

INCH-POUND

MIL-G-001298C (AR)  
 AMENDMENT 2  
30 September 1993  
 SUPERSEDING  
 AMENDMENT 1  
 29 January 1990

## MILITARY SPECIFICATION

GUN, MACHINE, CALIBER .50, BROWNING, M2, HEAVY BARREL

This amendment forms a part of MIL-G-001298C (AR) dated, 17 November 1981, is approved for use by the U.S. Army Armament, Munitions, and Chemical Command, and is available for use by all Departments and Agencies of the Department of Defense.

## PAGE 1

- \* 1.1: Delete in its entirety and substitute the following:
  - "1.1 Scope. This specification covers an automatic, recoil-operated, alternate feed, link-belt fed, air-cooled, caliber .50, heavy barrel machine gun."
- \* 2.1.1, line 2: Delete "(see 6.2)" and substitute "(see 6.1.b)".
- \* Delete the specification number for Inspection Process, Magnetic Particle: "MIL-I-6868" and substitute "MIL-STD-1949".

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- \* 2.1.2, under Product and Packaging Drawings: Add the following:
  - "12002953 - Machine Gun, Caliber .50: M2 Heavy Barrel, Turret Type. (M48 and M48C) Series"
- \* 2.1.2, under Inspection Equipment Drawings:
  - Delete "12003958" and substitute "12003958 or 5351211".
  - Delete "12003959" and substitute "12003959 or 5351213 and 5351214".

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- \* 3.2, line 4: After "...Drawing 7265636" add "or 12002953".
- \* 3.2.1, line 3: Delete "...to insure engagement of the hook of the extension to the hook of the sear" and substitute "...to insure engagement of the hook of the extension with the hook of the sear".
- \* Add new paragraph 3.2.5 as follows:  
    "3.2.5 Bar code label. A bar code label shall be firmly affixed to the receiver assembly."

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- \* 3.3.2: Delete in its entirety and substitute the following:  
    "3.3.2 Firing pin indent. The firing pin indent shall be within the range of 0.017 to 0.040 inches and shall not be off center by more than one-half the diameter of the indent. Testing shall be as specified in 4.5.3.3."
- \* 3.3.3: Delete in its entirety and substitute the following:  
    "3.3.3 High pressure resistance. The machine gun shall be capable of withstanding the firing of one high pressure test (proof) round. Bolt subassemblies, barrel extension assemblies, and barrel assemblies may be proof tested, inspected and marked individually in accordance with the applicable product drawings. If components are proof tested individually, and then assembled into a complete machine gun, they shall be reproof tested and inspected with the complete machine gun. After firing, the machine gun shall be free from cracks, seams, or other injurious defects. The barrel assembly, barrel extension assembly and bolt subassembly shall be magnetic particle inspected and marked in accordance with the applicable drawing except those assemblies which receive a second proof round shall be marked with a prefix "2" at the previous marking."
- \* 3.3.8, Table I: Delete "correctible" and substitute "correctable" (two places).

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- \* 3.5: Delete the last sentence and substitute the following:

"Each machine gun shall be identified by a serial number which shall appear on both the top plate of the receiver assembly and on the bar code label. The serial number shall be assigned by the procuring activity (see 6.1)."

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- \* 4.1.4, line 5: Delete "responsibilities" and substitute "responsibilities".

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- \* 4.5.3.5.1: Delete in its entirety and substitute the following:

"4.5.3.5.1 Right hand feed function testing. When 500 consecutive machine guns meet the specification requirement, the number of machine guns to be tested each month of production shall be reduced to two or 5% of the total monthly production rounded up to the next higher whole number, whichever is greater. Reduced testing shall apply to subsequent contracts provided production has been uninterrupted."

- 4.5.3.6: Delete in its entirety and substitute the following:

"4.5.3.6 Belt pull testing. Each machine gun shall be tested for belt pull (see 3.3.5) using the test method specified in 4.6.5. Machine guns which fail to meet these requirements shall be subject to the provisions of paragraph 4.5.3.1. They may then be mechanically gymnasticated for a period not longer than ten minutes, and then retested as specified in 4.6.5. Failure of the retest to meet the requirements shall be cause for rejection of the machine gun."

- \* Add new paragraph 4.5.3.6.1 as follows:

"4.5.3.6.1 Right hand feed belt pull testing. When 500 consecutive machine guns meet the specification requirement the number of machine guns to be tested each month of production shall be reduced to two or 5% of the total monthly production rounded up to the next higher whole number, whichever is greater. Reduced testing shall apply to subsequent contracts provided production has been uninterrupted."

- \* 4.5.3.9, line 4: Delete "falure" and substitute "failure".

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- \* 4.5.5, line 4: Delete "documentation" and substitute "documentation".
- \* 4.6.2, line 2: Delete "cyclinders" and substitute "cylinders".
- \* 4.6.3, last line: Delete "MIL-I-6858" and substitute "MIL-STD-1949".

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- \* 4.6.4: Delete "maching" and substitute "machine".
- \* 4.6.4: Add the following to the end of the paragraph:

"Machine guns which fail to fire the 50-round right hand feed test may be retested and accepted if two subsequent consecutive firings are successful."
- \* 4.6.5: Add the following to the end of the paragraph:

"Machine guns which fail to fire the initial ten-round burst right hand feed may be retested and accepted if two subsequent consecutive firings are successful."
- \* 4.6.7: Delete in its entirety and substitute the following:

"Targeting and accuracy test. Machine Gun Caliber .50: M2 Heavy Barrel, Flexible. The machine gun shall be mounted in a firing fixture conforming to Drawing 8440929 or an approved equivalent. With the leaf of the rear sight in the folded-down position and the windage scale adjusted to zero, the sights shall be aligned at 6 o'clock on the sighting image of the targeting and accuracy diagram D7266955 and a 10-round continuous burst fired."
- 4.6.7.1: Add new paragraph 4.6.7.1 as follows:

"Targeting and accuracy test. Machine Gun Caliber .50: M2 Heavy Barrel, Turret Type (M48 and M48 Series). The machine gun shall be mounted in a firing fixture conforming to Drawing 8440929 or an approved equivalent. Boresight the gun to bring the point of aim to the center of the target (reference Drawing 7266955) at a range of 100 feet. A 10-round continuous burst shall be fired and all shots shall group within or cut the edge of an 8.0 inch diameter circle."

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4.6.8: Delete "...During the interrupted burst firing, the bolt latch release shall be released at least twice to stop the firing and the trigger shall be released at least three times to stop firing..." and substitute "...During the interrupted burst firing, the bolt latch release (if applicable) shall be released at least twice to stop the firing and the trigger shall be released at least three times to stop firing...".

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4.6.8.2, line 2: Delete "(see 3.3.9.1)" and substitute "(see 3.3.8.1)".

4.6.9.1.1, line 1: Delete "Machine guns. Machine guns shall be tested..." and substitute "Machine guns, Caliber .50: M2 Heavy Barrel, Flexible. Machine guns shall be tested...".

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Delete "Groups of Nonmating Parts" and substitute "Groups of Nonmating Parts (Flexible)".

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- \* In Group V: Delete "Shaft Assembly, Cover Latch - 7312723".
- \* In Group VII: Delete "Washer, Thrust - 5013545".
- \* In Group VIII: Delete "Cover Subassembly - 5504081".

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- \* In Group X: Delete "Support, Barrel - 5504091".
- \* Add new paragraph 4.6.9.1.1.1 as follows:

"4.6.9.1.1.1 Machine Guns, Caliber .50: M2, Heavy Barrel, Turret Type (M48 and M48 Series). Machine guns shall be tested for interchangeability by disassembling and then reassembling parts using the parts and prearranged system specified below: Interchange of parts shall be accomplished by dividing the parts of each machine gun into 10 groups of nonmating parts as shown below and distributing the groups into 10 different trays until each tray contains parts for a complete machine gun. Groups of parts from the first machine gun shall be taken in order and placed in trays 1 through 10; groups of parts from the second machine gun shall be taken in order and placed in

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trays 2 through 10 to 1; groups of parts from the third machine gun shall be taken in order and placed in trays 3 through 10 to 2, etc. Commercial parts such as screws, spring pins, etc., shall be placed in the same tray as their mating or associate part. Any commercial part rendered unserviceable by disassembly shall be replaced without penalty to the interchangeability test. The machine guns shall be reassembled using only those parts which are in the same tray."

- \* Add Listing of Nonmating Parts for Turret Type interchange as follows:

"GROUPS OF NONMATING PARTS (TURRET TYPE)

GROUP IB

Bar, Trigger - 6257592  
Barrel Assy - 7266131  
Extension Assy, Firing Pin -  
6008976  
Extractor Assy - 6008959  
Pin, Cocking Lever - 7312078  
Spring, Cover Latch - 6008931  
Cam, Lock, Breech - 6147583  
Cover, Top Plate - 6008939  
Cover, Trunnion Block -  
5013588  
Spring, Switch - 6008493

GROUP IIB

Bolt Subassembly - 6147463  
Rod Assy, Oil Buffer Piston -  
6008763  
Pin, Locking - 7312970  
Spring, Cover Extractor -  
6009741  
Pawl, Cover Detent - 7313069  
Pin Assy, Breech Lock -  
6008784  
Pin Assy, Trigger Bar -  
7313106  
Spring, Helical, Comp -  
5013693  
Safety, Trigger - 6147511

GROUP IIIB

Slide, Sear - 5351220  
Switch, Bolt - 5504062  
Tube, Barrel Buffer - 9340486  
Pin Assy, Belt Feed Pawl -  
6008962  
Spring, Helical Compression -  
5013516  
Plunger, Adjusting Screw -  
5152839  
Spacer, Back Plate - 5013583  
Screw, Trigger Safety - 5152897  
Stop Assy, Adjustable, Trigger  
Bar - 7265212

GROUP IVB

Lever, Cocking - 6009718  
Sear - 5504067  
Stop, Accelerator - 7161301  
Spring, Helical Compression -  
6009832  
Plunger, Belt Feed Lever -  
5013515  
Spring, Trigger Safety -  
5152896  
Lever, Retracting Slide -  
6147085  
Stop, Front, Cartridge -  
5013539

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GROUP VB

Lock, Accelerator Stop -  
7161300  
Spring, Helical Compression -  
5009524  
Guide Assy, Buffer Spring -  
6008782  
Trigger - 6008918  
Spring, Helical Compression -  
5009351  
Pawl Assy, Belt Holding -  
7313083  
Sleeve, Buffer Tube - 7265562  
Rod Assy, Driving Spring -  
5564305  
Stop, Rear, Cartridge -  
5013540  
Spring, Helical Compression -  
5013525

GROUP VIIB

Body Assy, Barrel Buffer -  
7266835  
Arm, Belt Feed Pawl - 6008914  
(2) Pin, Headed - 5152854  
Lock, Back Plate Latch -  
11010453  
Plate, Buffer - 5152869  
Screw, Adjusting - 5152834  
Spring, Helical Compression -  
5009352  
Switch, Extractor - 6147461  
Stop Assy, Cartridge,  
Rear RH - 5577409

GROUP VIB

Accelerator, Oil Buffer -  
5508141  
Slide Assy, Belt Feed -  
6261110  
(3) Pin, Locking - 7312517  
Nut, Slotted, Hexagon -  
5152939  
Screw, Externally Relieved  
Body - 7312028  
Stud Assembly, Bolt - 7268490  
Plate, Back - 6535475  
Washer, Thrust - 5013697  
Stripper, Link - 5013541

GROUP VIIIB

Pin Assy, Accelerator -  
6008790  
Piece Filler - 5152750  
Disk, Buffer, Fiber - 5152835  
Latch, Back Plate - 6008949  
Pin, Locking - 7312517  
Spring, Locking, Elevating  
Mechanism - 5140428  
Spring, Helical Compression -  
7160628  
Plunger, Bolt Latch - 5013524  
Spring, Helical Compression -  
5009300

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GROUP IXB

Lever, Belt Feed - 5564278  
Lock, Breech - 7161302  
Pin, Straight, Headed -  
5013581  
Pin, Belt Holding Pawl -  
7162872  
Spring, Back Plate Latch  
Lock - 6243607  
(3) Screw, Machine,  
MS35266-68(2)  
Spring, Helical Compression -  
7313068  
Pin, Firing - 7310080

GROUP XB

Nut, Buffer Piston Head -  
9340485  
Pawl Assy, Belt Feed -  
6008961  
Extension Assy, Barrel -  
5504082  
Nut, Slotted, Hexagon -  
5013556  
Pin, Straight, Headless -  
5009275  
Spring, Helical Compression -  
5009356  
Pin, Straight, Headed -  
5009271  
Screw, Machine, Flat Csk  
Head - 5153191  
Charger, M10 - 7267982

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- \* 5.3: Delete "...in accordance with the Packaging Data Sheet..." and substitute "...in accordance with the applicable Packaging Data Sheet...".
- \* 6.1.b: Delete "List of drawings, specifications and publications pertinent to the machine gun, showing applicable revision dates" and substitute "List of drawings, specifications and publications pertinent to the machine gun, showing applicable revision and dates".

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\* 6.1: Add new paragraph as follows:

"m. Bar code marking requirements."

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