



V-M18-RK INSTALLATION MANUAL

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CAUTIONS AND WARNINGS

Read, understand, and follow all warnings, training materials, and safety instructions for the M18.

CAUTION: CLASS **3R** LASER, PRODUCT, LASER RADIATION. DO NOT stare into beam or view directly with optical instruments.

WARNING: M18 recoil kits are for training purposes only.

The installation procedures described below are to be performed by trained personnel. For repair and maintenance procedures, please refer to V-M18-RK Maintenance manual. Any procedures not covered in either the installation or the repair/maintenance user manuals are considered Factory Maintenance & Repair and it is required that the item be sent to VirTra for repair.

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I. RECOIL KIT COMPONENTS

A. RECOIL KIT ASSEMBLY

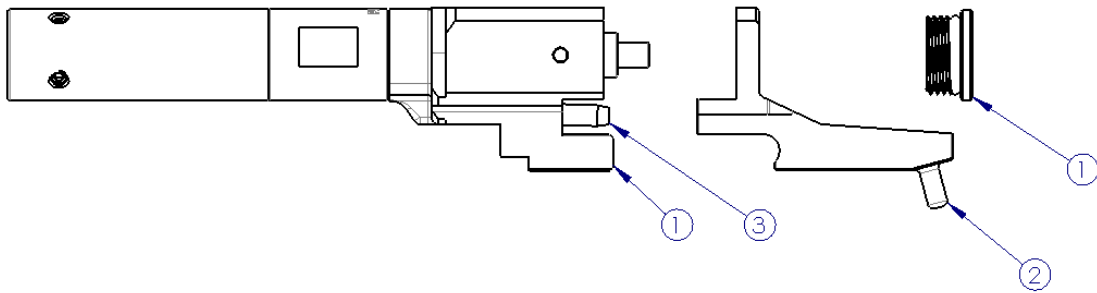


Figure 1: Recoil Kit Assembly

ITEM NO.	DESCRIPTION
1	Tailpiece Fastener
2	Tailpiece
3	Air Tube
4	Barrel Assembly

Table 1: Recoil Kit Components

II. OPERATION INSTRUCTIONS

A. RECOIL KIT INSTALLATION

CAUTION: Before proceeding, make sure the firearm is unloaded and safe.

Field strip the firearm according to the manufacturer's instructions. Place the factory barrel in a safe spot. Install the recoil kit into the M18 as shown below.

- Remove the Tailpiece and Tailpiece Fastener from the recoil kit as shown in the figure. Use the VirTra Wrench from the M18 recoil kit to unscrew the Tailpiece Fastener.

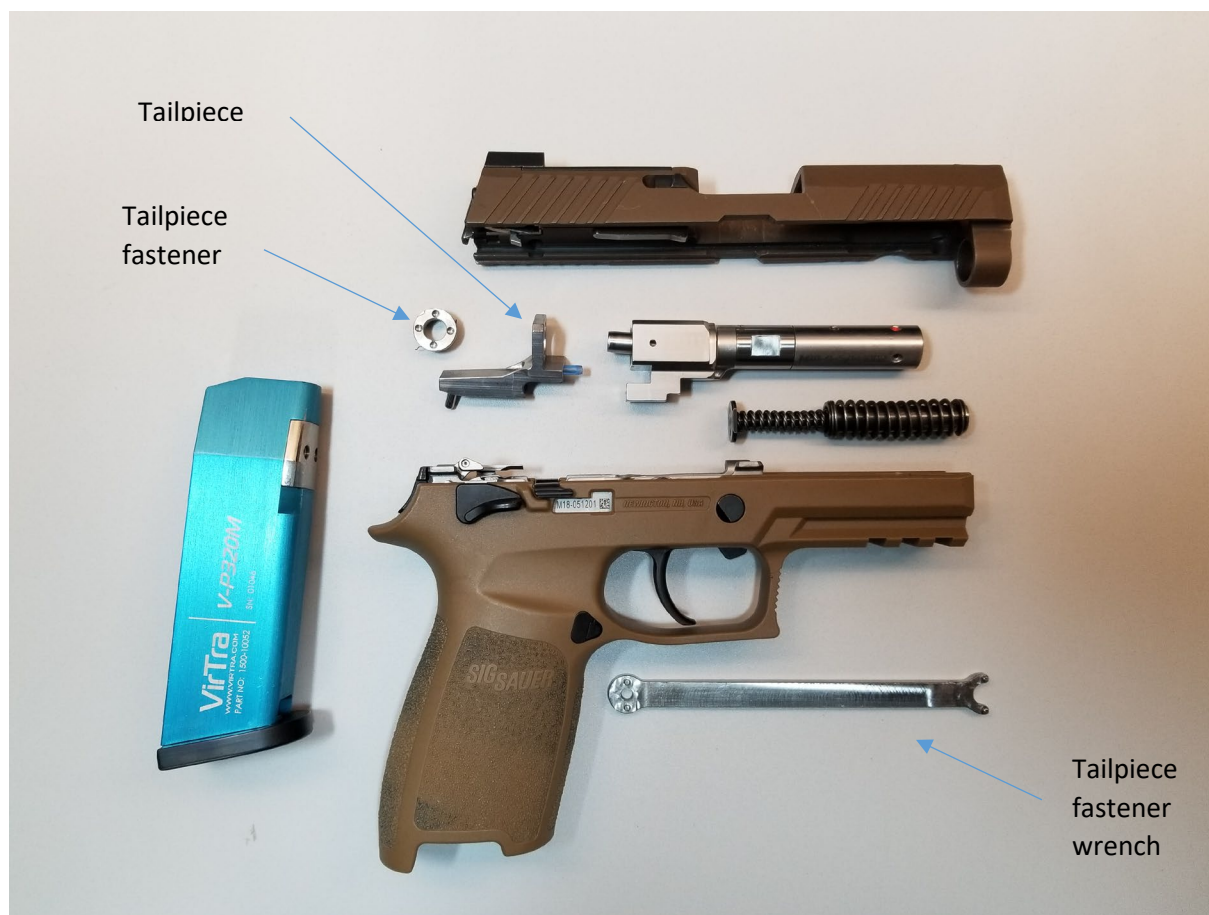


Figure 2: Kit Components

- With the bottom of the slide turned up, place the Barrel Assembly (Figure 1: Recoil Kit Assembly) into the slide with the barrel lug turned up (Figure 3).

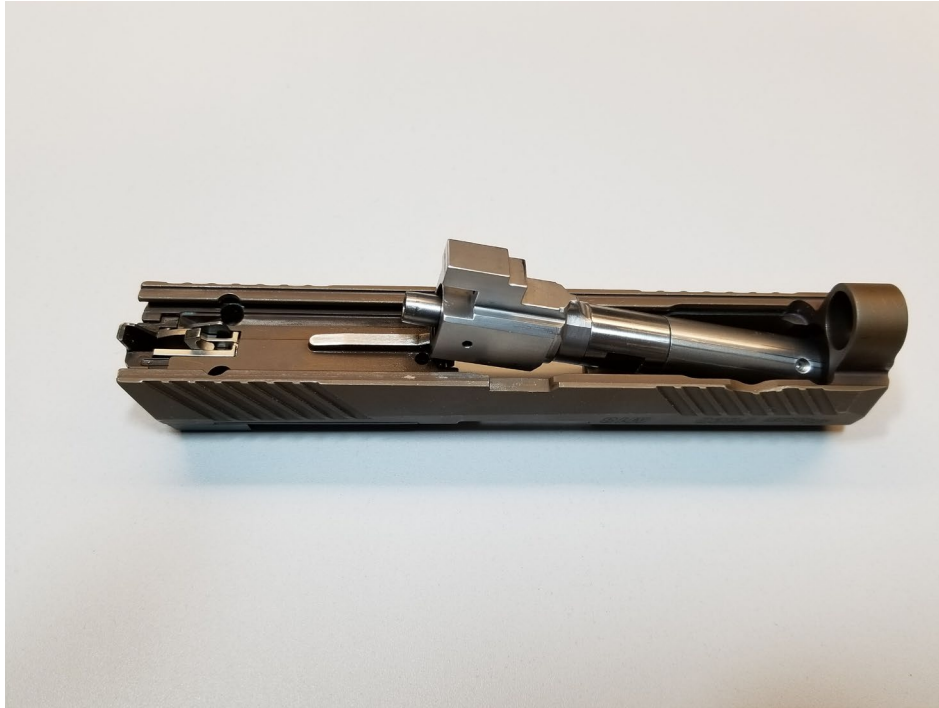


Figure 3: Barrel Assembly Install

- Insert the factory Recoil Assembly (Figure 1, #5) into the slide guide housing (muzzle end) of the slide. Push the guide rod through the recoil spring compressing it enough to seat the rear of the guide rod into the assembly notch of the barrel lug (Figure 4 & 5).



Figure 4: Recoil Spring Install



Figure 5: Completed Recoil Spring Install

- Holding the slide and recoil spring assembly firmly, place the rear of the slide onto the front frame rails and continue moving the slide onto the frame until it is fully rearward (Figure 6).



Figure 6: Handgun Frame Install

- Once in the fully rearward position set slide lock and rotate slide release pin counter clockwise to set. You may have to gently straighten Recoil Spring before rotate slide locking mechanism (Figure 7)



Figure 7: Slide Lock Rotated

- Release the slide slightly, exposing the end of the barrel block and insert the tailpiece into the ejection port. Press the tailpiece into the barrel block so that the air transfer tube (Figure 1) engages both pieces. This can be done easily by letting the slide close on the tailpiece after it has been lined up (Figure 7 & 8).



Figure 8: Tailpiece Installed

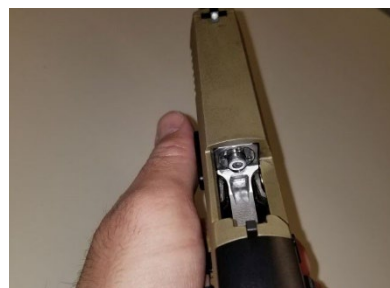


Figure 9: Completed Tailpiece Install

- Install the Tailpiece Fastener and tighten with the VirTra Wrench in the clockwise direction until tight. Be sure the sides of the Tailpiece are well aligned with the barrel block to prevent it from turning and sticking out of the ejection port. Even small misalignment can compromise the performance of the recoil kit and shorten the lifespan of the air transfer tube.



Tighten Tailpiece Fastener



Completed Assembly

- Weapon is ready to fire.

B. BEFORE USE/LUBRICATION

Lubricate the weapon following normal manufacturer instructions using approved Lubricant.

Approved Lubricants Include

- SLIP 2000™ Advanced Gun Oil

See repair/maintenance manual for more specific instructions.

C. MAGAZINE

The CO2 magazine is refillable via the VirTra CO2 Refill Station and the table clamp refill nozzle. For the refill station, simply place the CO2 magazine into the corresponding guide block and insert into the station. For the table clamp nozzle, simply push the magazine onto the nozzle until the magazine is full.

Do not store pressurized CO2 magazines overnight. Make sure to expel any gas at the end of the day by following this procedure:

- Fire the weapon until there is not enough pressure to cycle the slide.
- Take the magazine out and insert a depressurization tool.
- Wait 30 seconds to allow any frozen CO2 to thaw and insert the depressurization tool again.

D. DISASSEMBLY

Follow the steps outlined in 'Recoil Kit Installation' in reverse to remove the VirTra Recoil Kit and install factory components.

III. CONTACT VIRTRA

For any questions or additional help with any part of this manual, please contact VirTra via the information below.

VirTra Service Department



295 E. Corporate Pl
Chandler, AZ 85225 USA

Office: 480.508.5977
Email: service@virtra.com

