

## M2 MG - HEADSPACE ADJUSTMENT

**WARNING:** Weapon may explode if not properly head spaced!

**NOTE:** Ensure charging handle is retracted before inserting barrel.

**NOTE:** Headspace and timing must be performed each time the barrel is installed

**NOTE:** Ensure barrel is a lined barrel (PN 7266131).

1. Raise cover all the way up, retract bolt to align barrel locking spring lug with 3/8" hole in right side of receiver.
2. With bolt retracted, screw barrel completely into barrel extension; then unscrew barrel two clicks. Allow bolt to go forward; barrel should not rotate.
3. Charge the weapon and allow the bolt to go forward. (Do not slam)
4. Retract the bolt until the barrel extension begins to separate (but not more than 1/16 inch) from the trunnion block. **(DO NOT INSERT ANY OBJECT BETWEEN THE BARREL EXTENSION AND TRUNNION BLOCK)**. Hold in this position until gage check is completed.
5. Raise cartridge extractor; push in on alignment guide to insert gage. (Apply slight pressure on gage). Attempt to insert "GO" end of headspace gage in the T-slot between the face of bolt and rear of barrel all the way up to the ring. If "GO" end of headspace gage enters down to the ring, attempt to insert the "NO GO" end of headspace gage; if "NO GO" end does not enter, headspace is set. If "NO GO" end enters T-slot or "GO" end does not enter, retract bolt to align barrel locking spring lug with 3/8" hole in right side of receiver.
6. Screw barrel in one click at a time (if "NO GO" end enters slot) or one click out at a time (if "GO" end does not enter) rechecking after each click starting from **Step 4 above**.
7. Repeat until "GO" end can enter T-slot and "NO GO" will not enter T-slot.

**CAUTION:** Do not unscrew barrel more than a total of seven clicks.  
If condition occurs, turn in machine gun for next echelon inspection.

## M2 MG - TIMING ADJUSTMENT

**WARNING:** Never charge gun with back plate off.

Do not stand directly behind gun while removing back plate.

**NOTE:** Gun must be in single shot mode before removing back plate.

**NOTE:** Ensure proper head space is set before attempting to adjust timing.

**Barrel must be installed. Each time the back plate is removed, remove gage.**

1. Raise cover all the way up. (Do not hold barrel while charging weapon).  
Charge the weapon and allow the bolt to go forward. (Do not slam).
2. Retract bolt just enough to insert “**FIRE**” gage with beveled edge against barrel notches.
3. Remove back plate (pull back plate latch lock straight back, while lifting up on back plate latch. Raise back plate assembly straight up and remove from receiver).
4. Turn timing adjustment nut all the way down (to the left), but not completely off the timing stud.
5. Retract bolt just enough to remove “**FIRE**” gage. Reinstall back plate. Retract bolt just enough to insert “**FIRE**” gage and attempt to fire by pressing butterfly trigger; gun should not fire (firing pin not released).
6. Retract bolt just enough to remove “**FIRE**” gage. Remove back plate, screw nut one click at a time. Reinstall back plate. Retract bolt just enough to insert “**FIRE**” gage and attempt to fire by pressing on butterfly trigger (repeat procedure until the gun fires, firing pin releases).
7. After the gun fires, remove back plate, turn nut up two more clicks. Reinstall back plate, charge the weapon and allow the bolt to go forward. (Do not slam)
8. Retract bolt just enough to insert “**NO FIRE**” gage with beveled edge against barrel notches. Attempt to fire by pushing the butterfly trigger; machine gun should not fire.
9. Retract bolt just enough to remove “**NO FIRE**” gage and insert “**FIRE**” gage with beveled edge against barrel notches. Attempt to fire by pushing on butterfly trigger; machine gun should fire. (Remove “**FIRE**” gage). **Timing adjustment is complete.**