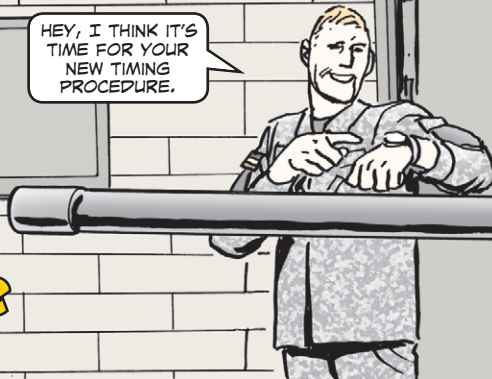


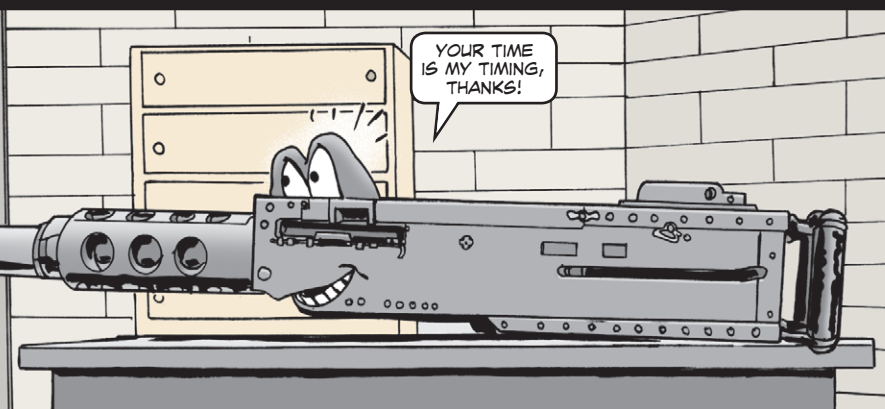
M2 Machine Gun...

Time to Change Timing Procedure

HEY, I THINK IT'S TIME FOR YOUR NEW TIMING PROCEDURE.



YOUR TIME IS MY TIMING, THANKS!



SINCE PS PUBLISHED THE HEADSPACE AND TIMING PROCEDURE FOR THE M2 MACHINE GUN IN PS 653 (APR 07), THE TIMING PART HAS BEEN REVISED SLIGHTLY.

HERE'S THE NEW IMPROVED VERSION...



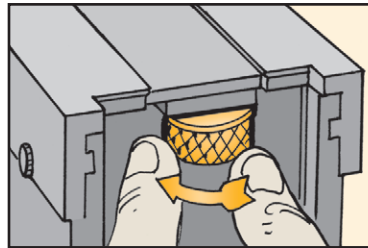
Never charge the gun with the back plate off. Do not stand directly behind the gun while removing the backplate. The gun must be in single shot mode before removing the backplate.

1. Raise the cover all the way up. Do not hold the barrel while charging the weapon. Charge the weapon and allow the bolt to go forward (but not slam).

2. Retract the bolt just enough to insert the FIRE gauge with its beveled edge against the barrel notches.

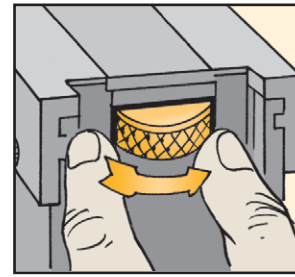
3. Remove the backplate. Pull the backplate latch lock straight back while lifting up on the backplate latch. Raise the backplate assembly straight up and remove it from the receiver.

4. Turn the timing adjustment nut all the way down to the left, but not completely off the timing stud.



5. Retract the bolt just enough to remove the FIRE gauge. Reinstall the backplate. Retract the bolt just enough to insert the FIRE gauge and try to fire by pressing the butterfly trigger. The gun should not fire.

6. Retract the bolt just enough to remove the FIRE gauge. Remove the backplate. Screw the nut one click right. Reinstall the backplate. Retract the bolt just enough to insert the FIRE gauge and try to fire by pressing on the butterfly trigger. Repeat this procedure until the gun fires.

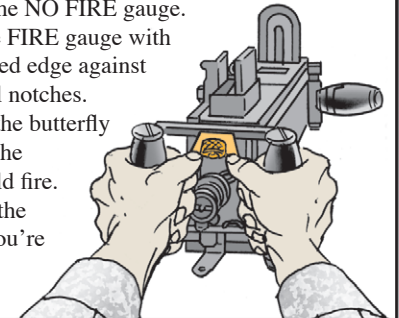


7. After the gun fires, remove the backplate, and turn the nut right two more clicks. Reinstall the backplate, charge the gun and allow the bolt to go forward without slamming.

8. Retract the bolt just enough to insert the NO FIRE gauge with the beveled edge against the barrel notches. Push on the butterfly trigger. The gun shouldn't fire.

9. Retract the bolt just enough to remove the NO FIRE gauge.

Insert the FIRE gauge with the beveled edge against the barrel notches. Push on the butterfly trigger. The M2 should fire. Remove the gauge. You're done.



A poster is available that gives the complete procedure for timing and headspacing the M2 machine gun. Your pubs clerk can order the poster with DA Poster 750-98, IDN 401181, and PIN 083874.

There is also a smart card available that gives the complete timing and headspacing procedure. It's available on the AEPS website:

<https://aeps2.ria.army.mil/commodity/pubs/tacom/bulletin/m2-mg-time-gage2.doc>