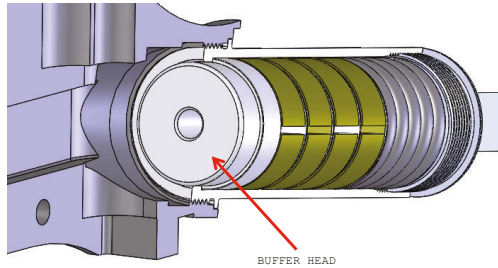
- Visually inspect the chamber for heavy wear, gouging, damage, etc.
- Visually inspect the bore is clean and free from obstruction.
- Visually inspect the inside of the receiver cavity for unusual wear, damage, etc.
- Visually inspect the gas hole in the barrel to ensure that is clean and not obstructed with carbon.





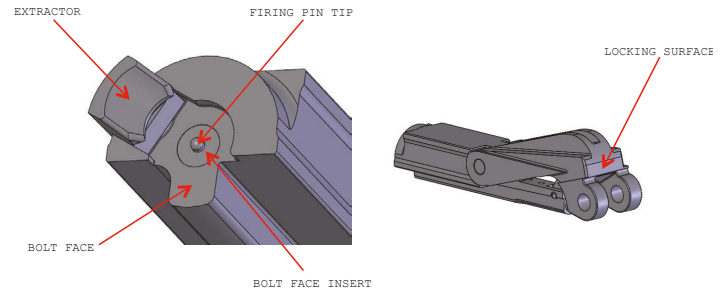


- Visually inspect the buffer head for damage or deformation.



### Bolt Assembly

- Visually inspect the face of the bolt for damage, gouges, loose bolt insert, etc.
- Push the firing pin forward so that the tip protrudes through the bolt face. Visually inspect the pin for damage, excessive pitting, etc. Ensure that the firing pin can move freely within the bolt
- Manipulate the extractor to verify that it has free side-to-side movement
- Visually inspect the locking surface of the bolt for heavy wear or damage.





## Model 1918 SLR Manual

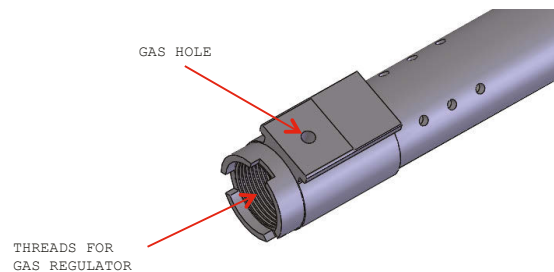
### Slide Assembly

- Visually inspect the gas piston for excessive carbon build up. Inspect the sealing rings for heavy gouges, scratches, or excessive pitting.
- Manually inspect the piston tube to verify that it has a small amount of free movement.
- Visually inspect the buffer impact surface for deformation.



### Gas Tube Assembly

- Visually inspect the bore of the gas tube for excessive carbon build up, heavy pitting, heavy scratches or gouges, bulges, dents, or other damage.
- Visually inspect the gas hole to ensure that it is clean and not obstructed with carbon.

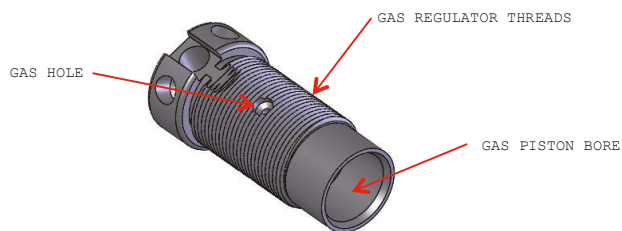




## Gas Regulator Body

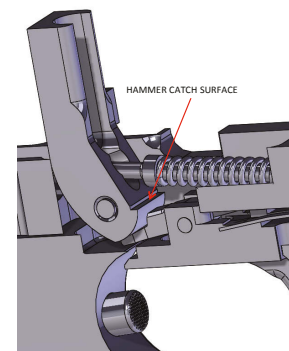
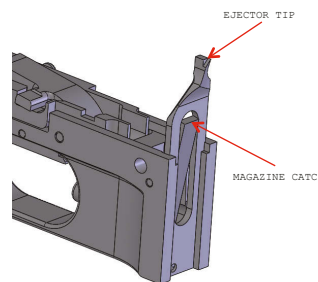
Visually inspect for the following:

- The bore of the gas regulator to ensure that it is clean and free of carbon
- The gas holes are clean and not obstructed with carbon
- The threads are clean of carbon and are not damaged



## Trigger Group

- Visually inspect the tip of the ejector for excessive wear or damage
- Visually inspect the catch surface of the hammer for excessive wear or chipping.
- Visually inspect the top edge of the magazine catch for excessive wear

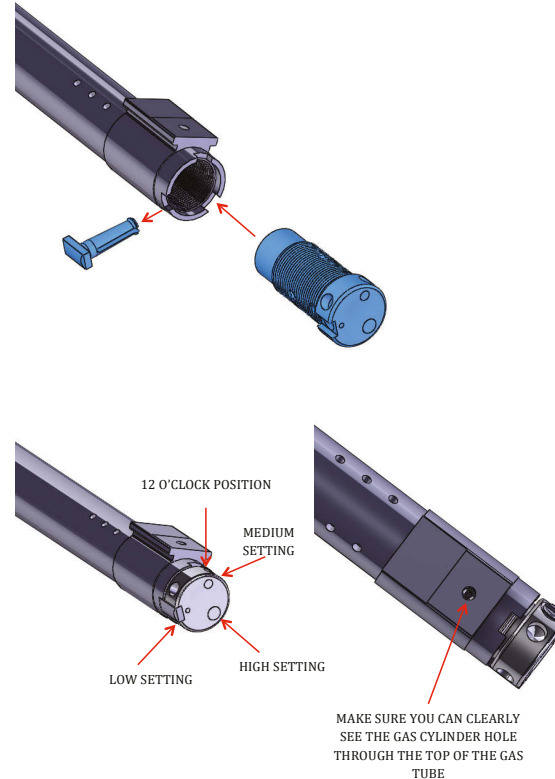




## Section 9. Reassembly

### Gas Tube Assembly

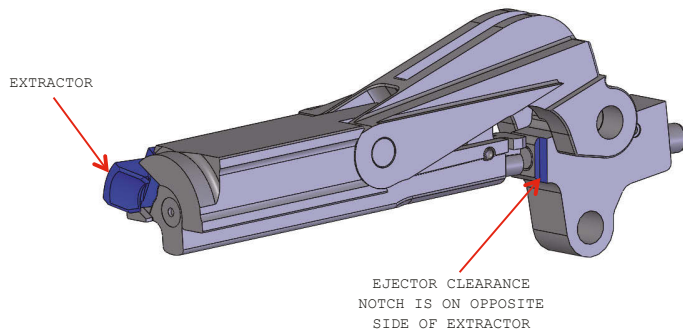
1. Thread the gas regulator into the gas tube until it stops against the front of the gas tube. Back the gas regulator out until the gas hole in the gas regulator is aligned with the gas hole in the gas tube.
2. Turn the gas regulator to the medium gas setting. The gas regulator is marked with a small, medium, and large circle indicating the setting. The circle in the 12 o'clock (or top) position indicates which setting the gas regulator is utilizing and sets the amount of gas flow into the gas tube.
3. Install the gas regulator lock into the gas regulator.



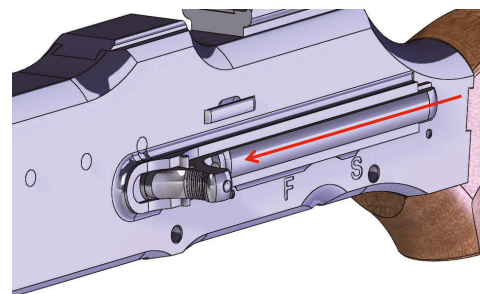


## Model 1918 SLR Manual

4. Assemble the bolt link to the bolt (as shown) and install the bolt link pin.



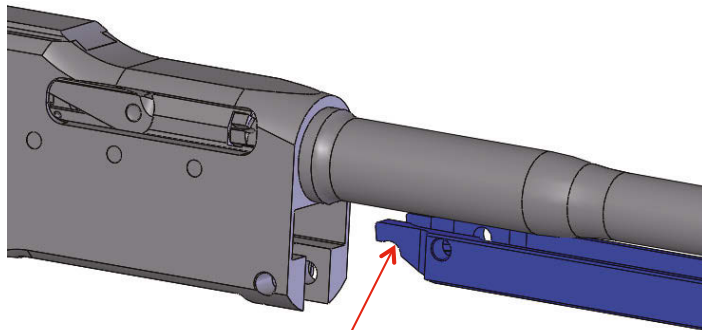
5. Install the bolt assembly into the receiver.
6. Install the charging slide assembly into the receiver.





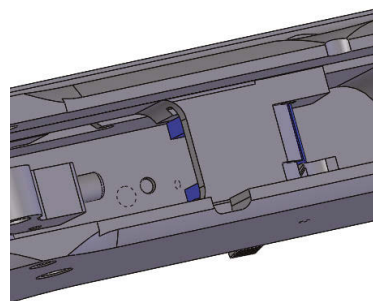
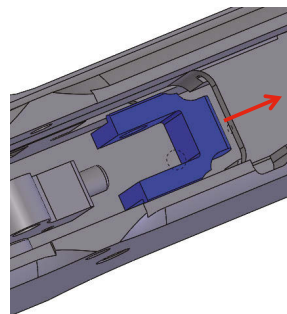
## Model 1918 SLR Manual

7. Install the slide into the receiver. Make sure the hammer clearance notch is toward the bottom of the receiver.



HAMMER CLEARANCE NOTCH

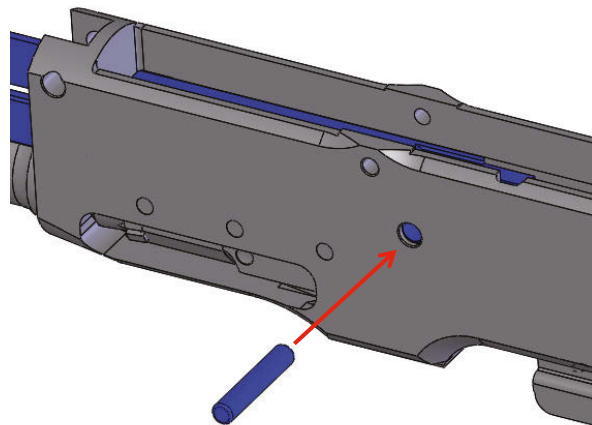
8. Install the cocking insert into the slide.





## Model 1918 SLR Manual

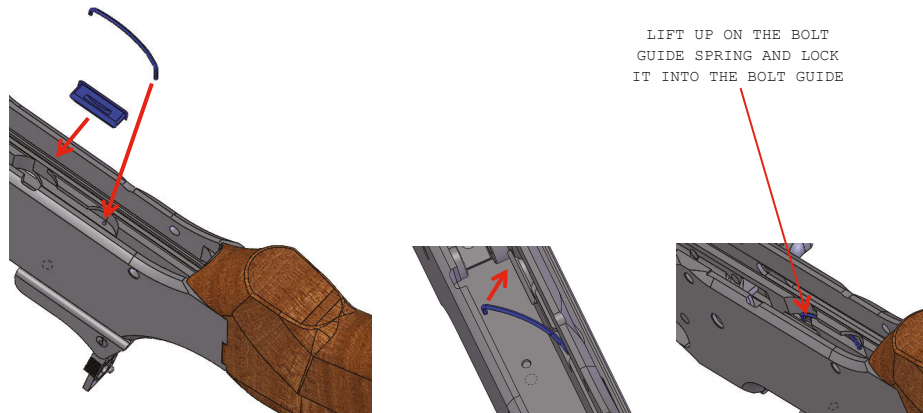
9. Move the slide forward and align the charging handle pin hole in the bolt link with the corresponding holes in the slide and cocking insert. Install the charging handle pin thru the access hole in the right side of the receiver.





## Model 1918 SLR Manual

10. Install the bolt guide into the left side of the receiver. Install the long leg of the bolt guide spring into the hole in the inside of the receiver. Rotate the bolt guide spring toward the bolt guide until it is under the slot wall of the receiver. Using the hook tool, lift up on the end of the bolt guide spring and pull it toward the bolt guide until it catches in the slot in the bolt guide.



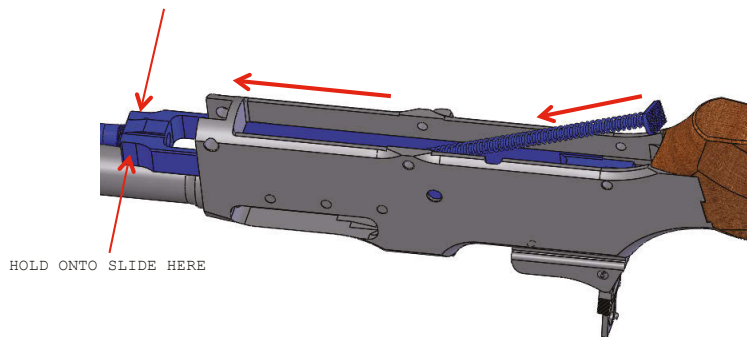
11. Place the driving rod inside the driving spring. Pull the slide all the way to the rear. Feed the driving spring into the piston tube in the slide assembly. With one hand hold the slide to the rear. With the other hand feed the driving spring into the piston tube until the tip of the driving rod is capture in the tube. Make sure that the locking lugs on the driving spring are facing horizontal. Once the tip of the driving rod is inside the tube and the driving move the driving rod and slide assembly forward simultaneously until the slide is fully forward. Then push the driving rod into its locking position and rotate the locking lugs 90° to lock it in place.



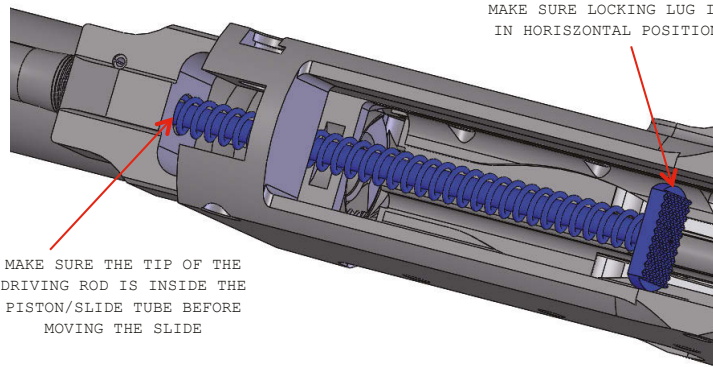




# Model 1918 SLR Manual

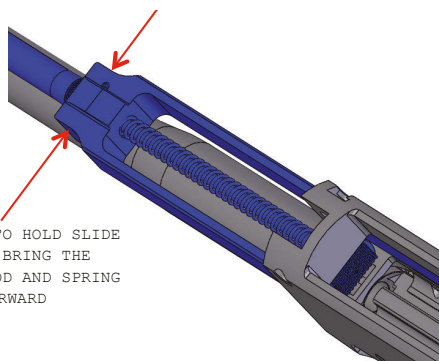


HOLD ONTO SLIDE HERE

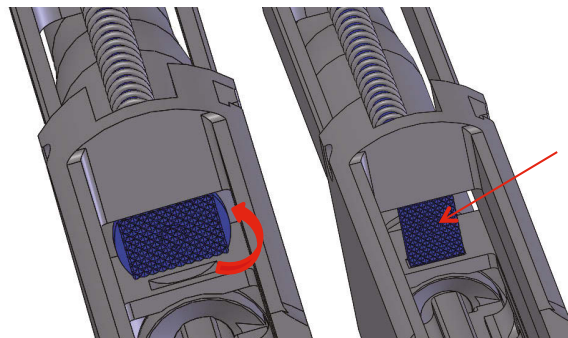


MAKE SURE LOCKING LUG IS IN HORIZONTAL POSITION

MAKE SURE THE TIP OF THE DRIVING ROD IS INSIDE THE PISTON/SLIDE TUBE BEFORE MOVING THE SLIDE



CONTINUE TO HOLD SLIDE AS YOU BRING THE DRIVING ROD AND SPRING FORWARD



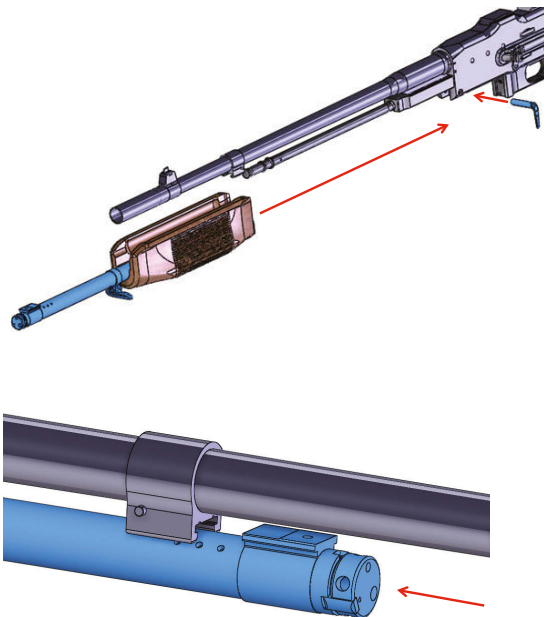
LOCKED POSITION



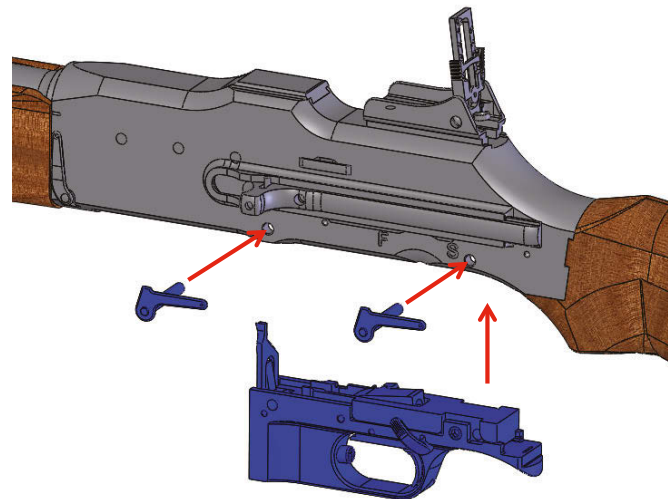


## Model 1918 SLR Manual

12. Slide the gas tube assembly over the front of the barrel. Guide the front lugs of the gas tube into the slots in the gas block and rear lug into the slot in the receiver. Install the gas tube retaining pin and rotate to lock the gas tube in place.



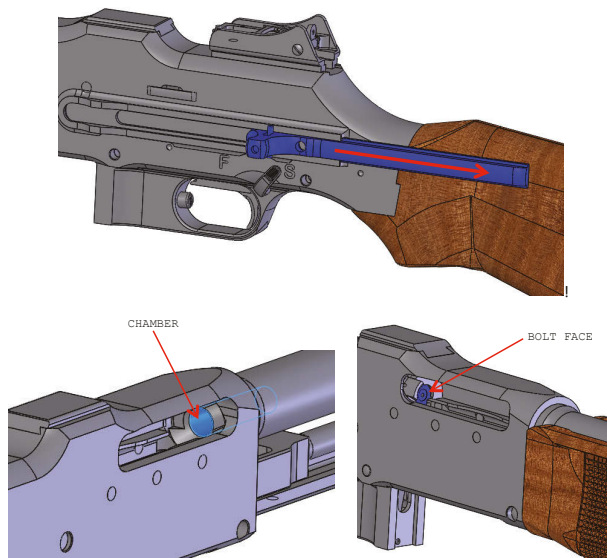
13. Take the trigger group and move the hammer to the cocked position. Move the safety to the "SAFE" position. Install the trigger group into the receiver. Install both trigger housing pins and rotate to lock in place.



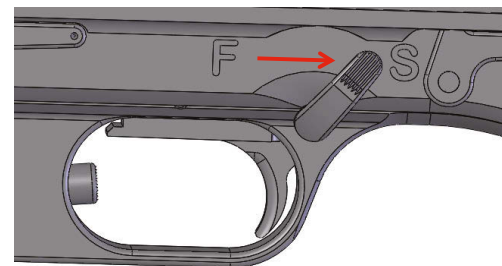


### Function Check – After Reassembly

1. With the magazine removed and the muzzle pointed in a safe direction, pull the charging handle fully to the rear. While holding in the rear position, visually inspect the chamber and the bolt face to ensure that rifle is free and clear of ammunition.



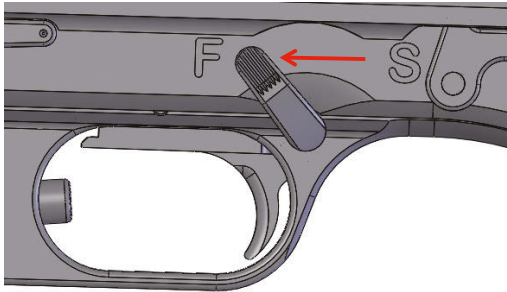
2. Release the charging handle to allow the bolt to return to the home position. **Warning!** Keep your fingers out of the ejection and magazine slot! The “action” (slide/bolt assembly) has now been cycled and the hammer is “cocked”.
3. Move the safety to the “SAFE” position. **Note:** The safety selector cannot be moved to the “SAFE” position unless the hammer is cocked. With the rifle pointed in a safe direction, attempt to pull the trigger. The hammer should not drop.





## Model 1918 SLR Manual

4. Move the safety to the "FIRE" position. With the rifle pointed in a safe direction, pull the trigger. The hammer should drop - indicated by an audible click.



### Trigger Reset Test

1. Pull and **hold** the trigger fully to the rear. Pull the charging handle fully to the rear and release.
2. Slowly release the trigger with a slow, smooth motion until it is fully forward. During the forward travel an audible click should be heard. This is the sound of the trigger resetting. Pull the trigger again. You should now hear the hammer drop. Repeat this entire sequence 5 times. If the trigger does not reset when released fully forward (after being held to the rear during the cycling of the bolt) or the hammer does not drop when the trigger is pulled then return the rifle to Ohio Ordnance Works, Inc. for service. **WARNING!** Attempting to fire your rifle with a malfunctioning trigger system can result in catastrophic failure of your rifle, serious injury, or death.



## Section 10. Operating The Rifle

### How To Use Your 1918 SLR

#### **PRECAUTIONS**

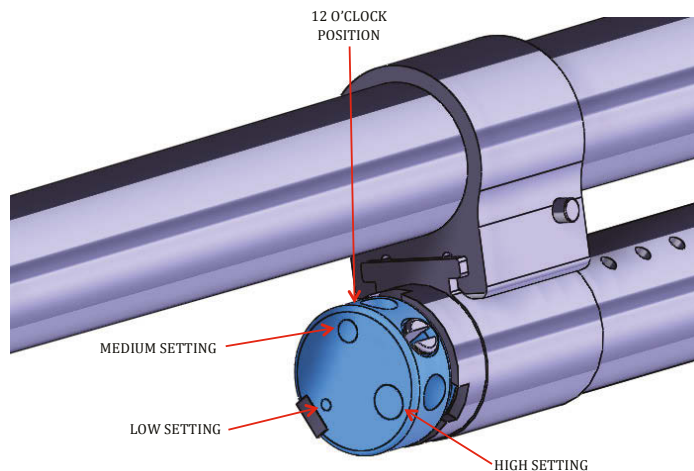
- Always clean, dry, and inspect the bore and chamber of your rifle before shooting! Firing a firearm with solvents or preservatives in the bore can cause increased pressures which can result in the catastrophic failure of the firearm, severe injury, and death.
- Safeguard your sight, hearing and health. Always wear eye and ear protection. Endeavor to limit your exposure to heavy metal particulates and gases
- Be careful of hot gases and metal shavings ejected from the rifle.
- Keep your fingers and other parts of your body away from the muzzle, gas cylinder, and the ejection area of the rifle.
- Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead, a substance known to be associated with birth defects, reproductive harm, and other serious injury. Have adequate ventilation at all times and wash hands after handling.



## Model 1918 SLR Manual

### Setting the Gas Regulator

**Important!** The gas regulator is marked with a small, medium, and large circle indicating the setting. The circle in the 12 o'clock (or top) position indicates which setting the gas regulator is utilizing and sets the amount of gas flow into the gas tube. Prior to loading your rifle, verify that the gas regulator is on the medium setting for normal use.



### Loading The Magazine

**Warning!** Be sure to use only .30-06 cartridges. Shooting incorrect ammunition in a firearm may cause it to be damaged or even make it blow up.

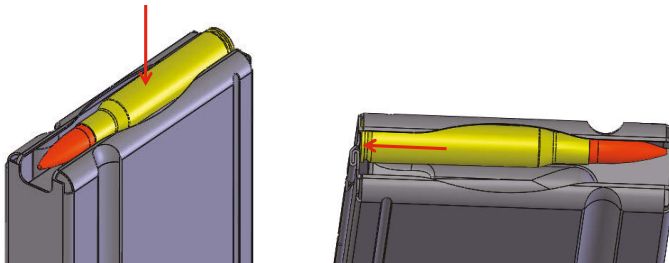
**Warning!** Never fire ammunition which exceeds industry standard pressure specifications. Over-pressure ammunition will reduce the service life of your rifle, and puts you and those around you at risk of a catastrophic firearm failure. Ohio Ordnance Works, Inc. and Colt's Manufacturing Company, LLC will assume no responsibility or liability for incidents that occur from the use of reloaded or cartridges of non-standard dimensions, or commercially available ammunition that does not comply with the SAAMI standards (Sporting Arms and Ammunition Manufacturers' Institute). The use of reloaded ammunition will void this firearm's warranty.

**Warning!** Handling of cartridges and firing firearms may expose you to lead. Always assure that there is adequate ventilation. Always wash your hands after handling ammunition or firing your firearm.





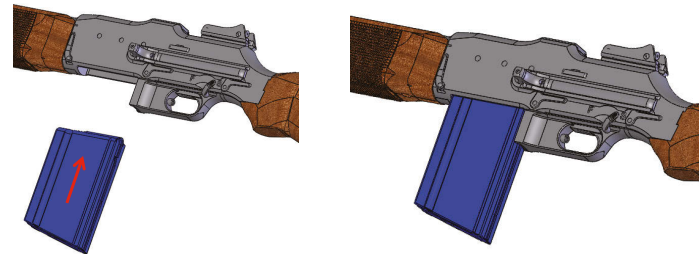
1. Place a cartridge on top of the feed lips in the center of the magazine with the nose pointing forward.
2. Press down on the cartridge with your thumb until it locks into position under the feed lips. Make sure the base of the cartridge is up against rear inside wall of the magazine.
3. Continue this process until you reach the desired number of rounds you wish to fire or the magazine reaches maximum capacity.



### Loading The Rifle

**Warning!** Always clean, dry, and inspect the bore and chamber of your rifle before shooting! Firing a firearm with solvents or preservatives in the bore can cause increased pressures which can result in the catastrophic failure of the firearm, severe injury, and death.

1. With the muzzle pointed in a safe direction, insert the magazine into the receiver with the nose of the cartridges facing forward. Push upward until the magazine catch locks the magazine in place. You should hear an audible click. To verify that the magazine catch has been engaged, pull down on the magazine – it should remain in place.





## Model 1918 SLR Manual

2. Pull the charging handle fully to the rear and release it.

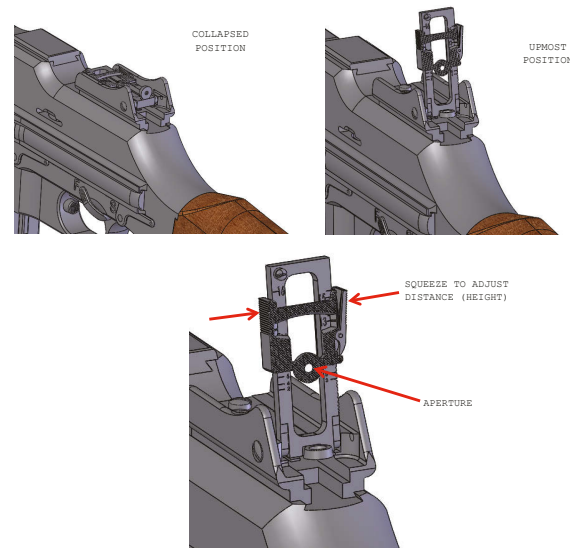
**Warning!** Do not keep your hand on the charging handle assembly to let the bolt ride home slowly. This will result in feed issues. **Caution!** A cartridge is now in the chamber and the rifle is ready to fire. Move the safety to the "SAFE" position.

**Caution!** A cartridge is now in the chamber and the rifle is ready to fire.

**Warning!** When the magazine is installed into the firearm, the ammunition is pressing against the bottom of the bolt. Due to variations in the case diameters of different brands of cartridges there may be less free space in the magazine when it is fully loaded. This can make it difficult to install a fully loaded magazine into the receiver and lock it in place. Once locked in place it will put extra resistance on the bolt when pulling the charging handle assembly to the rear to chamber a cartridge. It may be optimal to load your magazine with 1 round less than maximum capacity. This will create space in the magazine for the rounds to depress when loaded against the bottom of the bolt allowing the magazine to lock in place more easily and making it easier to charge the bolt.

### Operating The Rear Sight

1. Lift the ladder assembly to the upmost position. The ladder assembly should lock into position at a slight angle towards the muzzle of the firearm.
2. Squeeze lock lever to allow vertical travel of the aperture assembly. Use the distance marks to accurately sight firearm.





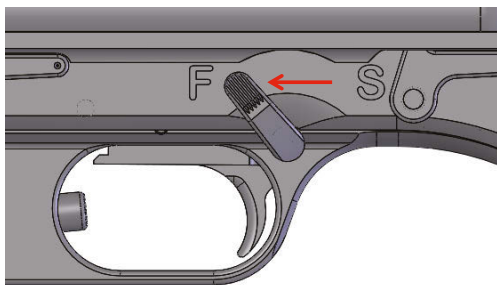


## Firing The Rifle

1. Now that the rifle is loaded, the muzzle still pointed in a safe direction, and your finger off the trigger, hold the butt stock firmly against your shoulder to secure the rifle. Move the safety selector to the "FIRE" position, take aim at your target, and pull the trigger fully to the rear. **Caution!** Pulling the trigger will cause the rifle to fire – be prepared!
2. After a cartridge has been fired, the bolt and slide assembly move rearward, with the extractor pulling the empty case out

of the chamber until it contacts the tip of the ejector, expelling the empty case from the receiver and then return forward feeding a cartridge from the magazine and into the chamber of the barrel. This process is repeated every time the trigger is pulled until the magazine is empty.

3. The empty magazine can be removed by pushing forward on the magazine release and simultaneously pulling down on the magazine. The rifle can be reloaded by following the loading process previously described.

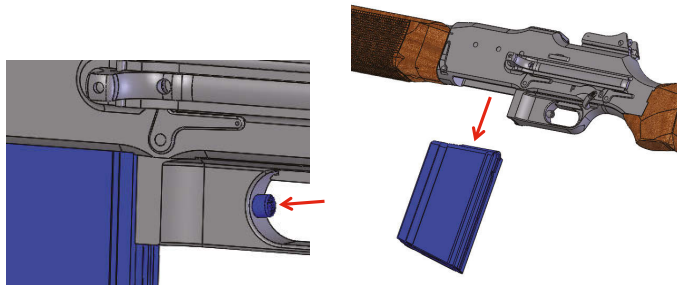




## Model 1918 SLR Manual

### Clearing The Rifle

1. Keep the muzzle pointed in a safe direction!
2. Depress the magazine release and remove the magazine from the receiver.
3. Pull the charging handle assembly to the rear and visually check the chamber and the bolt face to ensure that the rifle is free and clear of ammunition. **Warning! Keep your face clear of the ejection port!**
4. Move the safety selector to the "SAFE" position



**Warning!** The firing of a weapon can cause parts to become extremely hot and can cause injury (primarily the barrel, gas system, and surrounding parts). Use caution when handling your rifle during firing and after firing.

**Warning!** Extended firing can cause the barrel to become extremely hot! A cartridge left in the chamber may fire without pulling the trigger due to the heat from the barrel. This is known as a "cookoff". Always unload your firearm immediately after you finish firing!

**Warning!** If your rifle stops firing with a live cartridge in the chamber, then remove it quickly. If the cartridge cannot be removed within 10 seconds, then remove the magazine, move the safety selector to the "SAFE" position, and wait 15 minutes with the muzzle pointed in a safe direction. Maintain control of the rifle the entire time and make sure that the "safe" direction remains safe the entire time.

**Warning!** If you hear an unusual sound or an audible pop upon squeezing the trigger or feel an unusual recoil, stop shooting and investigate. You may have experienced a "squib" load (or under-





powered cartridge), and it may have caused a bore obstruction. Keep the firearm pointed in a safe direction, remove your finger from the trigger, wait 30 seconds, then perform the following:

1. Keep the muzzle pointed in a safe direction
2. Remove the magazine from the rifle
3. Move the safety selector to the "SAFE" position
4. Pull the charging handle assembly to the rear and visually check the chamber and the bolt face to ensure that the rifle is free and clear of ammunition. **Warning! Keep your face clear of the ejection port!**
5. Once you are absolutely sure that the rifle is empty insert a cleaning rod into the barrel to check for an obstructed bore.



**Warning! If a bullet is stuck in the barrel do not attempt to remove it! Return the rifle to Ohio Ordnance Works, Inc. for repair!**

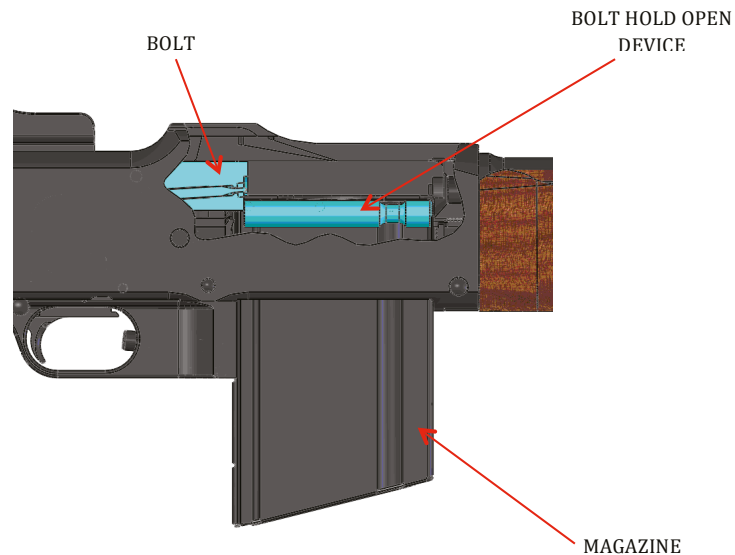




## Model 1918 SLR Manual

### Bolt Hold Open Device

Install the bolt hold open device into an empty magazine. Load the magazine and fire the rifle as specified in this manual. When the last round is fired the bolt hold open device will rise into the path of the bolt and stop against the front inside surface of the magazine. The device stays inside the magazine. This will hold the bolt in the open position. **Caution:** When the magazine is removed the bolt slam shut under the force of the driving spring. **Keep fingers clear of ejection area!**



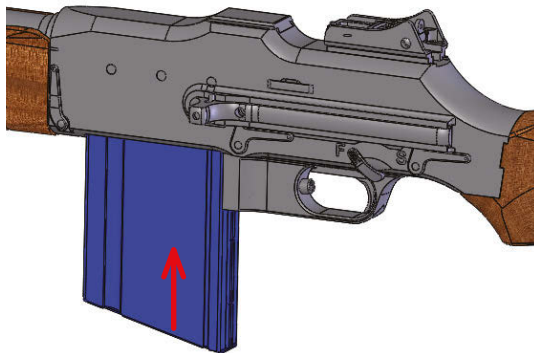


## Section 11. Troubleshooting

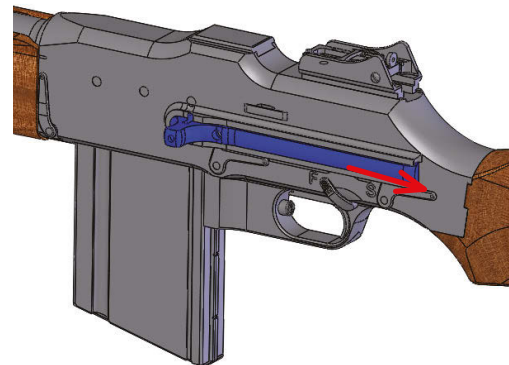
### Immediate Actions

If your rifle stops firing then perform the following "Immediate Actions":

1. Push up on the bottom of the magazine to ensure that it is locked in place in the receiver.



2. Pull the charging handle assembly all the way to the rear to eject an empty/unfired cartridge.

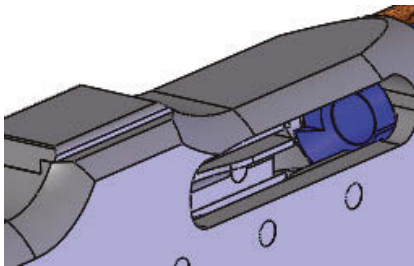




## Model 1918 SLR Manual

3. Hold the charging handle assembly to the rear and visually check the chamber to ensure that it is not obstructed.

**Warning! Keep your face clear of the ejection port!**




4. If the chamber is clear then let the charging handle assembly return home under the force of the driving spring. **Warning!** Do not keep your hand on the charging handle and slowly “ride” it home as this could cause a failure to feed another cartridge into the chamber!
5. Continue firing.





## Remedial Actions

If the rifle is still experiencing malfunctions then perform the following "Remedial Actions":

1. Keep the muzzle pointed in a safe direction!
2. Remove the magazine
3. Move the safety selector to the "SAFE" position
4. Pull the charging handle assembly to the rear and visually check the chamber and the bolt face to ensure that the rifle is free and clear of ammunition. **Warning! Keep your face clear of the ejection port!**
5. Refer to Trouble Shooting Table for further guidance.

 **Warning!** The firing of a weapon can cause parts to become extremely hot and can cause injury (primarily the barrel, gas system, and surrounding parts). Use caution when handling your rifle during firing and after firing.

 **Warning!** Extended firing can cause the barrel to become extremely hot! A cartridge left in the chamber may fire without pulling the trigger due to the heat from the barrel. This is known as a "cookoff". Always unload your firearm immediately after you finish firing!

 **Warning!** If your rifle stops firing with a live cartridge in the chamber, then remove it quickly. If the cartridge cannot be removed within 10 seconds, then remove the magazine, move the safety selector to the "SAFE" position, and wait for 15 minutes with the muzzle pointed in a safe direction. Maintain control of the rifle the entire time and make sure that the "safe" direction remains safe the entire time.



## Model 1918 SLR Manual



**Warning!** If you hear an unusual sound or an audible pop upon squeezing the trigger or feel an unusual recoil, stop shooting and investigate. You may have experienced a “squib” load (or under-powered cartridge), and it may have caused a bore obstruction. Keep the firearm pointed in a safe direction, remove your finger from the trigger, wait 30 seconds, then perform the following:

1. Keep the muzzle pointed in a safe direction
2. Remove the magazine from the rifle
3. Move the safety selector to the “SAFE” position
4. Pull the charging handle assembly to the rear and visually check the chamber and the bolt face to ensure that the rifle is free and clear of ammunition. **Warning! Keep your face clear of the ejection port!**
5. Once you are absolutely sure that the rifle is empty insert a cleaning rod into the barrel to check for an obstructed bore.



**Warning!** If a bullet is stuck in the barrel do not attempt to remove it! Return the rifle to Ohio Ordnance Works, Inc. for repair!





## Model 1918 SLR Manual

FAILURE MODE	DESCRIPTION	CAUSE	RESOLUTION
<b>FAILURE TO FIRE</b>	Bolt is not fully forward	Sluggish action and/or gas system	Clean your gun
	Hammer drops but cartridge does not fire	Broken firing pin	Return to Ohio Ordnance Works, Inc. for repair
		Bad Ammunition	Inspect ammunition
		Hammer spring is too weak	Return to Ohio Ordnance Works, Inc. for repair
	Hammer does not drop when the trigger is pulled	Safety selector is on "SAFE"	Move safety selector to "FIRE"
		Hammer/trigger engagement ledges are worn	Return to Ohio Ordnance Works, Inc. for repair
	The trigger is not returning after the trigger is pulled	Trigger return spring is worn	Return to Ohio Ordnance Works, Inc. for repair
<b>FAILURE TO FEED</b>	Cartridge is not feeding fully into the chamber	Sluggish action and/or gas system	Clean your gun
		Weak/Worn driving spring	Replace driving spring
		Obstruction in chamber	Inspect and clear chamber
	Cartridge is not being removed from the magazine	Magazine is not installed and fully locked into the receiver	Refer to magazine installation instructions
		Magazine is damaged	Replace magazine
	Magazine is not loaded properly	Refer to loading instructions	
<b>FAILURE TO EXTRACT</b>	Cartridge is not removed from the chamber	Extractor is broken or missing	Replace extractor
		Extractor spring is weak	Replace extractor spring
		Chamber is excessively dirty or damage	Clean and inspect chamber and bore
<b>FAILURE TO EJECT</b>	Bolt is not cycling back far enough for cartridge to contact the ejector	Gas system may not be on proper setting	Check proper gas setting.
		Gas system may be excessively dirty	Clean your gun
		Receiver, slide, and bolt are excessively dirty	Clean your gun
		Receiver, slide, and bolt lack lubrication	Properly lubricate your gun
	Cartridge is not ejecting	Ejector tip is broken	Return to Ohio Ordnance Works, Inc. for repair
<b>Other Malfunction</b>			Contact Ohio Ordnance Works, Inc.





## Section 12. Warranty

### 2 Year Limited Warranty

Ohio Ordnance Works, Inc. guarantees your 1918 SLR to be free of defects in material and workmanship for a period of Two Years. Ohio Ordnance Works, Inc. will correct, repair, or replace your rifle with the same or comparable model within the Two Year Warranty period free of charge – including all shipping costs. This warranty applies to the original retail purchaser and begins on the day you receive your rifle. Maintain all records of purchase and receipt. This warranty is not transferable.

### Alterations, Modifications, And Accessories

The following actions are unsafe and could result in the catastrophic failure of your rifle, serious injury, or death. They will also void your warranty.

- Altering or modifying of any parts
- Tampering with the trigger mechanism
- The use of improper caliber, reloaded, non-standard, or poor quality ammunition

- Unsafe and improper use and handling
- Use of accessories that are not rated for use with a .30-06 rifle
- Improper installation of accessories
- Improper cleaning and maintenance

### Questions/Problems/Returns

If you have any questions about your rifle, are experiencing any problems, or need to return your rifle for repair call Ohio Ordnance Works, Inc at 440-285-3481:

Ohio Ordnance Works, Inc.  
310 Park Drive  
Chardon, OH 44024

**Note: It is illegal to ship a firearm loaded with ammunition or ammunition in the same package as the firearm. Firearms and ammunition must be shipped separately.**



This page is intentionally blank





*Licensed Trademark of Colt's Manufacturing Company LLC, Hartford Connecticut  
Manufactured for Colt under License by Ohio Ordnance Works, Inc.*

**Ohio Ordnance Works, Inc.**

PO Box 687  
Chardon, Ohio 44024

**phone:** 440-285-3481

**fax:** 440-286-8571

**sales inquiries:** [sales@oowinc.com](mailto:sales@oowinc.com)  
**general:** [oow@ohioordnanceworks.com](mailto:oow@ohioordnanceworks.com)

1918-OPMAN RevColt  
82015-500

Printed in USA

