

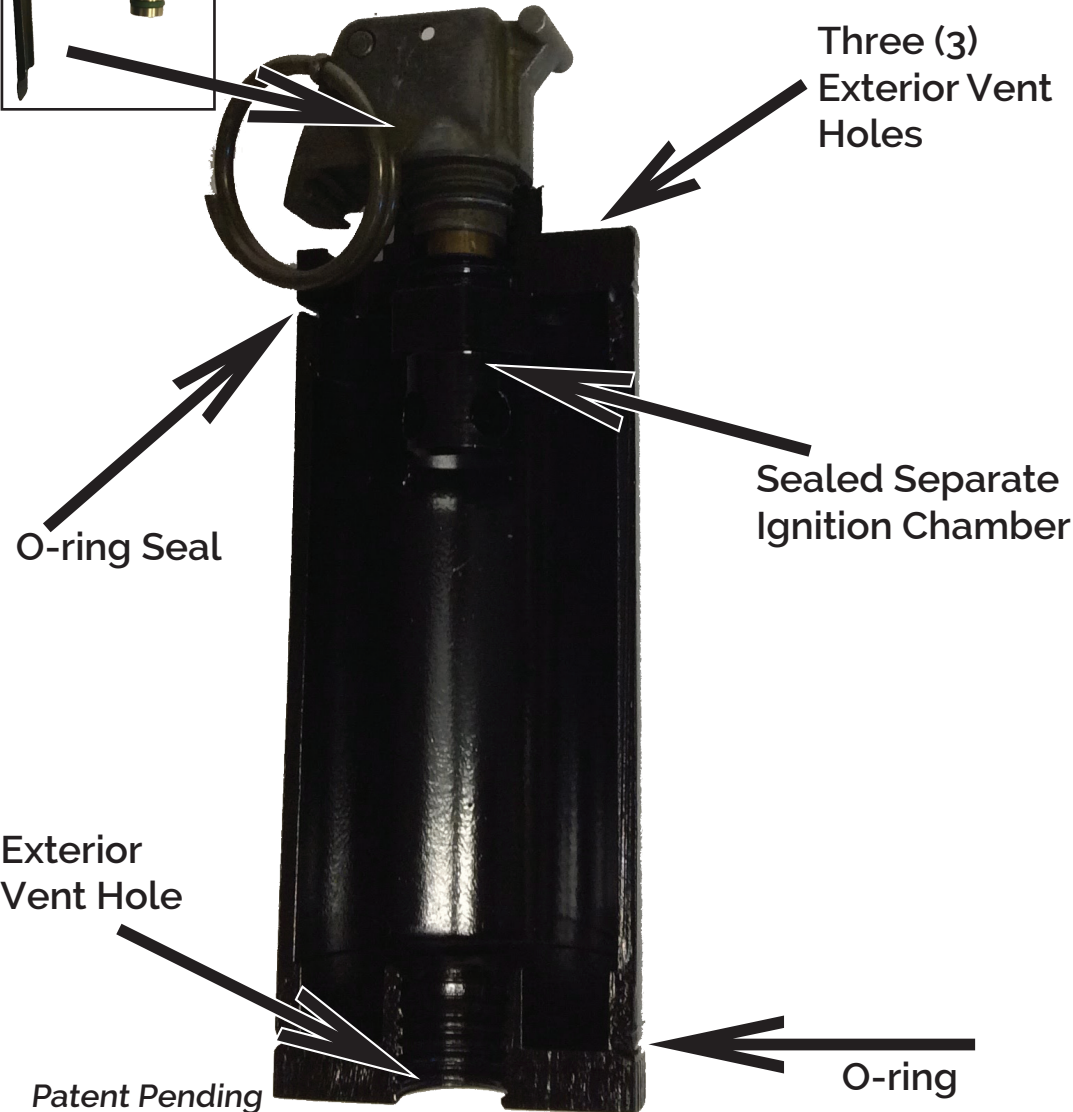


# LOADING INSTRUCTIONS

## XM-18 RELOADABLE SMOKE GRENADE



Our proven M228 designed brass fuse tube with set screw fuse holder & small pistol primer pocket



Assemble M228/M201A1 Modified Smoke Grenade Fuse Head with 3mm fuse and secure with set screws. Fuse head spout 5/8 x 11 threads

**Over-tightening set screws will cut fuse train!**

Cover four (4) vent holes on ignition chamber, vent hole on bottom of tube, and three (3) exterior vent holes on top with mylar or painter's tape.

Lightly coat o-rings and threads on grenade body with silicone lubricant

Assemble tube and base.

Fill with desired smoke mix of your choice.

Fill ignition chamber with 4-5 grains of smokeless powder (tested with 5 grains of Hi Skor 800X Smokeless Powder) and attach to inside of top.

Thread assembled top with covered vent holes onto tube.

Install M228/M201A1 modified fuse head with readied striker safety pin and spoon loaded with small pistol primer, 3mm fuse and fuse secured with set screws.

Delay of smoke mix ignition dependent on type of fuse installed (seconds/foot).

**Assembly is ready for use.**

Using this device as anything other than a smoke grenade turns it into an **un-registered destructive device. The ATF takes these violations very seriously.** The penalty for possessing an un-registered destructive device is 10 years in prison and a \$250,000 fine.