



•• DEFENSE SYSTEMS ••

U.S. ORDNANCE

••• MANUFACTURING •••

OPERATOR'S BASIC INSTRUCTIONS



.50 M2 QCB ADDENDUM

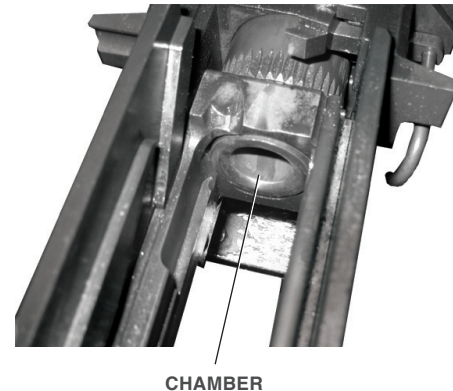
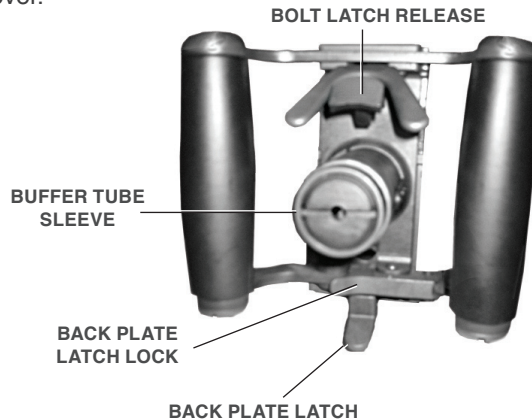
WARNINGS: Carry out safety check before handling the weapon. The weapon is heavily oiled for shipping. Clean and lubricate before firing. These procedures given apply only to the US Ordnance QCB version.

Safety Check

1. If the buffer tube sleeve is hooked over the bolt latch release, rotate the sleeve to the right to unlock it.
2. Open the feed cover by turning and lifting the feed cover latch, if there are rounds on the feed tray refer to “unloading.”
3. Pull cocking handle fully to the rear, then push it forwards. The bolt will be held open. Check that the chamber and bolt face are clear.
4. Press down on the bolt latch release to close the bolt.

Note: Do not close feed cover with the bolt open.

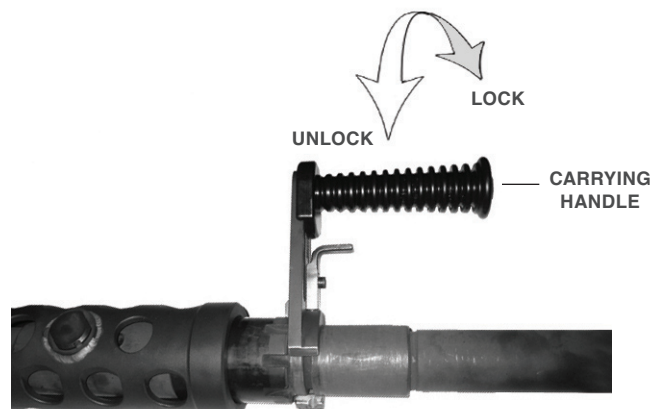
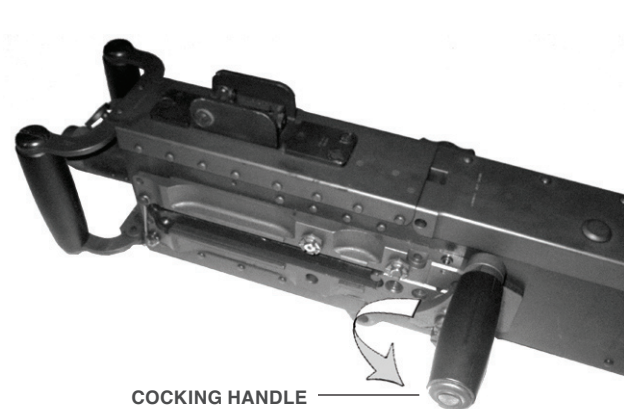
5. Close the feed cover.



Barrel Removal

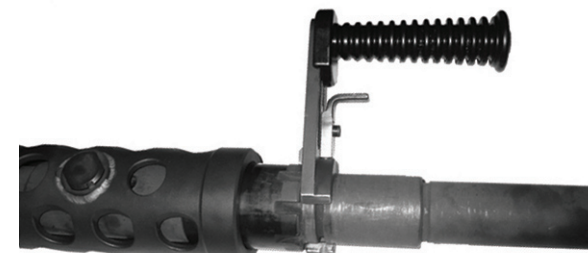
1. Rotate the cocking handle fully downwards and hold it in position.
2. Pull the barrel carrying handle up to the vertical position, causing the barrel to turn and unlock.
3. Pull barrel out, and release the cocking handle.

Note: Whenever the barrel is not fitted the cocking handle must be used to slow the moving parts when closing the bolt.



Barrel Assembly

1. Move the cocking handle back until it rotates fully downwards and hold it in position.
2. Slide barrel into the barrel guide sleeve with the carrying handle pointing upwards (the guide stud in the sleeve will enter the long groove on the barrel).
3. Turn the carrying handle towards the left side of the weapon causing the barrel to rotate and lock. Ensure that the rear of the barrel protrudes through the back of the extension (as shown on page 1 safety check pointing out the chamber).
4. Release the cocking handle.

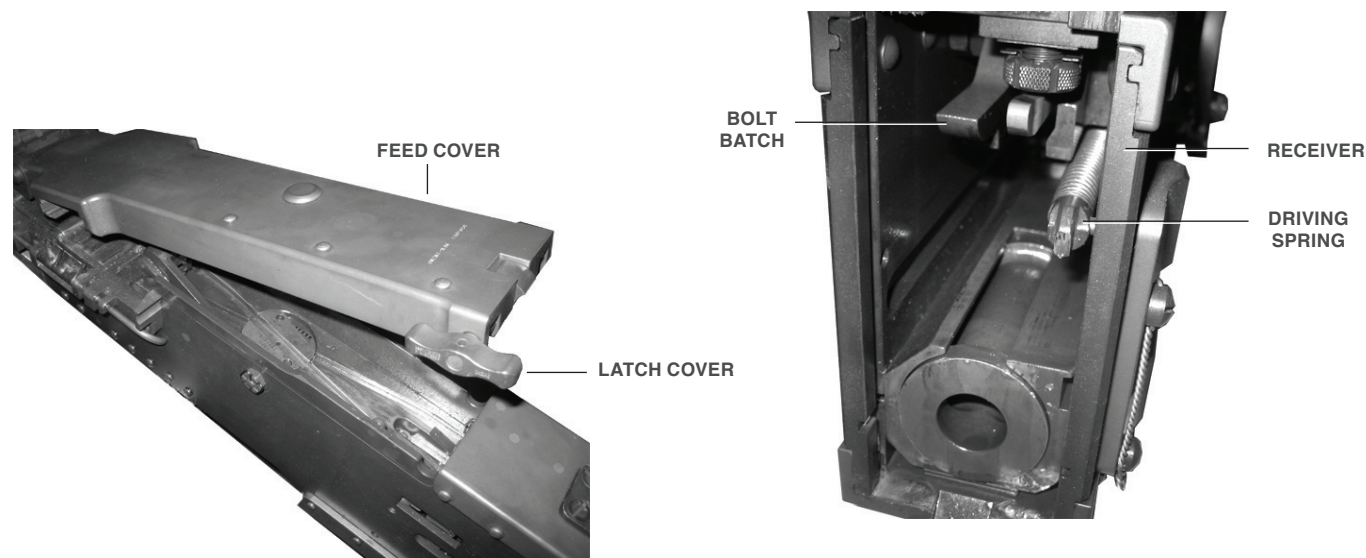


Field Stripping

1. Carry out safety check.
2. Remove the barrel.
3. Open the feed cover and ensure that the bolt is fully forwards.

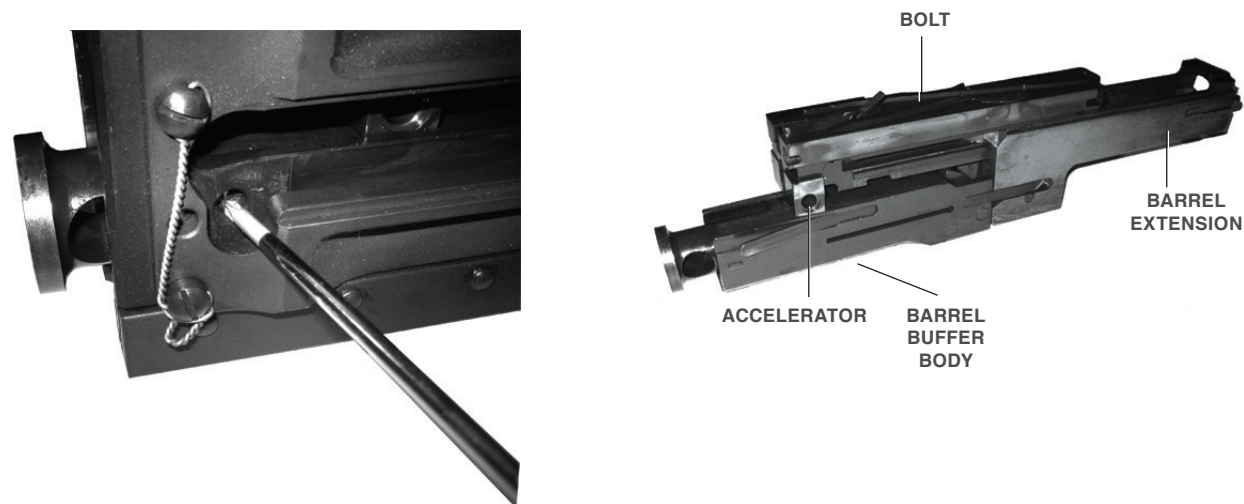
Note: Do not try to remove the back plate group with the bolt held open by the bolt latch.

4. Ensure that the bolt latch release is not held down by its lock on the buffer tube sleeve.
5. Pull and hold the back plate latch lock to the rear, then raise the back plate latch and slide the back plate upwards out of the receiver.
6. Push the end of the driving spring assembly to the left to free it from the receiver, then pull it out to the rear.
7. Pull back on the cocking handle to open the bolt. If the bolt returns too far and is caught by the bolt latch, push up hard on the latch to free the bolt. Align the bolt stud with the dismounting hole in the receiver, and pull it out.



Field Stripping Continued

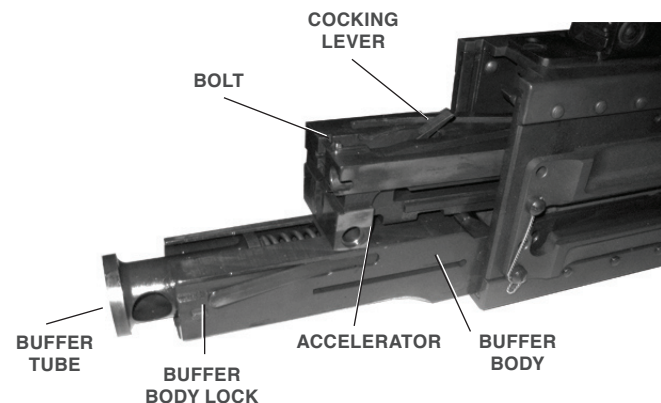
8. Using a punch, press in on the buffer body lock through the hold in the receiver while pulling back on the barrel extension; Remove the bolt, barrel buffer and barrel extension assemblies.
9. Slide bolt backwards out of the barrel extension, put it down on its right side so that the extractor will not fall out. Push accelerator tips forwards to separate the barrel buffer body from the barrel extension. Remove barrel buffer from the barrel buffer body.



Assembly

Note: The bolt and barrel extension are marked with the weapon serial number and must be reassembled to the same weapon.

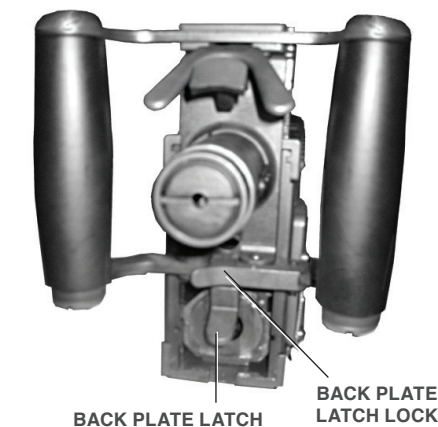
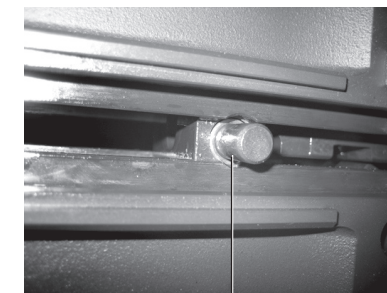
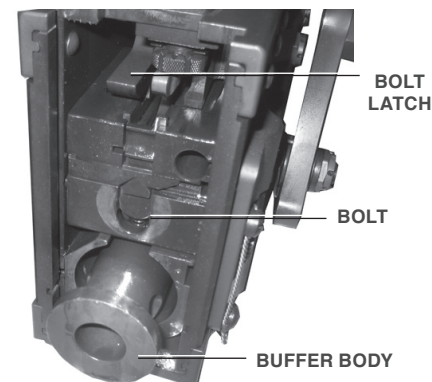
1. Insert barrel buffer tube into the buffer body making sure that the guide lug on the tube fits into the slot in the buffer body.
2. Holding the barrel buffer body so that the accelerator is supported with the tips pointing forwards and upwards, assemble it to the barrel extension so that the shank of the barrel extension fits into the groove on the arm of the barrel buffer, and the breech lock depressors enter the slots in the barrel extension.
3. Push the buffer body forwards until the accelerator rotates back and locks the buffer assembly to the barrel extension.
4. Slide the bolt half way into the barrel extension.
5. Hold the assembled moving parts together, tilted slightly downwards, and push them into the receiver.



Assembly Continued

Be sure that the firing pin cocking lever remains pointed forwards during assembly.

6. Push on the buffer body until the buffer body lock is engaged. The bolt will be held to the rear by the bolt latch and the buffer tube will not fully enter the receiver.
7. Raise the bolt latch and push the bolt forwards a short distance.
8. Place the bolt stud in the bolt, align the stud with the dismounting hole in the receiver and push fully in.
9. Pushing forwards on the bolt stud slam the bolt fully forwards, this will cause the buffer tube to fully enter the receiver.
10. Insert the front end of the driving spring into the hole in the bolt, then engage the pin on the rear of the spring guide into the hole in the side of the receiver.
11. Pull and hold the back plate latch lock to the rear, then raise the back plate latch and position the back plate in top of the grooves of the receiver. Push the back plate fully downwards, then release the latch and latch lock.
12. Assemble the barrel.



Preparation

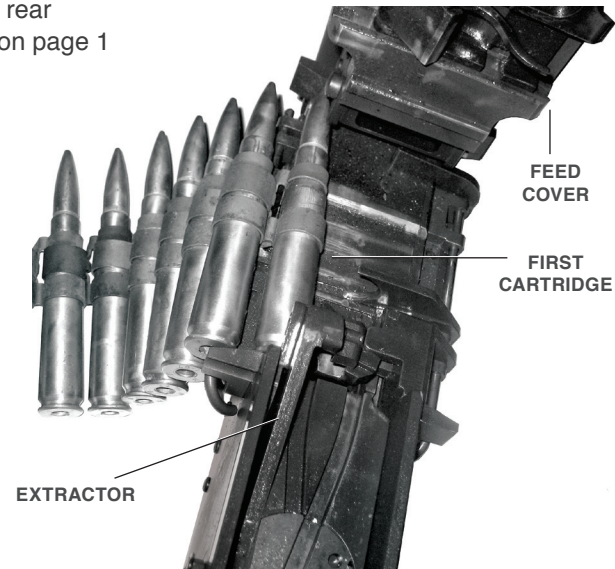
1. Fit the machine gun onto its mounting.
2. Check that the barrel is locked onto the weapon.
3. Raise the rear sight leaf and select the range setting.

Loading

1. Open the feed cover, check that the bolt is forwards. Ensure that the rear of the barrel protrudes through the back of the extension (as shown on page 1 safety check pointing out the chamber).
2. Take the end of the belt with the double loop of the links empty.
3. Place the belt on the feed tray with the first cartridge held by the belt holding pawl.
4. Hold the belt in position, make sure the extractor arm is down and close the cover.

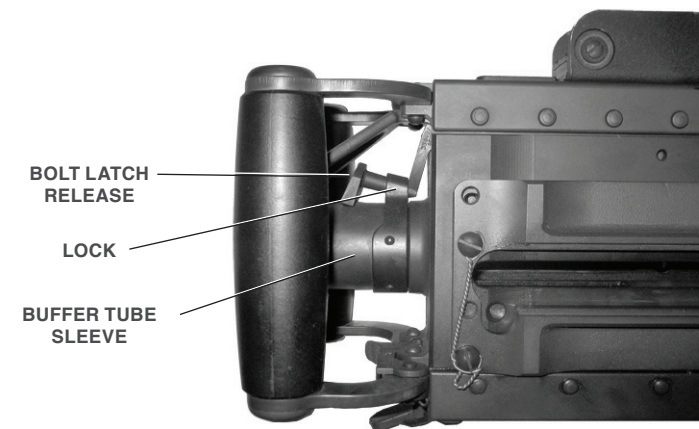
Note: Do not close the feed cover with the bolt held open, this may damage parts.

5. To half load, pull the cocking handle back hard in one movement; if the bolt is held by the bolt latch, push the cocking handle forwards, then press down on the bolt latch release.
6. To fully load repeat the previous actions, the first link will be ejected, and the first round is in the chamber.



Firing

1. Single shots: check that the bolt latch release is not held down by the buffer tube sleeve. Press the bolt latch release then the trigger to fire.
2. Bursts: press down on the bolt latch release, rotate the buffer tube sleeve to engage the lock over latch release, press the trigger down to fire. If the buffer tube sleeve is not engaged, bursts can be fired by pressing down on both the bolt latch release and the trigger.



Unloading

1. Open the feed cover, raise the extractor arm, remove the belt.
2. Pull the cocking handle back to remove the cartridge from the chamber.
3. Check that the chamber and bolt face are clear.
4. Return the bolt to the forward position.
5. Lower the extractor arm. Close the feed cover.

Immediate Action

1. If the weapon fails for fire, cock weapon and fire again.
2. If the problem persists, put safety on, release the bolt latch if it is engaged, and cock the weapon so that the bolt is held open. Open the feed cover and remove the belt. Check that no damaged rounds or empty cases are in the receiver.
A cartridge will be in the bolt face. Release the bolt latch, and cock again immediately (within 10 seconds). If the bolt was unable to close, there is probably a ruptured case in the chamber: use another barrel.
If the round was fed correctly, check the condition of the belt, extractor, and firing mechanism (close the bolt on an empty chamber, release the safety and press the trigger. There is a click if the firing pin is released correctly).

Cleaning

1. Carry out the field stripping. Wipe oil and dirt off the moving parts, receiver, feed cover, back plate group, and outer surface of the barrel. Clean the barrel bore and chamber carefully using the cleaning rod, bore brush, chamber brush. Wipe bore with cleaning patch until last cloth remains clean.

Lubrication

1. For firing: lubricate the moving parts, and the inside of the receiver. The barrel bore and chamber must be wiped dry. Other surfaces should be lightly oiled and wiped off to protect against corrosion.
2. For storage: all surfaces should be lightly oiled.
3. Lubricating oil: NATO 0-157

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